

CG 01 CODE YE-698-D
MAY -0-81-21452

PROCESSES

APPROVED BY

() YE-698-D (S) FWP 04/14/81

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COMTYP JOB NAME: 01YE698DMS

(DATE) (LOT NUMBER)

ESTIMATED WGT 5632 LBS.

STANDARD HRS. TIME M

EQUIP MENT	NAME: MOLYBDATE ORANGE	USE LBS	N-CODE	ACCT LBS
PREP	1 OBTAIN FOR S-22	84	108-A	84
1	2 WEIGH FOR S 25	65.04 %	33-D	47.85
	3 OBTAIN FOR S-30	734	4-A	734
	4 OBTAIN FOR S-34	146	3-A	146
	5 OBTAIN FOR S-36	237	32-D	237
	6 OBTAIN FOR S-38	367	15-A	367
	7 OBTAIN FOR S-40	243	3-A	243
	8 WEIGH IN DRUM FOR S-42 M 32.9	219	28-D	70
	9 OBTAIN FOR S-42	70	711-B	70
351	10 WEIGH INTO V-351 CHECKED BY: 27038.46	4901	10-D	1885
2		V-360		
359	11 WEIGH INTO V-359 CHECKED # MS 234.91 %	868	423-D	303
3				
SV	12 RUN 20" (996 G) WATER INTO V-242			
4	13 RUN IN FROM V-354 CHECKED BY: 85 MS 35.2916 %	17524	41-D	5110
	RECORD: G/ML 1.323 (1.270-1.328)			
	RECORD: PH 2.0 (2.2-3.7)			
	14 ADJ TO 79" (3770G) AT 67-69°F 83"	7260	57-A	7260
	RECORD: TEMP 69 °F			
	15 STIR 5 MIN & RECORD: PH 3.4 (2.2-3.7)			
	16 IF NECESSARY, ADJ TO PH 3.0-3.1 ASSUME 60%	4	33-D	3
	RECORD: PH 3.1			
	NOTE: DILUTE N-7-D 10:1 WITH WATER BEFORE			
	ADDING ASSUME 50%		7-D	
	17 RECORD: 1.132 G/ML (1.135-1.138)			
	NOTE: IF G/ML OUT OF LIMITS FILL OUT			
	CHECK LIST & ATTACH			
	18 STIR AT 67-69°F FOR S 28			
358	19 RUN 10" (500 G) WATER INTO V-358			
5	20 RUN V-359 INTO V-351 & PUMP IN V-351			
	21 ADJ TO 55" (2600 G)			
	22 SIFT IN N-108-A FROM S 9.5			
	23 STIR 5 MIN & RECORD: PH 9.5 (9.0-10.0)			
	24 ADJ TO PH 9.8-9.9 & RECORD: PH 9.8			
	ASSUME 50%		7-D	
	ASSUME 60%		33-D	
	25 ADD N-33-D FROM S 2 (PUMP FROM V-351,			
	FLUSH WITH 1000# WATER)			
	26 ADJ TO 66" (3121 G) AT 67-69°F			
	RECORD: VOL 66" & 69.85			
	27 STIR 5 MIN & RECORD: PH 7.5 (7.4-7.6) &			
	G/ML 1.083 (1.080-1.083)			
	NOTE IF G/ML OUT OF LIMITS FILL OUT CHECK			
	LIST & ATTACH			

MAY 27 1981

JH

	28	OBTAIN 1 QT SAMPLES OF S-18 & S-27 SOLUTIONS & TITRATE TWICE RECORD: LOWEST PH <u>2.25</u> & ML N-10-D <u>4.91</u> LOWEST PH <u>2.25</u> & ML N-10-D <u>4.91</u> NOTIFY SUPV IF ML N-10-D IS NOT IN RANGE 6.8-7.1 OR IF THE TWO TITRATIONS DIFFER BY MORE THAN 0.10 ML N-10-D (IF YES, FLUSH ALL EQUIPMENT & REPEAT TITRATIONS) DO NOT PROCEED IF N-10-D TITRATION IS OUT OF RANGE <u>2.30</u> ADJUST V-358 TO OBTAIN A TITRATION PH = <u>2.05</u> (2.00-2.10) (<u>2.20-2.35</u>)	<u>10</u>	33-D 7-D	<u>6</u>
SV 6	29	WHEN S-28 TITRATION OK, STRIKE V-358 THRU BOTH UNDERSURFACE DISTRIBUTORS INTO SV IN 16-18 MIN RECORD: START <u>1:02 P</u> , TOTAL MIN <u>16</u> NOTE: STRIKE TIME UP WHEN 1/2 VAT BOTTOM SHOWS & BUBBLES APPEAR IN SIGHT GLASSES 30 IMMEDIATELY DUMP IN N-4-A FROM S 3 & SET TIMER FOR 15 MINUTES 31 DURING S 30, WASH IN V-358 32 STIR 2 MIN & RECORD PH <u>2.22</u> (1.8-2.5) PEXS, <u>+</u> (MUST BE +) 33 STIR TOTAL OF 15 MIN FROM S-30 & RECORD: TEMP <u>70</u> *F (67-73*F) 34 DUMP N-3-A FROM S-4 35 STIR 3 MIN 36 POUR IN N-32-D FROM S-5 37 STIR 2 MIN 38 DUMP IN N-15 FROM S-6 39 STIR 3 MIN 40 DUMP IN N-3 FROM S-7 41 STIR 4 MIN FOR S-44			
DRUM 7	42	DURING S-41 SIFT N-711-B FROM S-9 INTO DRUM OF N-28-D FROM S-8 IN 1-2 MIN. 43 STIR 1-2 MIN WITH PADDLE TO MILKY SOLUTION			
SV 8	44	WHEN S-41 COMPLETE, IMMEDIATELY POUR N-711-B SOLUTION GRADUALLY OVER 5 MIN PERIOD INTO SV WATCH FOAM!!! IF FOAMING IS EXCESSIVE, STOP POURING UNTIL FOAM SUBSIDES 45 DUMP IN <u>350</u> 46 STIR 10 MIN <u>5.9</u> 47 RECORD: PH <u>5.9</u> (5.8-6.0) 48 IF NECESSARY, ADJ TO PH 5.8-6.0 & RECORD: PH- 49 RECORD: TIME <u>2:05 P</u> 50 FLOOD TO 153" (7619 G) 51 STOP AGITATOR Delayed ± 2 hrs. ice machine jammed 3 times START 3:00 PM FINISH 2:00 P OPTR 86 HELPER 225	<u>350</u>	<u>128-A</u> 7-D 33-D	<u>350</u>

28	OBTAİN 1 QT SAMPLES OF S-18 & S-27 SOLUTIONS & TITRATE TWICE RECORD: LOWEST PH <u>2.1</u> & ML N-10-D <u>7.14</u> LOWEST PH <u>2.1</u> & ML N-10-D <u>7.15</u> NOTIFY SUPV IF ML N-10-D IS NOT IN RANGE 6.8-7.1 OR IF THE TWO TITRATIONS DIFFER BY MORE THAN 0.10 ML N-10-D (IF YES, FLUSH ALL EQUIPMENT & REPEAT TITRATIONS) DO NOT PROCEED IF N-10-D TITRATION IS OUT OF RANGE <u>2.15</u> ADJUST V-358 TO OBTAIN A TITRATION PH = <u>-2.05</u> (2.00-2.10) <u>2.10-2.20</u>				
SV 6	29 WHEN S-28 TITRATION OK, STRIKE V-358 THRU BOTH UNDERSURFACE DISTRIBUTORS INTO SV IN 16-18 MIN RECORD: START <u>8:55 PM</u> , TOTAL MIN <u>18</u> NOTE: STRIKE TIME UP WHEN 1/2 VAT BOTTOM SHOWS & BUBBLES APPEAR IN SIGHT GLASSES 30 IMMEDIATELY DUMP IN N-4-A FROM S 3 & SET TIMER FOR 15 MINUTES 31 DURING S 30, WASH IN V-358 32 STIR 2 MIN & RECORD PH <u>2.1</u> (1.8-2.5) PBXS, <u>+</u> (MUST BE +) 33 STIR TOTAL OF 15 MIN FROM S-30 & RECORD: TEMP <u>71</u> *F (67-73*F) 34 DUMP N-3-A FROM S-4 35 STIR 3 MIN 36 POUR IN N-32-D FROM S-5 37 STIR 2 MIN 38 DUMP IN N-15 FROM S-6 39 STIR 3 MIN 40 DUMP IN N-3 FROM S-7 41 STIR 4 MIN FOR S-44				
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				7-D	
				33-D	

START FINISH OPTR HELPER
5:15 PM 10:00 PM 220 058