

CG 01 CODE YE-698-D

PROCESSES

APPROVED BY

MAY -0.81-E-1446

() 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	65.04%	33-D	45.25
	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 32.0%	28-D	28-D	70
	9. OBTAIN FOR S-42	70	711-B	70
351 2	10. WEIGH INTO V-351 CHECKED BY: #69.76538.25%	49.28	10-D	1885
359 3	11. WEIGH INTO V-359 CHECKED #69.523.91%	8.6	423-D	303
SV 4	12. RUN 20" (996 G) WATER INTO V-245			
	13. RUN IN FROM V-354 CHECKED BY: #62.57756%	85.1	41-D	5110
	RECORD: G/ML 1.300 (1.270-1.328)			
	RECORD: PH 7.5 (2.2-3.7)			
	14. ADJ TO 79" (3770G) AT 67-69°F	2970	57-A	2970
	RECORD: TEMP 68 *F			
	15. STIR 5 MIN & RECORD: PH 7.3 (2.2-3.7)			
	16. IF NECESSARY, ADJ TO PH 3.0-3.1 ASSUME 60%	4	33-D	3
	RECORD: PH 3.1			
	NOTE: DILUTE N-7-D 10:1 WITH WATER BEFORE			
	ADDING ASSUME 50%		7-D	
	17. RECORD: 1.137 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 9.6 (9.0-10.0)			
	24. ADJ TO PH 9.8-9.9 & RECORD: PH 9.9			
	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 " & 69 *F			
	27. STIR 5 MIN & RECORD: PH 2.6 (7.4-7.6) &			
	G/ML 1.083 (1.080-1.083)			
	NOTE IF G/ML OUT OF LIMITS FILL OUT CHECK			
	LIST & ATTACH			

MAY 26 1981

USE
LBSN-
CODEUSE
LBS

	28	OBTAIN 1 QT SAMPLES OF S-18 & S-27 SOLUTIONS & TITRATE TWICE RECORD: LOWEST PH <u>2.25</u> & ML N-10-D <u>7.08</u> LOWEST PH <u>2.23</u> & ML N-10-D <u>2.08</u> 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 <u>2.20</u> ADJUST V-358 TO OBTAIN A TITRATION PH = <u>2.05</u> (<u>2.00-2.10</u>) <u>2.15-2.25</u>			
SV 6	29	WHEN S-28 TITRATION OK, STRIKE V-358 THRU BOTH UNDERSURFACE DISTRIBUTORS INTO SV IN 16-18 MIN RECORD: START <u>8:00 PM</u> TOTAL MIN <u>17</u> 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 <u>2.0</u> (1.8-2.5) PBXS, <u>+</u> (MUST BE +) 33 STIR TOTAL OF 15 MIN FROM S-30 & RECORD: TEMP <u>72</u> *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 <u>5.9</u> (5.8-6.0) 48 IF NECESSARY, ADJ TO PH 5.8-6.0 & RECORD: PH <u>5.9</u> 49 RECORD: TIME <u>9:10 PM</u> 50 FLOOD TO 153" (7619 G) 51 STOP AGITATOR	350	128-A	350
		ASSUME 50% ASSUME 66%		7-D 33-D	

START FINISH OPR HELPER
4:30 PM 9:20 PM 86 69