ALM #2 C.V. 214,215,320 D.V.

CG 46 CODE YW-811-P PKG. 55 TIME M

→ LOT ~~49~~ 81 ~~37~~ 38698-3 JAN 21

TAB: PUNCH TOTAL WGT AS EST WGT
EST WGT. (DO NOT PUNCH) ~~5561~~ LBS
(REQ. #)
TAB PUNCH FOLLOWING CONSUMPTIONS:

PROCESSES		APPROVED BY
( ) YW-811-P	B)	BBK 8-17-77
( )	( )	DCG 8-29-77
( )	( )	
( )	( )	
TYPED BY NSA 8-29-77		

CG	CODE	LOT	PQ	DISP	LBS.	TAB: %	DO NOT PUNCH PULP WGT
46	YC-11-A	37985	93		1026		
46	YC-11-A	37985	98		169		
46	YC-11-A	38040	93		521		
46	YC-11-A	38040	98		137		
46	YC-11-A	37999	93		1084		
46	YC-11-A	37999	98		28		
46	YC-11-A						
			TOTAL WGT.		~~7961~~		

6104
1025
5079

766°

8320

NON-BLEEDING

EQUIPMENT		NAME: DALAMAR® YELLOW	USE LBS	N CODE	AC LB
Misc. 1		NOTE: MAKING SUPV - 1 hour before taking S33 sample, advise CTL Supv of status			
	✓	RUN IN ± 150# WATER INTO ALM & CHECK FOR LEAKS			
		RECORD: FINDINGS 0			
		NOTE: (1) IF LEAKS FOUND, ADVISE SUPVR & DO NOT PROCEED WITH BATCH UNTIL CORRECTED			
		(2) IF NO LEAKS FOUND, DRAIN ALM & PROCEED WITH BATCH			
	2	Obtain as listed above	5088	YC-11-A	2400
	3	Obtain & Mix to uniformity for S9 & S13		896-B	
	4	Calculate for S27			
		~~6581~~ 5088# YC-11-A Pulp Wgt (S2) = 1493# water			
		6581			
ALM 2	5	CLOSE ALM # 2 outlet & run in 250# WATER			
	6	DO NOT START AGITATOR			
	7	POUR IN ASSUME 50%	8	T-D	4
	8	DUMP IN 2 DRUMS OF YC-11-A FROM S2			
	9	POUR IN	200	896-B	20
	10	START AGITATOR & STIR ONE MINUTE ONLY			
		RECORD: TEMP 65 °F			
		NOTE: (1) IF COLOR BRIDGING OCCURS, STOP AGITATOR ALLOW TO STOP & DISLODGE COLOR			
		(2) OVER STIRRING WILL GENERATE EXCESSIVE HEAT & FOAM			
	11	ADD REST OF YC-11 (S2) IN 2 DRUM INCREMENTS USING FOLLOWING PROCEDURE (SCRAPE DRUMS):			
		(1) AGITATOR OFF, DUMP IN 2 DRUMS YC-11			
		(2) START AGITATOR & STIR ONE MINUTE ONLY FOR EACH 2 DRUM INCREMENT			
	12	RECORD: TEMP 66 °F			
→	13	START AGITATOR & POUR IN & STIR 5 MIN	420	896-B	42
	14	RINSE GRATING, SIDES & MIXER BASKET WITH 150# WATER			

SHIPMENT		PAGE 2 CG 46 CODE YW-811-P EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. LBS.
ALM 2 CONT	15	STIR 60 MIN. RECORD: START 11.35 PM. NOTE: (1) DO NOT EXCEED 95°F DURING STIR (2) IF NECESSARY, CUT STIR WHEN TEMP REACHES 95°F			
	16	RECORD S15 STIR TEMP EVERY 10 MINUTES			
		TIME / INTERVAL, MIN / °F			
		START 11.35 PM /			
		11 45 / 10 / 78			
		11 55 / 20 / 80			
		12 5 / 30 / 82			
		12 15 / 40 / 84			
		12 25 / 50 / 86			
		12 35 / 60 / 88			
	17	Pour in and stir 5 min	2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 90 °F			
	19	Record: pH 11.0 (10.0-12.0)			
	20	If necessary, adj to pH 10.0-12.0 & Record: pH ____ Assume 50%		7-D	
	21	Pour in and stir 5 min	80	195-B	80
	22	Stop agitator			
	23	When scheduled dump in Lot		YW-811-	
		NOTE: If ALM is full, add as vol permits during homog			
CV 3	24	Run ALM thru homog at 4800-5200 psi into V-320			
		NOTE: (1) Collect material homog below 4800 psi and return to ALM			
		(2) DO NOT ALLOW HOMOG TEMP TO EXCEED 120°F			
		(3) IF HOMOG PRESSURE AT UPPER LIMIT (5200 PSI) & TEMP BORDERLINE, LOWER HOMOG PRESSURE ± 100 PSI. TEMP SHOULD DROP 3 to 4°F PER 100 PSI CUT IN PRESSURE. DO NOT GO LOWER THAN 4800 PSI (LOWER LIMIT)			
		(4) IF TEMP BECOMES EXCESSIVE, STOP HOMOG & ADVISE SUPVR. THIS CONDITION INDICATES FOREIGN MATERIAL HUNG UP BETWEEN BALLS & SEATS CAUSING SLURRY TO RECIRCULATE WITHIN HOMOGR.			
	25	DURING S24 HOMOG, RECORD HOMOG DISCHARGE TEMP EVERY 10 MIN			

TIME	INTERVAL, MIN	°F	TIME	INTERVAL, MIN	°F
START 1.20 PM	0	105	2.40 PM	70	114
1.30 PM	10	111	2.50	80	114
1.40	20	112	3.00	90	114
1.50	30	112	3.10	100	114
2.00 PM	40	114	3.20	110	114
2.10	50	114		120	
2.20 PM	60	114			

WAT	26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension			
	27	Rinse ALM with 1493# water calculated in S4 thru homogenizer at 2000-5000 PSI			
	28	Drain lines from homog to CV into drum & pour into CV			
	29	Add & stir 30 min	4 ozs.	816-A	1
	30	Record: pH 10.6 (10.0-12.0)			
	31	If necessary, adjust to pH 10.0-12.0 Assume 50%		7-D	
		& Record: pH Assume 75%		30-D	
	32	Discharge ± 25 G thru packout line & pour into CV			
	33	Fill 1-16 ounce jar from packout line & deliver to CTL for color. Record in S46			

DUP050292038

WAREHOUSE REQUEST FORM

REQUEST NO 3693
1/20/81

DELIVER TO Mixing AREA BY 1/22/81 7 AM

FOR: CG 46 CODE YW811P LOT 386983 SCHEDULED 1/20/81

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
P3	46	YC011A	93	37985	1026	58.40	6	325	1757	1300 -40
P3	46	YC011A	98	37985	169	58.40	1	290	289	289
35P4	46	YC011A	93	38040	521	61.10	3	300	853	600 -3
35P4	46	YC011A	98	38040	137	61.10	1	225	224	224
35P2	46	YC011A	93	37999	1084	37.30	9	325	2906	2600 -32
35P2	46	YC011A	98	37999	28	37.30	1	74	75	75

25 17 = 4

1021

PICK UP AND RETURN TO STORAGE:

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT

EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE __/__/__

COPY-1 PROD. CONTROL 1076
COPY-2 MANUFACTURING
COPY-3 WAREHOUSE
COPY-4 RAW MATERIAL

DUP050292039

N 31782.01