SOUTH PRODUCTION NOTES

April 19, 2014
Midnight Shift

BASF EMPLOYEES
37 Last Recordable
287 Last Lost Time

#1 MED / AL-3992:

No milled recycle needed per engineer. Work notifications written for oil leak at gearbox on the extruder (4/8/14).
Day shift: After confirming correct inserts, we began MED line. Please note that the MOD and MI inserts listed have the correct number (JMP 3760P83F). It was discovered that JMP mistakenly wrote the wrong insert number on their packaging (JMP 3670P83F).
Afternoon Shift: Continued running.
Midnight shift:

#1 RC / AL 3992:

Hold until Trimer frees-up and Selexorb is completed.
Day shift: Hold until we get Selexorb lined out and drumming/bags are filling with good material. Calcining must wait until the Selexorb is completed (exhausting to Trimer).
Afternoon Shift: On hold.
Midnight shift:

Exhaust to Trimer

#2 MED line/ Cu-0860:

Finishing the last batch late on 2nd shift. Work notification on #2 Viron East flow meter still outstanding (RAND 4/7/14) - per the engineer, we can run with low flow.
Day Shift: making additional batches due to more Cu 3818 found. When the Cu 3818 hopper in the powder room gets close to around 1000 lbs, contact John Bodmann for guidance on how to finish batches.
Afternoon Shift: Contacted Bodmann and decided to make a final large batch using the last of the Cu 3818 that was in the hopper. It is finishing up late on 2nd shift.
Midnight shift:

#2 RC/ Cu-0860:

We are starting slowly so keep an eye on the rate at the start. F1 is working again.
Day shift: Continue
Afternoon shift: Continued on.
Midnight shift:

Exhaust to F1

#3 MED line / D-0704:

Breaker repaired, continue batches.
Day shift: Continue
Afternoon Shift: Continued on.
Midnight Shift:

#3 RC/ D-0704:

Currently feeding. We need to keep track of the weight on the fines drums as they are filled up – need to add the weight to the green sheet. Additionally, and because it is a precious metal base, we need to weigh each bag and record its weight on the log sheet by the scale at the East side of building 31 on the first floor. HEPA filter for the CTO was changed[4/17/14 M.V.] Keep an eye on the DP for this.
Day shift: Continue feeding. Please note that late on midnight shift the CTO stopped pumping ammonia (around 4:30 am Friday). It was determined that the low inlet NOx ppm caused the flow to stop going to the CTO. Bill Grodecki arrived Friday morning to manually adjust the ammonia flow and CTO is working OK. Any issues going into the weekend, contact Bill for guidance.
Afternoon Shift: Continued on. No issues with the CTO being in manuel at 35%. This setting may be able to be reduced.
Midnight shift:

Exhaust to CTO

Abbe Blender – D-5206:

We are ahead on this job and can run as manpower permits. We can run on the weekend and off shifts. Make sure to read Grodecki's instructions at the end of the shift notes regarding how to match up the lots of 5202. We will need to start staging these upstairs as there is going to be work done on the elevator this upcoming week.
Day shift: No activity (contractors)
Afternoon shift: No activity (manpower).
Midnight shift:

National Dryer / D-5206:

Make sure that we are taking the bags coming off the National dryer to the far railshed for the moment. We will not feed D-5206 to the calciner just yet.
Day shift: The material in the square buggies fed early in the shift was very wet and may need to be fed through again. The totes from last night are still on the 2nd floor draining. Feed through if they dry out and drain enough.
Afternoon Shift: No totes on the 2nd floor with material in them.
Midnight Shift:

PK Blender / 1506 is next:

Confirm with John Bodmann with how to use the partial bag of 1505 to dry back the 1 wet batch that is still in building 9. Hold the 1 batch that was wet. It will need to be dried back with help from the engineer.
Day shift: Continue 1506 impregs with Lot 45 material (use Lot 44 solution numbers). Should be 3 batches left to make from Lot 45
Afternoon Shift: 1 batch made before moving operator. 2 batches left.
Midnight Shift:

#5 RC / 1506:

Need to remember that we do not need 5A dust collector running with this product. We need to check the suction twice every shift.
Day shift: Continue
Afternoon shift: Continued to run.
Midnight shift:

Exhaust to Trimer

Old Pfaudler – D-0795 blends:

We need to man this job with 2 people if possible to get ahead. Continue getting the blends done.
Day Shift: Blends have been completed (made batch 90 per the instruction sheet from Bill Grodecki)
Afternoon Shift: No change. Clean out sheet has been provided.
Midnight Shift:

Tower 3 / Loading DPT 101:

Loading the DPT 101. REMINDER…the Cu-1155 3/16x3/16 that was unloaded is different from the material in Tower 6! Keep segregated from the T 3/16 x 1/8.
Day shift: Continue
Afternoon shift: Unloaded tower and began loading.
Midnight Shift:

Tower 6 / Cu-1155 T 3/16 x 3/16:

Running the Cu-1155 T 3/16 x 3/16
Day shift: Continue.
Afternoon shift: Holding until after maintenance work on Monday.
Midnight Shift:

North Screener / Cu-1155 3/16 x 1/8

Scale work by OCS completed. Switch screener to Cu 1155 3/16 x 1/8 when Cu-1986 is completed.
Day shift: Screen changed over to Cu 1155 3/16 x 1/8. Hold until south screener issue resolved and decision made on how to proceed
Afternoon Shift: We can run the Cu 1155 3/16x 1/8 material on the North screener only. Be advised that this is a different kind of alcohol. Do not mix up the two different sizes of Cu 1155.
Midnight shift:

South Screener / Cu-1986:

Scale work by OCS completed. Switch screener to Cu 1155 3/16 x 1/8 when Cu-1986 is completed.

Day shift: NOTE: late midnight shift (early Friday morning) the south screener motor began to fail, and eventually quit by day break. There are still approximately 3 drums of material in the hanging tote, down to the screener. With the screener motor dead, the only way to access the motor would be to take screener apart. The plan is to isolate the tote using the wheel "knife" gate under the tote and keep that portion under nitrogen. If the knife gate can be successfully closed, the screener will then need to be removed and dismantled in order to access screener motor. We also will need to "clear the room" of all drums, alcohol or any other flammable or ignitable material. FIRST STEP…get knife gate to close and then notify Bill Grodecki and Leon Zavodnik for further instructions.
Afternoon Shift: Butterfly valve closed on mini-hopper and system put on nitrogen. Still debating on how to remove motor without disassembling the screener.(possibly hoisting the screener and suspending it from the above decking to keep the system sealed and save the material. The fines and oversized hoses would have to be removed from their drums and tied up to keep the nitrogen in the system.)
Midnight shift:

Tunnel Kiln #2 / D-0406 (Zinc material off #1 MED):

COMPLETED-Is in shut down mode.
Day shift: Done
Afternoon Shift: Done.
Midnight shift: Completed.

Tunnel Kiln #3 / Cu Carb testing:

We have lit up zone #2 per the engineer and have added material to the kiln for the continuing testing. Material will come off the kiln in the morning.
Day shift: Latest test saggers sampled and at lab. Waiting for further instructions.
Afternoon Shift: Continued to monitor temps.
Midnight shift:

Tunnel Kiln #4 / Cu-0540:

We will need to light this kiln in preparation for the Cu-0540. The MOD should be in the TK area already. The conveyor has been replaced in TK4.
Day shift: Continue loading and unloading. Report to GL if kiln stops and needs maintenance to look at it.
Afternoon Shift: Continued on.
Midnight shift:

#4 RC / Selexorb:

Started Selexorb end of day shift Thursday 4/17/14. Make sure surface areas are above 140 AND color is olive green. When this is confirmed, contact John Bodmann for guidance to switch to drums.
Day shift: Continue adjusting temps and sampling for surface area.
Afternoon Shift: Continued on and after talking to Bodmann we were given the go ahead to switch to drums(12 of them and then switch back to bags.)
Midnight Shift:

Exhaust to Trimer

#6 RC / D-0754:

Will need to get cleaned for Friday inspection.(MV.4/15/14) Clean calciner, syntron and calciner discharge. Could not get calciner to rotate.
Day Shift:
Afternoon shift: No change. Need to clean and try to light on Saturday if possible.
Midnight shift:

Exhaust to

#2662 (east) Pill Machine / Zr-0403 1/8: Hold

Started to clean up and take apart machines in preparation for Zr material. We will use only one dust collector.
Day Shift: No change.
Afternoon shift: No change.
Midnight shift: No change.

#2664 (west) Pill Machine / Zr-0403 1/8: Hold

Started to clean up and take apart machines in preparation for Zr material. We will use only one dust collector.
Day Shift: No change.
Afternoon shift: No change.
Midnight shift: No change.

Harrop Kiln - Al-3921 T 3/16":

Down… saggers have been removed, screener parts at TK#2
Day shift: HOLD
Afternoon shift: HOLD
Midnight shift: HOLD

New Pfaudler / Celenese Trial

The Pfaudler has been rinsed but not acid washed. Tentative start update the week of 4-21.
Day shift: HOLD
Afternoon Shift: HOLD
Midnight shift: HOLD

HC-11 Tanks :

Acid washed Tanks 4 & 107; all tanks empty with the exception of Tank 2. (RAND - 3/24/14)
Day shift: No activity
Afternoon Shift: No activity
Midnight shift: No activity

Priorities for the next week from Leon Z:

I. Safety and Environmental
II. Towers - follow schedule by Kristen for work next week make sure to keep Cu-1155 T 3/16 by 1/8 separate from 3/16 by 3/ 16. If we make a mistake both orders will be short
III. Finish 1506 and switch back to 1505
IV. 3 line - D-0704 keep the rate up
V. 4 RC - Selectsorb make sure color and SA look ok run out what we have and hold
VI. 1 line Al- 3992 finish extrusion and start calciner after Selectsorb is completed. This is due to ship next week, check the quality
VII. Blends then clean pfaudler for QAQ trial (is the solution line from tanks blanked to the pfaudler so we do not have the possibility of any cross contamination at the weigh tank?)
VIII. 6 RC and drier - need to have this clean and put back together for QAQ trial. Rahul will be here Tuesday so let's get it together this weekend and get it lit up. No contamination. John will check on Monday
IX. Tunnel Kilns Cu-0540 and Cu-3818 P trials
X. Abbe and National
XI. Cu-0860 finish
XII. Cu-5020 P (actually 6081) will start next Wednesday. A number of visitors will be here so let's make we are ready and show well.

XIII.

Sheila will also be here next Wednesday and Thursday so let's make sure we are neat and clean. We should be addressing any powder leaks /spills from mix lines, etc

If I missed something obvious let me know. Items 1-9 require a CALLOUTS for maintenance.