

CG 01 CODE YE-698-D
MAY -0-81-1443

PROCESSES

APPROVED BY
FWP 04/14/81

(DATE) (LOT NUMBER)

COMTYP JOB NAME: 01YE698DMS

ESTIMATED WGT 5632 LBS.

STANDARD HRS. TIME M

EQUIP MENT	NAME	USE LBS	N-CODE	ACCT LBS
	NAME: MOLYBDATE ORANGE			
PREP 1	1 OBTAIN FOR S-32	84	108-A	84
	2 WEIGH FOR S-32 <u>105.04</u> %	<u>69</u>	33-D	<u>45</u> 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
ONLY →	8 WEIGH IN DRUM FOR S-42 M <u>32.9</u>	<u>24</u>	28-D	70
	9 OBTAIN FOR S-42	70	711-B	70
351 2	10 WEIGH INTO V-351 CHECKED BY: <u>145</u> <u>76338.05</u> %	<u>4954</u>	10-D	1885
359 3	11 WEIGH INTO V-359 CHECKED BY: <u>145</u> <u>MS1</u> <u>35.01</u> %	<u>865</u>	423-D	303
SV 4	12 RUN 20" (996 G) WATER INTO V- <u>242</u>			
	13 RUN IN FROM V-354 CHECKED BY: <u>MC</u> <u>207826</u> %	<u>1842</u>	41-D	5110
	RECORD: G/ML <u>1.310</u> (1.270-1.328)			
	RECORD: PH <u>2.4</u> (2.2-3.7)			
→	14 ADJ TO 79" (3770G) AT 67-69°F			
	RECORD: TEMP <u>67</u> °F	<u>181330</u>	57-A	<u>5940</u>
	15 STIR 5 MIN & RECORD: PH <u>3.35</u> (2.2-3.7)			
	16 IF NECESSARY, ADJ TO PH 3.0-3.1 ASSUME 60%	<u>1</u>	33-D	<u>1</u>
	RECORD: PH <u>3.1</u>			
	NOTE: DILUTE N-7-D 10:1 WITH WATER BEFORE ADDING		7-D	
	17 RECORD: <u>1.136</u> 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 5	19 RUN 10" (500 G) WATER INTO V-358			
→	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 1			
	23 STIR 5 MIN & RECORD: PH <u>9.8</u> (9.0-10.0)			
	24 ADJ TO PH 9.8-9.9 & RECORD: PH			
	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 <u>66</u> " & <u>69</u> °F			
	27 STIR 5 MIN & RECORD: PH <u>7.4</u> (7.4-7.6) & G/ML <u>1.083</u> (1.080-1.083)			
	NOTE IF G/ML OUT OF LIMITS FILL OUT CHECK LIST & ATTACH			

MAY 22 1981

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28 OBTAIN 1 QT SAMPLES OF S-18 & S-27
SOLUTIONS & TITRATE TWICE
RECORD: LOWEST PH 2.20 & ML N-10-D 2.14
LOWEST PH 2.19 & ML N-10-D 2.15
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
ADJUST V-358 TO OBTAIN A TITRATION PH = 2.20 1.5 33-D 9
(~~2.00-2.10~~) (2.15-2.25) 7-D

SV 29 WHEN S-28 TITRATION OK, STRIKE V-358 THRU
6 BOTH UNDERSURFACE DISTRIBUTORS INTO SV IN
16-18 MIN
RECORD: START 2:30 AM, TOTAL MIN 16
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 2.00 (1.8-2.5)
PBXS, + (MUST BE +)
33 STIR TOTAL OF 15 MIN FROM S-30 &
RECORD: TEMP 72°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 42 DURING S-41 SIFT N-711-B FROM S-9 INTO DRUM
7 OF N-28-D FROM S-8 IN 1-2 MIN.
43 STIR 1-2 MIN WITH PADDLE TO MILKY SOLUTION

SV 44 WHEN S-41 COMPLETE, IMMEDIATELY POUR N-711-B
B SOLUTION GRADUALLY OVER 5 MIN PERIOD INTO SV
WATCH FOAM!!! IF FOAMING IS EXCESSIVE, STOP
POURING UNTIL FOAM SUBSIDES
45 DUMP IN 350 128-A 350
46 STIR 10 MIN
47 RECORD: PH 5.9 (5.8-6.0)
48 IF NECESSARY, ADJ TO PH 5.8-6.0 ASSUME 50% 7-D
& RECORD: PH 5.8 ASSUME 66% 33-D
49 RECORD: TIME 3:00 AM
50 FLOOD TO 153" (7619 G)
51 STOP AGITATOR

START FINISH OPER HELPER
7:30 AM 11:00 PM 3:00 AM 86 145
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