

CG 01 CODE YC-016-B PQ 93

PROCESSES APPROVED BY:
(E) YC-016-B () FWP 11/17/8211/22/82 L2K63
(DATE) (LOT)4038
3938* LBS.
(EST WT)

COMTYP JOB NAME: 01YC016BME

BLENDED BACK: CG 01, PQ 98,

YC-16-B
(CODE)F2H88
(LOT)100
(POUNDS)

EQUIP MENT		NAME: MOLYBDATE ORANGE	USE LBS	N-CODE (RMCON)	ACCT LBS
PREP	1	WEIGH SODA ASH FOR S-36	117	3-A	117
	2	WEIGH FOR S-44	100	3-A	100
	3	WEIGH SODIUM SILICATE IN DRUM FOR S-40	185	32-D	185
	4	WEIGH SODIUM CHLORIDE FOR S-30	315	4-A	315
356	5	RUN 25" (451 G) WATER INTO V-356			
2	6	TURN ON AGITATOR AND STEAM			
	7	WEIGH AND SIFT IN BORIC ACID	345	131-B	345
	8	HEAT TO AND MAINTAIN 60-66° C FOR S-38			
359	9	WEIGH IN SODIUM MOLYBDATE SOLUTION:			
3		OPTR _____, MK <u>74</u> , T- <u>369</u> <u>30.95%</u>	<u>794</u>	423-D	244 246
		OPTR _____, MK _____, T-_____, _____%			
351	10	WEIGH IN SODIUM CHROMATE:			
4		OPTR _____, MK <u>303</u> , <u>38.05%</u>	<u>3881</u>	10-D	1477 1477
		OPTR _____, MK _____, _____%			
358	11	RUN 10" (473 G) WATER INTO V-358			
5	12	RUN V-359 INTO V-351 & PUMP IN V-351			
	13	ADJ TO 68" (3216 G) AT 67-69°F. RECORD: <u>68</u> "			
	14	STIR 3 MIN. RECORD: <u>67</u> °F & PH <u>9.2</u>			
	15	IF NECESSARY, ADJ TO PH 9.8-9.9 ASSUME 50%		7-D	
		RECORD: PH _____ ASSUME 66%		33-D	
	16	RECORD: G/ML <u>1.061</u> (1.060-1.062)			
SV	17	RUN 20" (996 G) WATER INTO V- <u>245</u>			
6		RECORD N-41-D STORAGE TANK TO PUMP FROM.			
		CIRCLE ONE: 402 410 411 420 424 425			
	18	CHECK WITH CU SUPV:			
		*STORAGE TANK MUST CONTAIN AT LEAST 1800			
		GAL: 402=37", 410=19", 411=37", 420=19",			
		424=19", <u>425=24"</u>			
		*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			
	19	SET METER FOR 300 G & PUMP TO SV <u>245</u>			

NOV 23 1982

N40808

EQUIP MENT	USE LBS	N- CODE	ACCT LBS
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SV 20 AT APPROX 100 G WHILE CONTINUING TO PUMP,
6 CHECK PH & DENSITY. RECORD BELOW. IF NOT
CONT IN RANGE, STOP PUMPING & SEE SUPV.

* PH: 2.5 (2.2-3.7)

* DENSITY: 1.317 G/ML (1.270-1.328)

21 IF S-20 OK & WHEN S-19 COMPLETE, RECORD
DENSITY 1.317 G/ML ON TRAPPED SAMPLE
FROM END OF S-19 PUMPING.

22 USING DENSITY FROM S-21, FIND METER SETTING FOR
SECOND PUMPING IN TABLE BELOW. NOTE: TABLE
ACCOUNTS FOR 300 G ALREADY PUMPED IN S-19.
CIRCLE DENSITY & SETTING IN TABLE BELOW.

**** TABLE ****

G/ML	SETTING	G/ML	SETTING	G/ML	SETTING
1.270	1178	1.291	1070	1.312	978
1.271	1172	1.292	1066	1.313	974
1.272	1167	1.293	1061	1.314	970
1.273	1161	1.294	1056	1.315	966
1.274	1156	1.295	1052	1.316	961
1.275	1151	1.296	1047	<u>1.317</u>	<u>958</u>
1.276	1146	1.297	1042	1.318	954
1.277	1140	1.298	1038	1.319	950
1.278	1135	1.299	1033	1.320	946
1.279	1130	1.300	1029	1.321	942
1.280	1125	1.301	1025	1.322	938
1.281	1120	1.302	1020	1.323	934
1.282	1115	1.303	1016	1.324	930
1.283	1110	1.304	1011	1.325	926
1.284	1105	1.305	1007	1.326	923
1.285	1100	1.306	1003	1.327	919
1.286	1094	1.307	999	1.328	915
1.287	1089	1.308	994	1.329	911
1.288	1085	1.309	990	1.330	908
1.289	1080	1.310	986	1.331	904
1.290	1075	1.311	982	1.332	901

23 SET METER & PUMP 958 G (RECORD FROM TABLE)
FLUSH LINE WITH WATER INTO SV FOR APPROXIMATELY
30 SECONDS

24 ADJ LEAD NITRATE TO 3148 G (66° 242 & 245,
64.5° 247) AT 67-69°F.

RECORD: 68 *F & ICE CONSUMED (330#/BLOCK)

25 STIR 5 MIN & RECORD PH: 3.0 (2.2-3.7)

**** USE TITRIMETER TO ADJUST N-41-D PH ****

26 IF NECESSARY ADJ TO PH 3.8-3.9 ASSUME 66%
& RECORD PH: 3.9 ASSUME 50%

NOTE: DILUTE N-7-D 10:1 WITH WATER BEFORE ADDING

27 RECORD: 1.27 G/ML (1.124-1.127) IF OUT OF SPEC
FILL OUT CHECK LIST & ATTACH.

28 STIR AT 67-69°F FOR S-29.

41-D 3893

330X.S 57-A 1650

33-D

7-D 1

LOT= _____ COMTYP JOB NAME: 01YC016BME PAGE 03 DATE PRINTED: 11/18/82
MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT	PAGE 03 OF 3 CG 01 CODE YC-016-B	USE LBS	N-CODE	ACCT LBS
29	RUN V-358 AT 67-69°F THRU BOTH UNDERSURFACE DISTRIBUTORS INTO SV AT 67-69°F IN 17-19 MIN RECORD: START <u>11:48</u> M & TOTAL MIN <u>(12)</u> NOTE: V-358 STRIKE TIME UP WHEN 1/2 VAT BOTTOM SHOWS MT			
SV 6 (CONT) 31	WHEN S-29 COMPLETED AND BEFORE WASHING IN V-358, DUMP IN N-4-A FROM S-4 RUN IN USING WEIGHT & FLOW CONTROL PANEL OPTR _____, MK <u>3</u> , <u>30.84%</u> OPTR _____, MK _____, % DURING S'S 30 AND 31 (IF ALONE, AFTER S'S 30 & 31) WASH IN V-358	<u>94</u>	28-D 28-D	29
32	STIR 2 MIN			
34	RECORD: PH <u>2.0</u> (2.2-2.5) & PB XS <u>+</u> (+)			
35	STIR TOTAL OF 15 MIN FROM COMPLETION OF S-29 RECORD: START <u>1:27</u> TOTAL MIN <u>15</u>			
36	DUMP IN N-3-A FROM S-1			
37	STIR 3 MIN			
38	RUN IN N-131-B FROM S-8 IN 7 MIN			
39	STIR 3 MIN			
40	POUR IN N-32-D FROM S-3			
41	STIR 2 MIN	<u>464</u>		<u>232</u>
42	RUN IN USING BADGER METER	<u>500</u>	115-D	<u>250</u>
43	STIR 3 MIN & FLUSH ALUM LINES WITH WATER			
44	DUMP IN N-3-A FROM S-2			
45	STIR 3 MIN			
46	RECORD: PH <u>7.0</u> (5.8-6.0)			
47	IF NECESSARY, ADJ TO PH 5.8-6.0 ASSUME 50% RECORD: PH _____ ASSUME 66%	<u>-</u>	7-D 33-D	<u>-</u>
48	WHEN SCHEDULED, DUMP IN BLEND BACK LISTED ON TOP OF PAGE 1			
49	RECORD: CODE <u>YC16B</u> , LOT <u>F2H88</u> , <u>100</u> #			
50	STIR 20 MIN RECORD: PH <u>5.9</u> (5.8-6.0)			
51	IF NECESSARY, ADJ TO PH 5.8-6.0 ASSUME 50%		7-D	
52	& RECORD: PH <u>6.9</u> ASSUME 66% FLOOD TO 153' (7298 G) & STOP AGITATOR	<u>10</u>	33-D	<u>6</u>
START <u>10:45 AM</u> FINISH <u>2:30 PM</u> OPTR <u>342-237</u>				