

CG 01 CODE YE-698-D

PROCESSES

APPROVED BY

MAY -0.81-E-1455

() YE-698-D (S)

FWP 04/14/81

(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	1 OBTAIN FOR S-22	84	108-A	84
	2 WEIGH FOR S 25 <u>45.04%</u>	<u>74</u>	33-D	<u>48</u>
	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 <u>32.0%</u>	<u>219</u>	28-D	70
	9 OBTAIN FOR S-42	70	711-B	70
351	10 WEIGH INTO V-351 CHECKED BY: <u>45 M 27.78-74</u>	<u>4919</u>	10-D	1885
2		<u>11-370</u>		
359	11 WEIGH INTO V-359 CHECKED <u>#145 M 57.38-25%</u>	<u>272</u>	423-D	303
3				
SV	12 RUN 20" (996 G) WATER INTO V- <u>242</u>			
4	13 RUN IN FROM V-354 CHECKED BY: <u>43 M 540, 21.0%</u>	<u>17566</u>	41-D	5110
	RECORD: G/ML <u>1.322</u> (1.270-1.328)			
	RECORD: PH <u>1.9</u> (2.2-3.7)			
	14 ADJ TO 79" (3770G) AT 67-69°F			
	RECORD: TEMP <u>67</u> °F	<u>151330</u>	57-A	<u>4950</u>
	15 STIR 5 MIN & RECORD: PH <u>1.90</u> (2.2-3.7)			
	16 IF NECESSARY, ADJ TO PH 3.0-3.1 ASSUME 60%		33-D	
	RECORD: PH <u>2.1</u>			
	NOTE: DILUTE N-7-D 10:1 WITH WATER BEFORE			
	ADDING ASSUME 50%	<u>10</u>	7-D	<u>5</u>
	17 RECORD: <u>12.85</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 <u>17.0, 17.8</u>			
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 <u>9.6</u> (9.0-10.0)			
	24 ADJ TO PH 9.8-9.9 & RECORD: PH <u>9.8</u>			
	ASSUME 50%	<u>2</u>	7-D	<u>1</u>
	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>1.12</u> (1.080-1.083)			
	NOTE IF G/ML OUT OF LIMITS FILL OUT CHECK			
	LIST & ATTACH			

MAY 28 1981

EQUIP

PAGE 2 CG 01 YE-698-D EST WGT 5632#

USE
LBSN-
CODEUSE
LBS

20 OBTAIN 1 QT SAMPLES OF S-18 & S-27
SOLUTIONS & TITRATE TWICE
RECORD: LOWEST PH 2.12 & ML N-10-D 2.06
LOWEST PH 2.15 & ML N-10-D 2.02
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 = 2.05
(2.00-2.10) 2.10-2.20

33-D
7-DSV
6

29 WHEN S-28 TITRATION OK, STRIKE V-358 THRU
BOTH UNDERSURFACE DISTRIBUTORS INTO SV IN
16-18 MIN
RECORD: START 10:43 AM 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 2.2 (1.8-2.5)
PBXS, 1 (MUST BE +)
33 STIR TOTAL OF 15 MIN FROM S-30 &
RECORD: TEMP 70 *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
7

42 DURING S-41 SIFT N-711-B FROM S-9 INTO DRUM
OF N-28-D FROM S-8 IN 1-2 MIN.
43 STIR 1-2 MIN WITH PADDLE TO MILKY SOLUTION

SV
8

44 WHEN S-41 COMPLETE, IMMEDIATELY POUR N-711-B
SOLUTION GRADUALLY OVER 5 MIN PERIOD INTO SV
WATCH FOAM!!! IF FOAMING IS EXCESSIVE, STOP
POURING UNTIL FOAM SUBSIDES
45 DUMP IN
46 STIR 10 MIN
47 RECORD: PH 6.2 (5.8-6.0)
48 IF NECESSARY, ADJ TO PH 5.8-6.0
& RECORD: PH 6.0
49 RECORD: TIME 12 PM
50 FLOOD TO 153" (7619 G)
51 STOP AGITATOR

350

128-A

350

ASSUME 50%
ASSUME 66%7-D
33-D

START FINISH OPTR HELPER
5:00 PM 12 PM 86 145
7:00 PM 12 PM 409 196