SOUTH PRODUCTION NOTES

April 21, 2014
Morning Shift

BASF EMPLOYEES
39 Last Recordable
289 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). 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). NOTE: additional work notifications written for continued issues with extruder constantly kicking out, and for mixer outlet valve passing powder to pulva when powder is dropped from hopper.
Day shift: After making 20 batches per Kristen Kaput, on hold until dried and calcined analysis obtained. In addition, several work notifications written that will need to be addressed before restarting (see above).
Afternoon Shift: On hold until we get calcined results from the lab.
Midnight shift: On hold.

#1 RC / AL-3992:

Calciner is ready to run since the #4 RC has no more feed.
Day shift: Claciner lit and coming up to temp. Plan on pre-start walk through beginning 2nd shift (Selexorb should be about done by then on #4 RC). If everything OK, start feed. (NOTE: MOD calls for bagging-off fines for reclaim. Per Kristen Kaput, we will drum the fines, then repack into appropriate bag for reclaim at a later date).
Afternoon Shift:
Midnight shift: Stopped the feed after we got 5 drums of fines versus 8 drums of finished good material. Screens are correct per MOD. Called engineer and left voicemail at 11:35 pm (RAND 4/21/14). All 8 finished drums were reweighed and corrected where applicable – some were very light.

Exhaust to Trimer

#2 MED line/ Cu-0860:

On hold…out of recycle. 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: Batches done as Cu 3818 recycle consumed. Will wait for further instructions.
Afternoon Shift: On hold.
Midnight shift: On hold.

#2 RC/ Cu-0860:

Continue.
Day shift: Continue. Should be out of feed by 2nd shift Sunday.
Afternoon shift: Feeding the last bag from the floor. There is one bag remaining on the bag off station that will need to be fed.
Midnight shift: Last of the material available has been fed. Material will run out at very end of shift or at the very beginning of first shift.

Exhaust to F1

#3 MED line / D-0704:

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

#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. CTO operating normally. Move any calcined bags to 3rd floor as space permits.
Afternoon Shift: Continued on.
Midnight shift: Continued on.

Exhaust to CTO

#4 RC / Selexorb:

Calciner temps brought down and reversed(M.V. 4/20)
Day shift: Finishing last of the feed. Should be empty by end of day shift. Reverse and bring down so #1 calciner can be switched to Trimer.
Afternoon Shift: Calciner reversed.
Midnight Shift: On hold. Reversed and temps down.

Exhaust to Trimer

PK Blender / 1505 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: Hold for now. Will impreg more 1506 when we get 1505 calcined bags from #5 RC.
Afternoon Shift: On hold for 1505 material.
Midnight Shift: On hold.

#5 RC / 1505:

We have made the switch back to 1505. 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 1506, then switch to the 1505. Only short break in between 1506 feed and 1505 feed to quickly purge the calciner.
Afternoon shift: Fed the last bag of 1506 at 8:30PM Waiting for hopper to empty and then blow down the dust collector so we can start feeding the 1505 material.
Midnight shift: Made the switch back to 1505 (RAND 4/21/14).

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: Trying to light calciner with assistance from electrician. Items still needed before using this week: quick vacuum of dryer belt at discharge end; button-up syntron; re-attach calciner discharge tube; re-assemble screener after installing 12 M and 3 M screens; vacuum trays underneath dryer belt and a final quick sweeping/vacuuming all around area from dryer to bag-off scale. Try to work on these tonight…anything remaining will be finished Monday.
Afternoon shift: No change(manpower).
Midnight shift: Continuing the clean up. All is left is assembling the screener once the screens are found and re-attach the calciner discharge tube.

Exhaust to

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.
Day shift: Continue batches off shifts and during weekend as manpower permits.
Afternoon shift: Continued to run.

Midnight shift: Continued to run and train.

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: Continue feeding as material available.
Afternoon Shift: Continued to feed as material is available.
Midnight Shift: Feeding as material is available.

Tower 3 / DPT-101:

Loaded the DPT 101
Day shift: Tower loaded and on hold for maintenance on Monday (chiller tie-in).
Afternoon shift: On hold.
Midnight Shift: On hold until Monday.

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

Running the Cu-1155 T 3/16 x 3/16
Day shift: Tower will be on hold and under nitrogen until Monday, then will be unloaded and reloaded (DPT 101) as part of SMED exercise.
Afternoon shift: On hold.
Midnight Shift: On hold – material is still in the tower under nitrogen.

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

Switched screener to Cu 1155 3/16 x 1/8. All Cu-1155 3/16" x 3/16" has been isolated and cordoned off with red tape – DO NOT USE THIS MATERIAL.
Day shift: Continue (using 130 lbs alcohol per drum)
Afternoon Shift: Continued on.
Midnight shift: Continued on.

South Screener / Cu-1986:

Switch screener to Cu 1155 3/16 x 1/8 when Cu-1986 is completed (after determining how to deal with left-over material in screener-bad motor)
Day shift: No activity and on hold due to screener motor issues. Will re-assess on Monday.
Afternoon Shift: Continued on.
Midnight shift:

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.
Day shift: Next test saggers loaded into car #4 again. Monitor overnight…will unload and sample Monday morning. NOTE: Jack Pettry advised to bump up temps to 475 degrees.
Afternoon Shift: Continued to monitor.

Midnight shift: Continued to monitor.

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: Continud on.

Old Pfaudler – D-0795 blends completed:

Blends completed…cleaning sheets on GLs desk
Day Shift: No activity (short on personnel), Still need to get cleaned for QAQ trial next week. Solution lines from 6 tank is blanked, but 7 tank is open to pfaudler solution tank. No solution currently in either 6 or 7 tank at this time.
Afternoon Shift: No change(manpower).
Midnight Shift: Continuing the clean up on Pfaudler per clean out sheet.

#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: HOLD

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…Will confirm Celenese Trial start-up date during production meeting on Monday.
Afternoon Shift: On hold. No change.
Midnight shift:

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.