CG 01 CODE YE-698-D PROCESSES ( ) YE-698-D (T) APPROVED BY: FWP 10/15/82

10/25/82 (DATE) K2L23 (LOT) 5537 5527* LBS. (EST WT) COMTYP JOB NAME: 01YE69BDMT

BLENDED BACK: CG 01, PQ 98, [illegible] (CODE), [illegible] (LOT), [illegible] (POUNDS)

EQUIPMENT		NAME: MOLYBDATE ORANGE	USE LBS	N-CODE	ACCT LBS
PREP 1	1	OBTAIN SODIUM SULFATE FOR S-13	84	108-A	84
	2	CALCULATE & SET ON BADGER METER FOR S-16 (NITRIC ACID WEAK) 64.40 %	93	33-D	60
	3	OBTAIN SODIUM CHLORIDE FOR S-33	734	4-A	734
	4	OBTAIN SODA ASH FOR S-37	146	3-A	146
	5	OBTAIN SODIUM SILICATE FOR S-39	237	32-D	237
	6	OBTAIN SODA ASH FOR S-43	350	3-A	350
	7	OBTAIN ANTIMONY TRIOXIDE FOR S-46	70	711-B	70
351 2	8	WEIGH SODIUM CHROMATE INTO V-351. OPTR ____, MK ___, 37.70% OPTR ____, MK ___, ____%	5000	10-D	1885
359 3	9	WEIGH IN SODIUM MOLYBDATE SOLUTION OPTR ____, MK ___, T-360, 23.73% OPTR ____, MK ___, T-____, ____%	1277	423-D	303
358 4	10	RUN 10* (500 G) WATER INTO V-358			
	11	RUN V-359 INTO V-351 & PUMP IN V-351			
	12	ADJ TO 55* (2600 G)			
	13	SIFT IN N-108-A FROM S 1			
	14	STIR 5 MIN & RECORD: PH 10.6 (9.0-10.0)		OCT 28 1982	
	15	ADJ TO PH 9.8-9.9 & RECORD: PH 9.8 (CAUSTIC SODA SOLUTION) ASSUME 50%	____	7-D	____
		ASSUME 66%	3	33-D	2
	16	ADD N-33-D FROM S 2 USING BADGER METER			
	17	ADJ TO 66* (3121 G) AT 67-69*F RECORD: VOL 66* & 67 *F			
	18	STIR 5 MIN & RECORD: PH____(7.4-7.6) & G/ML 1.082 (1.080-1.083) NOTE IF G/ML OUT OF LIMITS FILL OUT CHECK LIST & ATTACH. TAKE 1 QT SAMPLE			
SV 5	19	RUN 20* (996 G) WATER INTO V-242 RECORD N-41-D STORAGE TANK TO PUMP FROM. CIRCLE ONE: 402 410 411 420 424 425			
	20	CHECK WITH CU SUPV: *STORAGE TANK MUST CONTAIN AT LEAST 2376 GAL: 402=49*, 410=25*, 411=48*, 420=25*, 424=25*, 425=31* *STORAGE TANK MUST HAVE STIRRED AT LEAST 20 MIN SINCE LAST ADDITION OR ADJUSTMENT *STORAGE TANK MUST BE ISOLATED UNTIL ALL PUMPING FOR THIS BATCH IS COMPLETE			
	21	SET METER FOR 300 G & PUMP TO SV 242			

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LOT: _____ COMTYP JOB NAME: 01YE698DMT PAGE 02 DATE PRINTED: 10/15/82

EQUIPMENT			USE LBS	N-CODE	ACCT LBS
SV 5 CONT	22	AT APPROX 100 G WHILE CONTINUING TO PUMP, CHECK PH & DENSITY. RECORD BELOW. IF NOT IN RANGE, STOP PUMPING & SEE SUPV.			
		* PH: 2.2 (2.2-3.7)			
		* DENSITY: 1.305 G/ML (1.270-1.328)			
	23	IF S-22 OK & WHEN S-21 COMPLETE, RECORD DENSITY 1.305 G/ML ON TRAPPED SAMPLE FROM END OF S-21 PUMPING.			
	24	USING DENSITY FROM S-23, FIND METER SETTING FOR SECOND PUMPING IN TABLE BELOW. NOTE: TABLE ACCOUNTS FOR 300 G ALREADY PUMPED IN S-21. CIRCLE DENSITY & SETTING IN TABLE BELOW.			

****** TABLE ******

G/ML	SETTING	G/ML	SETTING	G/ML	SETTING
1.270	1678 1644	1.291	1534 04	1.312	1410 82
1.271	1670 1637	1.292	1527 1497	1.313	1404 76
1.272	1663 1630	1.293	1521 91	1.314	1399 71
1.273	1656 23	1.294	1515 85	1.315	1394 67
1.274	1649 16	1.295	1509 79	1.316	1388 61
1.275	1641 09	1.296	1503 73	1.317	1383 56
1.276	1634 02	1.297	1497 67	1.318	1378 51
1.277	1627 1595	1.298	1490 61	1.319	1372 45
1.278	1620 88	1.299	1484 55	1.320	1367 40
1.279	1614 82	1.300	1478 49	1.321	1362 35
1.280	1607 75	1.301	1473 44	1.322	1357 30
1.281	1600 1568	1.302	1467 1438	1.323	1351 1324
1.282	1593 62	1.303	1461 38	1.324	1346 19
1.283	1586 55	1.304	1455 26	1.325	1341 15
1.284	1580 49	1.305	1449	1.326	1336 10
1.285	1573 42	1.306	1444 16	1.327	1331 05
1.286	1566 35	1.307	1438 10	1.328	1326 1300
~~1.286~~	~~1566~~	~~1.307~~	~~1438~~	~~1.328~~	~~1326~~
1.287	1559 28	1.308	1432 04	1.329	1543
1.288	1553 22	1.309	1427 1399	1.330	1537
1.289	1546 15	1.310	1421 93	1.331	1532
1.290	1540 10	1.311	1415 87	1.332	1526

1321 14 1 1 96

1298 1690 1095 1560

	25	SET METER & PUMP 1449 G (RECORD FROM TABLE) FLUSH LINE WITH WATER INTO SV FOR APPROXIMATELY 30 SECONDS			
	26	ADJ LEAD NITRATE TO 76* (3625 G) AT 67-69*F.		41-D	5110
		RECORD: 68 *F		57-A	_____
	27	STIR 5 MIN & RECORD PH: 2.7 (2.2-3.7)			
	28	IF NECESSARY ADJ TO PH 3.0-3.1 ASSUME 66%	_____	33-D	_____
		& RECORD PH: 3.05 ASSUME 50%	1	7-D	1
		NOTE: DILUTE N-7-D 10:1 WITH WATER BEFORE ADDING			
	29	RECORD: 1.149 G/ML (1.143-1.144) IF OUT OF SPEC FILL OUT CHECK LIST & ATTACH.			
	30	STIR AT 67-69*F FOR S-31. TAKE 1 QT SAMPLE.			

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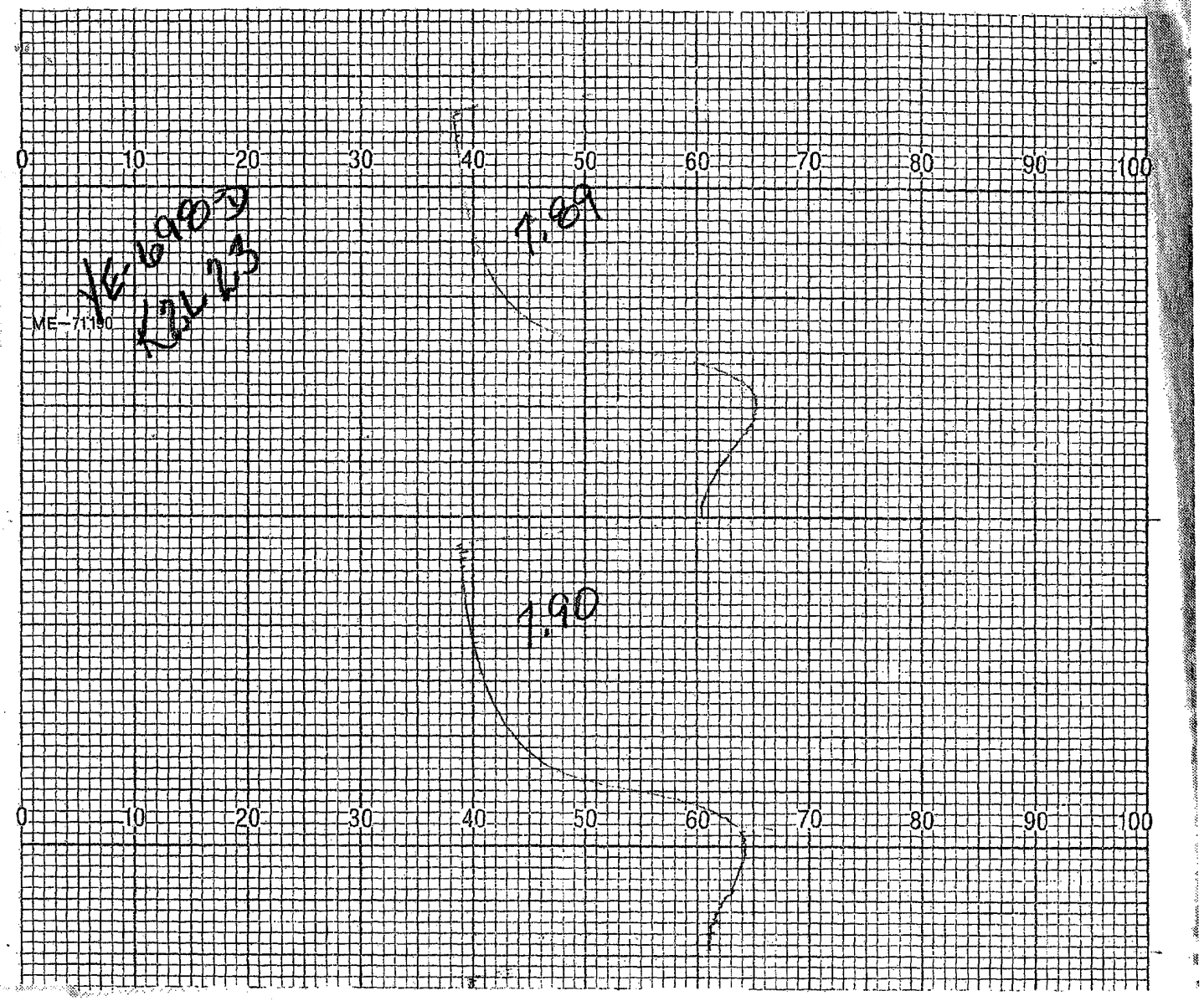

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			USE LBS	N-CODE	ACCT LBS
SV 5 CONT	31	OBTAIN 1 QT SAMPLES OF S-18 & S-30 SOLUTIONS & TITRATE TWICE NOTIFY SUPV IF ML N-10-D IS NOT IN RANGE 7.1-7.4 OR IF THE TWO TITRATIONS DIFFER BY MORE THAN 0.10 ML N-10-D (IF YES, FLUSH ALL EQUIPMENT & REPEAT TITRATIONS). DO NOT PROCEED IF N-10-D TITRATION IS OUT OF RANGE ADJUST V-358 FOR A TITRATION PH OF ~~2.10~~ TO ~~2.20~~		33-D	
		FROM FINAL IN-LINE TITRATION, RECORD LOWEST PH _____ & ML N-10-D _____. 1.85—1.95		7-D	
SV 6	32	WHEN S-31 TITRATION OK, STRIKE V-358 THRU BOTH UNDERSURFACE DISTRIBUTORS INTO SV IN 16-18 MIN			
		RECORD: START 4:40 Am, TOTAL MIN 18			
		NOTE: STRIKE TIME UP WHEN 1/2 VAT BOTTOM SHOWS & BUBBLES APPEAR IN SIGHT GLASSES			
	33	IMMEDIATELY DUMP IN N-4-A FROM S 3 & SET TIMER FOR 15 MINUTES			
	34	DURING S 33, WASH IN V-358			
	35	STIR 2 MIN & RECORD PH 2.0 (1.8-2.5)			
		PBXS, + (MUST BE +)			
	36	STIR TOTAL OF 15 MIN FROM S-33 & RECORD: TEMP 68 *F (67-73*F)			
	37	DUMP N-3-A FROM S-4			
	38	STIR 3 MIN			
	39	POUR IN N-32-D FROM S-5			
	40	STIR 2 MIN			
	41	RUN IN LIQUID ALUM USING BADGER METER	734	115-D	367
	42	STIR 3 MIN & FLUSH ALUM LINE WITH WATER			
	43	DUMP IN N-3 FROM S-6			
	44	STIR 4 MIN FOR S-48			
390 7	45	RUN IN HYDROCHLORIC ACID USING WEIGHT & FLOW CONTROL PANEL MK _____, 31.91 %	339	28-D	105
		MK _____, _____ %		28-D	
	46	DURING S-44 SIFT N-711-B FROM S-7 INTO V-390 WITH AGITATOR ON IN 1-2 MIN			
	47	STIR 1-2 MIN TO MILKY SOLUTION			
SV 8	48	WHEN S-44 COMPLETE, IMMEDIATELY RUN IN N-711-B SOLUTION GRADUALLY OVER 5 MIN PERIOD INTO SV WATCH FOAM!!! IF FOAMING IS EXCESSIVE, STOP UNTIL FOAM SUBSIDES.	~~330~~		~~330~~
	49	DUMP IN BLANC FIXE N	~~330~~ 330	128-A	330
	50	WHEN SCHEDULED, DUMP IN BLEND BACK LISTED ON TOP OF PAGE 1			
		RECORD: CODE _____, LOT _____, _____*			
	51	STIR 20 MIN			
	52	RECORD: PH 6.0 (5.8-6.0)			
	53	IF NECESSARY, ADJ TO PH 5.8-6.0 & RECORD: PH-_____ ASSUME 50%	_____	7-D	_____
		ASSUME 66%	_____	33-D	_____
	54	FLOOD TO 153" (7298 G) & STOP AGITATOR			

START	FINISH	OPTR
2:30 Am	5:35 Am	201+348

PRODUCT NAME: MOLYBDATE ORANGE

NON-BLEEDING PROCESSES YE-698-D (T) ALTERNATE

10/19/82 APPROVED BY: FWP 10/18/82

CG 01 CODE YE-698-D PKG ____

LOT K2L23

EST. WT. 5527* LBS. 5537

OCT 25 1982 OK TP

COMTYP JOB NAME: 01YE698DPT

MAKING NOTES: _____

= PRESSING =

INSTRUCTIONS					RECORD					
VAT	242				PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE	10-21				STARTED					
TIME	5:35 Am				CAKES USED					
RELEASED BY	RCH				WATER ON					
PRESS	2	92	93		HRS. WASHED					
NO.OF CAKES	54	54	54		M MHOS					
PRESS WITH AGITATION					HRS. WASHED					
WASH TO 500 M MHOS WITH 35-75* WATER					M MHOS					
TEST AFTER 2 HOURS					HRS. WASHED					
LOAD ON 7 CARS					M MHOS					
					CAKE CONDITION					
					NO CARS LOADED					
					EXPLAIN LOSSES					
SAMPLES 8 OZ					SAMPLED BY					
DELIVER TO CTL.					RELEASED BY					

= DRYING =

(EXTRUDED) DRY 10 HRS AT 240 DEG F

(NOT EXTRUDED) DRY 10 HRS AT 240 F

LUMP: - OK - WET - SALTS - CONTAMINATD

ADDITIONAL DRYING HOURS REQUIRED

SAMPLE

DELIVER

NO CARS PULLED NO DRUMS LUMP WGT

SAMPLED BY

RELEASED BY

CO-GRIND PER CTL INSTRUCTIONS

MILL MIKROATOMIZE SCREEN RPM

MAX. TEMP DEG F

SET ROOF BLAST - GATE AT "5" FOR HIGH AIR FLOW

GRINDING

SCREEN RPM

MAX. TEMP. F

EXPLAIN LOSSES

SAMPLE W/O MIXING

SAMPLES 1 ENV & 1 PINT CAN IF GROUND SEPARATELY

DELIVER TO CTL

DATE MIXED

SAMPLED BY

RELEASED BY

DUP050103047

LOT K2L03 CTL QUALITY SHEET 1 DATE 10/27/82

CG 01 CODE YE698D PQ EST 5527

DISP ____ SGND _____ DATE

TF 3001 S 98086 V/C

MT DK11 R17 DL6

UT ____ 96 ____ PT ____ R6 ____

STR 105+ TINT R11 DL6

FINISHW ___ FINISHD ___

BLEED _____ FINENESS ___

DC/MOIST ____ PH ____

OM ___ WS ____ WA ____

B/L ____

COMMENT

MOISTURE _____ PAINT _____
% SOLID _____ FLUID INK _____
SOL SALT _____ W BLENDER _____
BLEED _____ PLASTICS _____
RESIST'V _____ L/F _____
MISC _____

TEST _____ TEST _____
VS _____ VS _____
MASS _____ MASS _____
STR _____ STR _____
TINT _____ TINT _____
BLEED _____ BLEED _____
DATE _____ DATE _____

TEST _____ TEST _____
VS _____ VS _____
MASS _____ MASS _____
STR _____ STR _____
TINT _____ TINT _____
BLEED _____ BLEED _____
DATE _____ DATE _____

REMARKS _____

DUP050103048