SOUTH PRODUCTION NOTES

June 27, 2016
3-11 Shift Notes
BASF EMPLOYEES
209 Last Recordable
277 Last Lost time

Title V Notes: **Trimer** – back up and running. Cleaned flow probes on afternoon shift. ORP was lowered to -490 due to running #1. Bringing up feed rate now.
Keep an eye on the stack.
F1 – back up and running. Sheaves and belts have been ordered in case we have any more issues. **We need to drain half a tote from F1 per day on 2nd shift to get rid of Moly.** Need a sample of the sump taken on afternoon shift everyday on afternoon shift, and the sump pumped.
CTO – is online and running. Keep an eye on the ammonia day tank level; the tank looks like it is not cutting off at 80%.
Please keep the B31 sump locked out. We need to watch sump closely and sample every shift so we don't overflow. Had issues with it filling quickly during pfaudler cooling.
There is an intermittent issues with one of the NOx/CO sensors that keeps tripping out the system. Please keep an eye on it. WOW

#1 MED / AI 5645:

Continue making batches.
We are ok to build up feed. Bodmann is going to increase the rate on the calciner and we will need to run most shifts.
Grease the end seals each shift.

#1 RC / AI 5645 next:

Continue feeding, Bodmann wants to increase the feed rate to the MOD rate now that #4 is finished. Keep an eye on the trimer due to the high nitrates in this product.
Started feeding at ½ the MOD rate to ease the trimer in. This product has a lot of Nitric in it, so we need to keep a close eye on the trimer while running #1 and #4 together.

#2 MED line / Styrene:

We are going to hold off making batches until we get a few bags off the floor.
The replacement pallet jack is in shipping and we can bring it up to dept.

We need to clean the pallet jack we borrowed from LIB and have Bob Urig inspect it.
Plows were inspected and look good.
Do not manually move the pallets on the mezzanine - please take them down as you are bringing new bags up.
When we double stack the material put an extra pallet in between so people don't accidentally fork the top of the bags.
Green drums are the only drums to have dry ice put into them.

#2 RC / Styrene:

Calciner is running.
Feed bags in batch order.
We need to drain half a tote from F1 per day to get rid of Moly.

#3 MED line /:

Continue to follow cleaning sheets. Sheet are in the GL office, Please return when done for your shift.
Make sure we are greasing end seals once per shift when running.

#3 RC / D-1708 NAQ:

Calciner is cool, I was reversed on day shift 6/27 to purge out material.
Make sure to seal pouches on labels (we have had a few fall out).

#4 RC / D0222:

Finished. Bring temperatures down for a quick cleanup.
We will be switching over to cu-0228 next. Sheet is on GL-Stocks desk.
All bags of dried material have been brought over from Tunnel Kiln area.

#5 RC / Catoxid:

Kirk has reset the sequence. Need to light calciner on afternoon shift and bring up to temps. We will start feeding when we are at temp, Keep an eye on the feed end vacumax system.
Interlock that is spazzing out has been disabled until a new one can be installed.
Make sure that we are not staging bags for #4 by #5- we would not want to accidentally feed one of them.
When running, feed Hopper should not be filled past 2 feet below the top to allow room for blowdowns. HEPA filter was last changed out 6-11-16 on dayshift.

#6 RC & Dryer / D-0257:

Made a batch in the pfaudler on day shift. Feed material when aging is done.
Sly scrubber pumps have been switched over. No change in flow rates or trends.
A partial bag and 3 drums of material need to be refed – labeled and put on 2nd floor.
Close top of bags with wire tie and place on our dock #3 trailer.
Make sure the material has aged before feeding to the dryer.

West Pfaudler / Cu-0226:

Need to pull the lid and readjust the spray arm. We would like to start up the 0228 on Tuesday morning.
We can use a couple of zip ties to hold the arm up. Attach them to the vacuum arm. Use the Green Chem resistant ties.
We need to finish up this product because we have visitors in for the next product next week.
Leave bags open to air dry after unload.

East Pfaudler / D-0257:

Pump was replaced and batch made on day shift. Need to make batches to fill line back up.
We need to keep the area under the Pfaudler hopper cleaner. It was noted that there were a lot of PM extrusions around on the ground by the team that came through this week.
WE ARE USING THE NEW BLUE BUGGIES.

6 Tank / Empty:

Solution is made and sample in the lab.
Also need to lock out the discharge pipe so that we don't accidentally use it for this current run of cu-0226

7 Tank / Cu-0226 Solution:

Need to rinse out the tank and put the solution in the tote of solution that was toted off. Label it as D-0226 solution, we may use it in an upcoming run.

National Dryer / cleaning:

We need to finish up the cleaning, for the next material
Schirmer to soda blast.

PK Blender / Catoxid:

We need to screen 3 batches of sterotex/graphite mix for the north end. Please deliver to the blender room when done.
Discharge valve is sticking closed. WOW to have maintenance look at it.
We have the new screen for the building 9 screener. It is by the Cage in building 31. Install before screening more material.
Continue with Catoxid as we have manpower.
Removed the rubber discharge cloth. Need to talk with operators on how to operate the new chute. Apparently a bunch of them did not know it was modified.
Check bag house DP before starting each batch.

Flow meter is installed but not calibrated yet. DO NOT USE- trying to get it calibrated.
DP Gauge should be set at 3.5 and 4.25.

Abbe Blender / D 5206:

HF tote has been closed up and Abbe lid was removed and vessel cleaned out.
Cover plates over open hole in floor have been reinstalled.

Tower 3 / Cu 0860:

Tower was started on midnight shift, Having issues the vent fans, causing the Hydrogen step in the towers to cut off the hydrogen. Should be back running late on day shift.

Tower 6 / E 474 next:

Tower unloaded and washed down. We will be going to E-474 next.
Do not start until we are done doing the 406 on the screener and 0860 screening has started.
O2 meter is out for repairs.

North Screener / ?:

Holding for engineering. Should be fixed during shutdown.

South Screener / E 406:

Screener started screening 406
Switch to 0860 after the 406 is finished.
If you wash down drums with water you need to dry them off – the green drums are very prone to rust.

#2662 (west) Pill Machine / Al 3915:

Down- should be dry running on afternoon shift.

#2664 (east) Pill Machine /:

Continue to run.

TK #2 / Zr-0404:

Done. Blowers have been turned off and kiln is down.
Leave the saggars on - we don't know what product we will be going to next.

TK #4 / 103 GP screening:

Continue screening- keep feeder set at 50 and keep that area cleaned. Need to get a safety shower inspection done.

Harrop Kiln / Al-3920:

Continue to run. We will no longer be refeeding the oversized material. Empty the bucket into the labeled oversize drum and it will be rescreened in PR2. Approx 3 bags ahead of kiln.
We need to stop feeding hot material to the screener by making a large pile on the top of the screener then turning it on after the material has cooled. By overloading the screener we are causing the product to not screen correctly and this putting us out of spec on this material. We must now rescreen a bunch of material we have already made. Please allow cars to come around and cool, and feed the screener only if you are able to keep the screener running.

Building 27 Belt Filter / Cu 6081:

We need to run this station as much as possible. We need to send another shipment out to be calcined on monday.
Continue, and be sure to hand in / fill out SAP sheets.
Jeff has updated the batch sheets and we are okay to run. Jeff will provide training on the new Walk The Line requirements.
We have switched to 188 lined super sacks. These will need cardboard sleeves around them and new clean pallets.

Top 14 are important enough to keep running and staffed, top 6 cannot afford to have additional production interruptions.

1) #6RC/East Pfaudler
2) West Pfaudler
3) #4 RC/Trimer
4) #1 MED/RC/Trimer
5) #1 RC North
6) North CUAPV (to keep #1 RC North running)
7) South Precip/APV (PPT is low on feed)
8) #2 MED/RC
9) #3 MED/RC/CTO
10) Horne Machine
11) Harrop Kiln
12) South PK
13) #5 RC
14) North PK/Wyssmont

15) Screening 103 GP TK #4 Screener
16) Reduction Towers/Screening
17) PR2 103 GP
18) PR2 Al-3915 T
19) Kneader
20) PR2 Cu-0864 T