

CG 01 CODE YE-698-D

MAY -0-81 E-1107

PROCESSES

APPROVED BY

() YE-698-D (S)

FWP 04/07/81

(G) YC-10-B ()

() ()

(DATE)

(LOT NUMBER)

COMTYP JOB NAME: 01YE698DMS

ESTIMATED WGT

5632 LBS.

STANDARD HRS.

TIME M

EQUIP MENT	NAME: MOLYBDATE ORANGE	USE LBS	N-CODE	ACCT LBS
PREP	1 OBTAIN FOR S-22	84	108-A	84
1	2 WEIGH FOR S 25	69	33-D	458
	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
	8 WEIGH IN DRUM FOR S-42 M 2, 32.00%	217	28-D	70
	9 OBTAIN FOR S-42	70	711-B	70
351	10 WEIGH INTO V-351 CHECKED BY: #196 M 37.91%	4972	10-D	1885
2				
359	11 WEIGH INTO V-359 CHECKED #196 M 45.40, 62%	746	423-D	303
3				
SV	12 RUN 20" (996 G) WATER INTO V-242			
4	13 RUN IN FROM V-354 CHECKED BY# M 28.47% 17949		41-D	5110
	RECORD: G/ML (1.270-1.328)			
	RECORD: PH (2.2-3.7)			
	14 ADJ TO 79" (3770G) AT 67-69°F			
	RECORD: TEMP 67 °F		57-A	
	15 STIR 5 MIN & RECORD: PH 3.0 (2.2-3.7)			
	16 IF NECESSARY, ADJ TO PH 3.0-3.1 ASSUME 60%		33-D	
	RECORD: PH			
	NOTE: DILUTE N-7-D 10:1 WITH WATER BEFORE			
	ADDING ASSUME 50%		7-D	
	17 RECORD: 1137 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	19 RUN 10" (500 G) WATER INTO V-358			
5	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 9.2 (9.0-10.0)			
	24 ADJ TO PH 9.8-9.9 & RECORD: PH 9.8			
	ASSUME 50%	4	7-D	2
	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 66" & 67 °F			
	27 STIR 5 MIN & RECORD: PH 7.4 (7.4-7.6) &			
	G/ML 1.083 (1.080-1.083)			
	NOTE IF G/ML OUT OF LIMITS FILL OUT CHECK			
	LIST & ATTACH			

(2)

USE
LBSN-
CODEUSE
LBS

28 OBTAIN 1 QT SAMPLES OF S-18 & S-27 SOLUTIONS & TITRATE TWICE
 RECORD: LOWEST PH 2.33 & ML N-10-D 7.23
 LOWEST PH 2.30 & ML N-10-D 7.29 *Please fill in*
 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 2.35
 ADJUST V-358 TO OBTAIN A TITRATION PH = 2.05
 (2.00-2.10) 2.30 - 2.40 33-D
 7-D

29 WHEN S-28 TITRATION OK, STRIKE V-358 THRU BOTH UNDERSURFACE DISTRIBUTORS INTO SV IN 16-18 MIN
 RECORD: START 4:45 PM, TOTAL MIN 18
 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 2.5 (1.8-2.5)
 PBXS, + (MUST BE +)
 33 STIR TOTAL OF 15 MIN FROM S-30 & RECORD: TEMP 77 *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 SOLUTION GRADUALLY OVER 5 MIN PERIOD INTO SV
 8 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%
 & RECORD: PH- ASSUME 66% 7-D
 49 RECORD: TIME 5:35 PM 33-D
 50 FLOOD TO 153" (7619 G)
 51 STOP AGITATOR

START FINISH OPTR HELPER
12:30P 5:40PM 126 196