

CG 01 CODE YE-69B-D

MAY -0.81-31451

PROCESSES

APPROVED BY

() YE-69B-D (S) FWP 04/14/81

(DATE)

(LOT NUMBER)

() ()
() ()

ESTIMATED WGT

(2) 5632

LBS.

STANDARD HRS.

COMTYP JOB NAME: 01YE69BDMS

TIME _____ M

EQUIP MENT	NAME: MOLYBDATE ORANGE	USE LBS	N-CODE	ACCT LBS
PREP	11 OBTAIN FOR S-22	84	108-A	84
1	21 WEIGH FOR S 25	65.04	33-D	50.85
	31 OBTAIN FOR S-30	734	4-A	734
	41 OBTAIN FOR S-34	146	3-A	146
	51 OBTAIN FOR S-36	237	32-D	237
	61 OBTAIN FOR S-38	367	15-A	367
	71 OBTAIN FOR S-40	243	3-A	243
	81 WEIGH IN DRUM FOR S-42 M	32.0%	28-D	70
	91 OBTAIN FOR S-42	70	711-B	70
351	10 WEIGH INTO V-351 CHECKED BY: 225 238.46%	4201	10-D	1885
2		1-760		
359	11 WEIGH INTO V-359 CHECKED 225 M 5224.91%	868	423-D	303
4	12 RUN 20" (996 G) WATER INTO V-245			
	13 RUN IN FROM V-354 CHECKED BY: 225 M 5224.91%	17566	41-D	5110
	RECORD: G/ML 1.32 (1.270-1.328)			
	RECORD: PH 3 (2.2-3.7)			
	14 ADJ TO 79" (3770G) AT 67-69°F	2640	37-A	264
	RECORD: TEMP 69 °F			
	15 STIR 5 MIN & RECORD: PH 2.5 (2.2-3.7)			
	16 IF NECESSARY, ADJ TO PH 3.0-3.1 ASSUME 60%		33-D	
	RECORD: PH 3.05			
	NOTE: DILUTE N-7-D 10:1 WITH WATER BEFORE			
	ADDING ASSUME 50%		7-D	
	17 RECORD: 1.135 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 9.5 (9.0-10.0)			
	24 ADJ TO PH 9.8-9.9 & RECORD: PH 9.85			
	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 7.6 (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 20 1981

EQUIP

PAGE 2

CG 01

YE-498-D

EST WGT 54524

USE

LBS

N-

CODE

USE

LBS

28

OBTAIN 1 QT SAMPLES OF S-18 & S-27

SOLUTIONS & TITRATE UNICOR

RECORD: LOWEST PH 2.1 & ML N-10-D 2.2LOWEST PH 2.0 & ML N-10-D 2.2

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 = 2.0(2.00-2.10) 2.15

33-D

7-D

10

SV
6

29

WHEN S-28 TITRATION IS COMPLETE, STRIKE V-358 THRU

BOTH UNDERSIDE DISTRIBUTORS INTO SV IN

18-19 MIN

RECORD: START TIME 12:17 TOTAL MIN 12

NOTE: STRIKE WHEN 1/2 VAT BOTTOM SHOWS

& BUBBLES APPEAR IN SIGHT GLASSES

30

IMMEDIATELY DUMP N-4-A FROM S 3 & SET TIMER

FOR 15 MINUTES

31

DURING S 30, STRIKE V-358

32

STIR 2 MIN PH 1.8 (1.8-2.5)

PBXS, (1.8-2.5)

33

STIR TOTAL TIME FROM S-30 &

RECORD: 12:32 *F (67-73*F)

34

DUMP N-3-A

35

STIR 3 MIN

36

POUR IN N-3-B 1-5

37

STIR 2 MIN

38

DUMP IN N-3-B 1-6

39

STIR 3 MIN

40

DUMP IN N-3-B 1-7

41

STIR 4 MIN 1-8

DRUM
7

42

DURING S-41, DUMP N-711-B FROM S-9 INTO DRUM

OF N-28-D 1-8 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 FOAMING IF FOAMING IS EXCESSIVE, STOP

POURING UNTIL FOAM SUBSIDES

45

DUMP IN

350

128-A 350

46

STIR 10 MIN

47

RECORD: PH 5.8 (5.8-6.0)

48

IF NECESSARY, ADJUST PH 5.8-6.0

ASSUME 502

20

7-D

10

49

& RECORD PH 5.8

ASSUME 662

33-D

50

RECORD: TIME 12:42

51

FLOOD TO 153 (153-156)

52

STOP AGITATOR

START FINISH OPIR HELPER
1:00 PM 5:10 86 225