CG .01 CODE YE-698-D

PROCESSES ( ) YE-698-D (T)

APPROVED BY: FWP 10/15/82

__/__/__ (DATE) L2H29 (LOT) 5527* LBS. (EST WT)

COMTYP JOB NAME: 01YE698DMT

BLENDED BACK: CG 01, PQ 98, _____ (CODE), _____ (LOT), _____ (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 %	85	33-D	55 ~~80~~
	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 323, MK 274, 37.98% OPTR ____, MK ___, _____%	4963	10-D	1885
359 3	9	WEIGH IN SODIUM MOLYBDATE SOLUTION OPTR 322, MK 68, T-360, 31.96% OPTR ____, MK ___, T-____, _____%	948	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 10.8 (9.0-10.0)			
	15	ADJ TO PH 9.8-9.9 & RECORD: PH 9.9			
		(CAUSTIC SODA SOLUTION) ASSUME 50%	____	7-D	____
		ASSUME 66%	3	33-D	3
	16	ADD N-33-D FROM S 2 USING BADGER METER			
	17	ADJ TO 66" (3121 G) AT 67-69*F			
		RECORD: VOL 66" & 69 *F			
	18	STIR 5 MIN & RECORD: PH 7.4 (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-247			
		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 247			

NOV 5 1982

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:_____ (2.2-3.7) * DENSITY: _____ G/ML (1.270-1.328)			
	23	IF S-22 OK & WHEN S-21 COMPLETE, RECORD DENSITY _____ 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	1.291	1534	1.312	1410
1.271	1670	1.292	1527	1.313	1404
1.272	1663	1.293	1521	1.314	1399
1.273	1656	1.294	1515	1.315	1394
1.274	1649	1.295	1509	1.316	1388
1.275	1641	1.296	1503	1.317	1383
1.276	1634	1.297	1497	1.318	1378
1.277	1627	1.298	1490	1.319	1372
1.278	1620	1.299	1484	1.320	1367
1.279	1614	1.300	1478	1.321	1362
1.280	1607	1.301	1473	1.322	1357
1.281	1600	1.302	1467	1.323	1351
1.282	1593	1.303	1461	1.324	1346
1.283	1586	1.304	1455	1.325	1341
1.284	1580	1.305	1449	1.326	1336
1.285	1573	1.306	1444	1.327	1331
1.286	1566	1.307	1438	1.328	1326
1.286	1566	1.307	1438	1.328	1326
1.287	1559	1.308	1432	1.329	1543
1.288	1553	1.309	1427	1.330	1537
1.289	1546	1.310	1421	1.331	1532
1.290	1540	1.311	1415	1.332	1526

	25	SET METER & PUMP _____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: _____*F		57-A	_____
	27	STIR 5 MIN & RECORD PH: _____ (2.2-3.7)			
	28	IF NECESSARY ADJ TO PH 3.0-3.1 ASSUME 66%	_____	33-D	_____
		& RECORD PH: _____ ASSUME 50%	_____	7-D	_____
		NOTE: DILUTE N-7-D 10:1 WITH WATER BEFORE ADDING			
	29	RECORD: _____ 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.			

LOT: _____ COMTYP JOB NAME: 01YE698DMT PAGE 02 DATE PRINTED: 11/02/82

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: 2.11 (2.2-3.7) * DENSITY: 1.323 G/ML (1.270-1.328)			
	23	IF S-22 OK & WHEN S-21 COMPLETE, RECORD DENSITY 1.322 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	1644	1.291	1504	1.312	1382
1.271	1637	1.292	1487	1.313	1376
1.272	1630	1.293	1491	1.314	1371
1.273	1623	1.294	1485	1.315	1367
1.274	1616	1.295	1479	1.316	1361
1.275	1609	1.296	1473	1.317	1356
1.276	1602	1.297	1467	1.318	1351
1.277	1595	1.298	1461	1.319	1345
1.278	1588	1.299	1455	1.320	1340
1.279	1582	1.300	1448	1.321	1335
1.280	1575	1.301	1444	1.322	1330
1.281	1568	1.302	1438	1.323	1324
1.282	1562	1.303	1432	1.324	1319
1.283	1555	1.304	1426	1.325	1315
1.284	1549	1.305	1420	1.326	1310
1.285	1542	1.306	1416	1.327	1305
1.286	1535	1.307	1410	1.328	1300
1.287	1528	1.308	1404	1.329	1295
1.288	1522	1.309	1399	1.330	1290
1.289	1515	1.310	1393	1.331	1285
1.290	1510	1.311	1387	1.332	1280

	25	SET METER & PUMP 1330 G (RECORD FROM TABLE) FLUSH LINE WITH WATER INTO SV FOR APPROXIMATELY 30 SECONDS			
	26	ADJ LEAD NITRATE TO 3625 G (76°-242/245 & 74.5° -247) AT 67-69°F		41-D	5110
		RECORD: 68 °F & ICE CONSUMED (330#/BLOCK)	330X	57-A	
	27	STIR 5 MIN & RECORD PH: 2.7 (2.2-3.7) **** USE TITRIMETER TO ADJUST N-41-D PH ****			
	28	IF NECESSARY ADJ TO PH 3.0-3.1 ASSUME 66%		33-D	
		& RECORD PH: 3.1 ASSUME 50%	2	7-D	1
		NOTE: DILUTE N-7-D 10:1 WITH WATER BEFORE ADDING			
	29	RECORD: 1.144 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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LOT: _____ COMTYP JOB NAME: 01YE698DMT PAGE 03 DATE PRINTED: 10/15/82

EQUIPMENT			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~~ 1.95-2.05		33-D	
		FROM FINAL IN-LINE TITRATION, RECORD LOWEST PH _____ & ML N-10-D _____.		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 1:55 PM, 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 1.8 (1.8-2.5) PBXS, + (MUST BE +)			
	36	STIR TOTAL OF 15 MIN FROM S-33 & RECORD: TEMP 71 *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 3, 30.84 %	340	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.			
	49	DUMP IN BLANC FIXE N	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 5.9 (5.8-6.0)			
	53	IF NECESSARY, ADJ TO PH 5.8-6.0 ASSUME 50%		7-D	
		& RECORD: PH- ASSUME 66%		33-D	
	54	FLOOD TO 153" (7298 G) & STOP AGITATOR			

START	FINISH	OPTR
11:20 AM	2:55 PM	322-129

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