SOUTH PRODUCTION NOTES

April 22, 2014
Midnight Shift

BASF EMPLOYEES
40 Last Recordable
290 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(worked on and fixed on 1st shift4/21/14MV.), and for mixer outlet valve passing powder to pulva when powder is dropped from hopper.
Day shift: Waiting on repairs to extruder control panel, and still need maintenance to look at/address mixer outlet valve sealing issue (powder passing through to pulva). If these items are corrected, instructions are to make 4 batches using 2 lbs less acid in batch (Kristen should have entered this information in the MOD and also needs to discuss with oncoming CRTs).
Afternoon Shift: Maintenance working on discharge to mixer late on 2nd shift. We can start up after this is done.
Midnight shift:

#1 RC / AL-3992:

Calciner running
Day shift: Started back up. Continue to gather and weigh fines, and report these in the green sheet. Also, check-weigh the fines to verify scale integrity at #1 RC.
Afternoon Shift: Continued to feed until about 9pm and then ran out of feed. Getting a lot of fines. The engineer knows this.
Midnight shift:

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:
Afternoon Shift: On hold.
Midnight shift:

#2 RC/ Cu-0860:

Continue when material available.
Day shift: Out of feed
Afternoon shift:
Midnight shift:

Exhaust to F1

#3 MED line / D-0704:

Breaker repaired, continue batches.
Day shift: Line stopped, need to change out Vac-U-Max filter separator bags.
Afternoon Shift: Cartridges found and are being changed late on 2nd shift.
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. CTO operating normally. Move any calcined bags to 3rd floor as space permits.
Afternoon Shift: Continued feeding.
Midnight shift:

Exhaust to CTO

#4 RC / Selexorb:

Calciner temps brought down and reversed(M.V. 4/20)
Day shift: Down, hold. We will not need to clean as more Selexorb coming. When material is en route, fire up calciner again. We will also need to time this with Trimer usage between the other calciners (1, 5)
Afternoon Shift: On hold.
Midnight Shift:

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(no manpower)
Midnight Shift:

#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 1505
Afternoon shift: Continued on.
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: Finishing last clean-up items, putting screens in. Confer with Bodmann to verify what few things remain (general sweeping/debris removal around dryer and calciner, clean off scale, make sure everything closed up).
Afternoon shift: Final clean up and walkthrough just needed.
Midnight shift:

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: Down day shift (contractors)
Afternoon shift: No change.

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: Continue feeding as material available.
Afternoon Shift:
Midnight Shift:

Tower 3 / DPT-101:

Loaded and running.
Day shift: Hold for chiller tie-in
Afternoon shift: Tower fired up.
Midnight Shift:

Tower 6 / DPT-101:

Loaded and running.
Day shift: Hold for chiller tie-in
Afternoon shift: Tower fired up after compressor drive belt fell off and was fixed.
Midnight Shift:

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 ONLY when safe to screen. We are dismantling the south screener so no screening until the south is safely taken apart.
Afternoon Shift: On hold until we can get material removed from the South screener.
Midnight shift:

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: Screener feed arm separated from screener and tied-off … tote under nitrogen. Upper level of screener removed to begin airing-out (oxidizing) the contents of the screener. See Kristen Kaput for guidance to continue dismantling the rest of the screener so that the motor can be accessed and replaced.
Afternoon Shift: Need to remove the material from the screener into a fines drum and let it oxidize in the pole barn. Make sure this is done safely and be careful with the material as it could react while handling.

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: Continue with testing. Currently moving the half saggers located on the bottom of each stack to the top of each stack (per car).
Afternoon Shift: Continued switching saggers around.
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
Afternoon Shift: Continued on.
Midnight shift:

Old Pfaudler – cleaning for QAQ Trial:

Finishing cleaning
Day Shift: Continue setting up for QAQ trial. Need ready by Tuesday (follow cleaning sheet and contact Bodmann for details)
Afternoon Shift: Clean up continued. Just need to check vacuum.
Midnight Shift:

#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: Continue cleaning/re-tooling
Afternoon shift: No change.
Midnight shift:

#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:
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:
Midnight shift:

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.