SOUTH PRODUCTION NOTES

December 28, 2013
Midnight Shift

BASF EMPLOYEES
36 Last Recordable
181 Last Lost Time

#1 MED Al-5637: No longer making batches of AL-5637. The plan is to clean the dryer and calciner for D-0756 (if needed). Cleaning on hold for now as Sly scrubber repaired and trying to relight #6 dryer/calciner. We will go back to the AL-5637 whenever Grodecki and other engineers advise (dependent on status of #6).

#1 RC / clean for D-0756: We brought the temperatures down and reversed the calciner. The calciner is on hold until status of #6 confirmed and additional guidance provided by Grodecki.

Exhaust to Trimer

Midnight Shift: Waiting for decision by Bill Grodecki whether to run sand through.
Day shift: We will hold off with any additional cleaning/flushing efforts until confirmation that #6 is up and running, and whether Chevron permits us to use #1 line for D 0756.
Afternoon Shift: No change.

#2 MED line/ D-0768: Continue until we run out of either the copper carbonate or microsorb. There is more of both in the near rail shed. Also, continue hand-picking contaminated bagged material…feed this material to the calciner hopper when possible. 1 bag remaining.
Midnight Shift: Continued. Grodecki advised that we will continue until either the microsorb or the copper carbonate runs out. NOTE; end seals leaking bad, work notification written for seals to be repacked.
Day Shift: There is more copper carbonate and microsorb in the rail shed. Continue on until one or the other runs out.
Afternoon Shift: Had issues with powder mixed in with wet mix and locked up the auger. Were able to get maintenance to press it out and get it back to the department. Back up and running on midnight shift. We should run out of the Copper carbonate before microsorb according to Hebb(see note at end of shift notes.

#2 RC/ D-0768: Be sure to shovel the material from the floor onto the dryer bed on the feed end of the dryer at least once a shift. Continue to feed the calciner and check the screen on the granulator once a day to make sure there is not a hole in it. SAMPLING NOTE: please get two 16 oz samples per pallet for the lab.
Midnight Shift: Continue on. Currently up to mid-60s regarding drums in Lot 232.
Day shift: Continue on. Dump any picked D 0768 (in drums) into the RC feed hopper.
Afternoon Shift: Shut down calciner late on afternoon shift. Building feed.

Exhaust to CTO

#3 MED line /Next D-1795 NAQ: **Continue following the clean up sheet and signing off on what you have completed. The dryer/spiral/calciner/and calciner spiral should be done before the mixer/pulva/extruder. We will need to wash out the calciner and clean the spiral elevators before running.**
Midnight Shift: No change. Set-up instructions for the D 1795 will (through dryer) will be provided by Grodecki on Friday.
Day shift: No change.
Afternoon Shift: No change. Still need to clean the MED.
#3 RC /Next D-1795 NAQ: **We will need to wash out the calciner and clean the spiral elevators before running.**
Exhaust to CTO
Midnight shift: No change. Planning to address small pockets of extrusions on dryer and flush calciner this weekend.
Day shift: No change today. Work on final cleaning through weekend (minor dryer vacuuming, minor flushing of calciner.
Afternoon Shift: No change. Operator scheduled to flush the calciner on midnight shift.

Abbe Blender / D-5206: **Continue on until we are out of HF. We should have 24 batches left as of 3PM Friday the 20th. All of the 5202 should be in the railshed.**
Midnight shift: Out of HF.
Day shift: No change.
Afternoon Shift: Officially out of HF.

National Dryer / 5206 : **Done.**
Midnight shift: No feed.
Day shift: No feed.
Afternoon Shift: No change.

#4 RC / D-5206: **Continue to feed.**
Exhaust to 4 DC
Midnight shift: Continue on. May have several bags from Wednesday that need to be refed (went through too fast).
Day shift: All available 5206 was fed. There are 3 bags from lot 476 (2, 3, 4) that are being re-analyzed. May or may not have to re-feed. Will know by Saturday morning.
Afternoon Shift: Refed bags 2,3,4, and 5. Calciner just about empty.

HC-11 Tanks / Cu 5020: **Continue on. There is a pallet of Britesorb samples that were returned to the department (HC-11). At least one box contains 1 gallon (4 lb) pails. Per Noemi Trent, please add one of these to each strike batch in 4 tank.**
Midnight shift: Continue with batches…no issues with pump or tanks.
Day shift: Continue on, no issues. NOTE: flow rates were re-adjusted per Noemi Trent on Friday day shift (metals back to 650, soda ash back to 1870). MOD modified to show this.
Afternoon Shift: Continued on.

PK Blender / 4011: **19 batches of 4011 completed. On hold for now.**
Midnight shift: No change
Day shift: No change.
Afternoon Shift: No change.

#5 RC / 4011 done. DC has new HEPA filter installed.
Exhaust to Trimer
Midnight shift: Down
Day shift: Down
Afternoon Shift: Down.

New Pfaudler / BE-0101 E 1/8th: Extrusion batches to start Friday.
Midnight shift: Hold until day shift as we will be making next batches using Al 3921 E 1/8th batches (Lot 3, bags 5-7, 9-14, extrusions vs tablets), per Justin Quach.
Day shift: First batch of BE 0101 using Al 3921 E 1/8th made, will not make next batch until Saturday day shift, earliest. Raws for next two batches are on 3rd floor near pfaudler (see MOD).
Afternoon Shift: On Hold. Batch to be made on 1st shift.

Old Pfaudler D-0756: **On hold until dryer and calciner lit and feeding. Need to use RO unit for batches. PLEASE NOTE that each bag of base must be weighed (check-weigh) before loading into the pfaudler. Need to confirm that the bag weights are correct.**
Midnght shift: On Hold.
Day shift: Sly scrubber repaired, trying to light dryer and calciner. When both are lit and feeding, restart D 0756 batches. More base D 0702 in rail shed.
Afternoon Shift: Waiting for #6 RC to run before making a batch.

#6 - RC / D-0756: Sly scrubber repaired, trying to relight dryer and calciner. When up to temp and ready, restart feeding and schedule next batches on old pfaudler. The bags that come off of this calciner need to be check weighed in building 31 and recorded on the log sheet. MAKE SURE THAT WE TAPE SHUT THE SAMPLE JARS. Maintain 250 lbs/hr.

Exhaust to Sly Scrubber

Midnight shift: Down…waiting for Sly scrubber repairs (hopefully Friday). Will confirm status with Greg Menz first thing Friday morning.

Day Shift: Sly scrubber repaired, trying to relight dryer and calciner. Resume feeding when ready. Work oder was written as first attempt to get calciner running failed (burners went out). HELP…..

Afternoon shift: Almost began feeding before calciner kicked out. Trying again on midnight shift.

Tower 3 / Cu-0860: Loaded and running.

Tower 6 / Cu-0860: Loaded and running.

Midnight Shift: Continued.

Day shift: Continue

Afternoon shift: Continued on.

Harrop Kiln - Al-3921 T 3/16": Down…saggers will need to be changed to half saggers in the near future for next product. Also, parts from the harrop screener were used on the 2nd screener in the tunnel kilns.

North Screener / Cu-0860: Continue

Midnight shift:Continue….18 totes

Day shift: Continue on…~16 totes

Afternoon Shift: Continued on.

South Screener / Cu-0860: Continue.

Midnight shift: Continue…18 totes

Day shift: Continue on…~ 16 totes

AfternoonShift: Continued on.

#2662 Pill Machine / Al-3917 3/16: Finished. Holding for decision to switch to 3915.

#2664 Pill Machine / Al-3917 3/16: Finished. Holding for decision to switch to 3915.

Midnight shift: No change

Day shift: No change.

Afternoon Shift: No Change.

<u>Tunnel Kiln #2 / BE-0101 Extrusions:</u> Continue loading/unloading. ..1 scoop per sagger-12 pounds.
Midnight shift: NOTE: We will be making three special batches of BE 01010 using Al 3921 extrusions starting Friday. When the first batch is made, we will need to run out whatever material is on TK #2 in the bin, then use an empty car as a spacer, then start loading the new BE 0101 material. In addition, the screener fines screen will need to be changed BEFORE we screen the new material. MOD will be updated, and this information will be discussed further with the TK operators.
Day shift: Continue. Follow midnight instructions above. First batch made in pfaudler and bags are at tunnel kiln. Next batch (2 of 3) will be tentatively scheduled for Saturday day shift. The Be 0101 tablets in TK #2 bin should be done by around 6:00 pm Friday, then have an empty car for a spacer, then begin loading the Be 0101 E 1/8th. Also, 8 mesh fines screen was delivered to TK #2. It will need to be installed AFTER the last tablets are screened and BEFORE the extrusions are screened. Make sure the empty spacer car is marked accordingly so every operator knows when to change the fines screen.
Afternoon Shift: Change over was made with a one car gap. First bag was emptied at 2am and 2nd bag hung.

<u>Tunnel Kiln #4 / BE-0101 Tablets:</u> Continue loading/unloading. ..1 scoop per sagger-12 pounds.
Midnight shift: Continue with BE 0101 tablets (remaining tablet bags will run on TK #4).
Day shift: Continue, 3 bags on floor plus partial on deck.
Afternoon Shift: Continued on.

Copper carb, Versal 300 and Microsorb clay are in the rail shed you will run out of Copper carb first and we want to use it all so make a part batch to use it all. D 0702 is in the the rail shed or the 3rd floor. There AMMONIUM METATUNGSTATE on the 1st floor. The last of the britesorb is in the rail shed and the soda ash is in shipping. Keep loading the trucks at our docks with D 0768 drums and bags and the D 0756 when this get up and running. There is still some Cu 0860 in the far rail shed.

Bill Grodecki's Instructions:

I. I have left cleanup instructions for MED3/RC3. The next product on mix/extrusion (starting mid-January) will be similar to D-1794 so only a rough cleanup of mix/extrude is necessary. D-1795 will run on dry/calcine starting ~12/30. Only a rough cleanup is needed to avoid white extrusions in the colored product. Since we have 2 weeks, this is a good fill in job. (UPDATE: will work on this during weekend)

II. SSD is going well but please check the granulator screen daily and change if necessary. Lengths will be off if a hole goes undetected. (UPDATE: screen checked on Thursday and so far OK. Needed to be tightened, but not worn out).

Tim and I discussed it and made an executive decision to begin taking department retain samples of finished tower products. Operators will begin taking 6-16 oz. samples of finished product (instead of 3). Set 3 on the post for pickup and keep 3 in the screening room for retain. If a sample turns up missing, we will have the retains to give to the lab. Keep the retains for a month and return to production. I will post the new procedure in the screening room.