

→ Batch #

Date

EST. WGT.

6283

LBS.

STD. HRS.

9.5

TIME

M

6-11-81

(X) SF-67

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FEB 09-13-76

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BCG 09-17-76

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RE TYPED BY

emw 012177

06-005

2963

NON-BLEEDING

EQUIPMENT	NAME	SODIUM MOLYBDATE	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1	Inspect clarif press and clean if necessary (use 28 frames)			
	2	Weigh in SS container for S's 11 & 12	52	421-E	52
	3	Obtain for S's 10 & 12 (4700-4900# "as is")		418-C	
		LOT % MO #100%			
	200	(4) 8158 F 60.7 728 =	1200		728
	200	(8) 58191 61.3 1236 =	2000		1236
	200	(6) 58202 61.6 924 =	1500		924
		Note: Use in full drum increments			
	4	Obtain for S 16	100	418-C	61
		Note: Enter #100% under "acct Lbs" for S's 3 & 4			
348 2	5	Record: V-348 scale accuracy at 100# OK #			
	6	Calc and weigh in V-348 for S 7	5028	7-D	2389
		2378 #100% (S 3) x 0.83 = 2389 #100% N-7-D			
		Note: Enter #100% N-7-D under "Acct Lbs"			
209 3	7	Run V-348 into V-209 on wash water from previous batch			
	8	Adjust to 32" (1298 G)			
	9	Record: 115 °F, if above 115°F, adj to 115-110°F		57-A	
	10	Add 2 drums N-418-C from S 3 in 4-6 minutes			
	11	Add #6 N-421-E from S 2			
	12	Repeat S's 10 & 11 adding slowly to avoid excessive temp rise until all remaining N-418-C and N-421-E is added			
		Note: Keep temp below 185°F, stop adding N-418-C if necessary and allow to cool before proceeding			
	13	Stir 10 minutes at 175-185°F			
	14	Heat to 214-218°F and boil vigorously for 30 minutes			
	15	Turn off steam			
	16	Add N-418-C from S 4 in 2-3 minutes			
	17	Stir 10 minutes at 200-218°F			
	18	Record: pH 11.8 (10.8-11.1), if necessary adj to pH 10.8-11.1 with N-418-C in 20# increments	60.7 %MO	40	418-C 24
		or N-7-D in 5# increments	%	7-D	
	19	Record: pH 11.1 (10.8-11.1)			
	20	Adjust to 39" (1578 G) at 180-200°F			
	21	Stir 20 minutes at 180-200°F			
	22	Circulate thru clarif press and V-209 until effluent is clear			
		Maintain V-209 at 180-200°F			
		Record: Clarity OK			
239 4	23	When press effluent is clear, pump V-209 thru clarif press into V-239			
		Record: Time Start 3:00 AM			
	24	Wash in V-209 with minimum water			

EQUIPMENT		PAGE 2 CG 67 CODE SF-67	EST. WGT.	LBS.	USE LBS.	N CODE	ACCT. LBS.
Misc	25	During S 22 clarification calculate:					
5		A. 2389 # (100% N-7 S 3 & S 18) x 2.63 = 6283 #Na ₂ MoO ₄					
		B. Record: #Na ₂ MoO ₄ under "est wgt"					
Clarif	26	Rinse V-304 to sewer					
Press	27	Run 47" (573 G) water into V-304 and heat to 130-140°					
6	28	Install footplug in V-209					
	29	Wash press with hot water from V-304 thro fill port for 5 min					
		and collect in V-209					
	30	Wash press with hot water from V-304 thro fill port until V-304					
		is empty					
	31	Open all spigots on press					
	32	Close fill valve					
	33	Open wash valve					
	34	Open air valve located North of press and air blow 15 minutes					
	35	Close wash spigots and air blow 10 minutes					
	36	Shut off air valve and open all spigots					
	37	Dump press - take lot sample and send to Analytical Lab					
	38	Put sludge in metal drums and weigh. Record weight in Office					
	39	Hose out press frames and cloths with city water					
		START 11:00 P.M.					
		FINISH 3:55 A.M.					
		OPERATOR 381					