SOUTH PRODUCTION NOTES

June 7, 2014
Midnight Shift

BASF EMPLOYEES
92 Last Recordable
342 Last Lost Time

#1 MED / ICL-8:

Keep in contact with Kristen as we do not want to get too far ahead of the calciner. Keep a close eye on diameters. Anything from .129" to .133" is ok but anything higher than .133" will prompt a die change on the extruder. Check the oil in reservoir.
Midnight shift:
Day shift: Valve was adjusted and we began making batches. Keep in contact with Kristen as we do not want to get too far ahead of the calciner.
Afternoon shift: Continuing making batches.

#1 RC / ICL-8:

Watch each drum for discoloration (tan) and isolate any of these drums for re feeding. If drum material looks all white, apply label and close. If material is tan, place label on top of drum for re-feeding (tape it so it does not get lost). Feed rate 400-425.
Midnight shift:
Day shift: Began feeding underfired drums. When these are done we need to raise the temperatures back to 490 and feed the material that is in bags coming off of the MED. Keep the feed rate below 425 to avoid creating more drums that need to be refired.
Afternoon Shift: All drums have been fed. Bringing temperatures back up to 490 then feed material coming off the extruder.

Exhaust to F1 for ICL-8

#2 MED line/ Cu-0860:

We will need to pull auger #13(tag on Mike's desk), clean it and return it to Calvin. Down until we get more 3818. Use the wet mix cart for cleaning out the barrel and add it back into the mixer. Do not over use the ice. One shovel full is plenty.
Midnight shift:
Day Shift: Decision made by the engineer late in the shift to change out the auger and the fines screen from an eleven mesh to a 10 mesh while we are down waiting for more 3818.
Afternoon Shift: No activity.

#2 RC/ Cu-0860:

Continue per the MOD. Keep the feed rate up on this calciner. It has been too low lately.Need the feed rate at 300 lbs / hr.
Midnight Shift:
Day shift: Continued to feed.
Afternoon shift: Continue to feed.

Exhaust to F1

#3 MED line / D-0713:

MED is about ready. Powder room scale issues resolve with OCS work performed on Thursday afternoon. Be sure to use the cart for wet mix and add it into the mixer. Do not use drums unless a bad batch needs to be drummed off.
Midnight Shift:
Day shift: Pulva chain being installed late on 1st shift. Should be able to start after this is done.
Afternoon Shift: Attempted to start line but recipe is missing its second step. Contacted engineer and restored the second step. Midnight shift to start MED line.

#3 RC / D 0713 next:

All material fed, calciner coming down for reversing and cleaning for D 0713
Midnight shift:
Day shift: Flush was finished . We will need to get this calciner set up as we do not want to get too far ahead of the calciner on the MED line.
Afternoon Shift: Screens have been changed and the screener has been washed down as well as the discharge chute.

Exhaust to Trimer

#4 RC / Finishing Cu-0360:

At end of run maintenance needs to take a look at the spiral elevator – it has become very loud with an exaggerated up and down motion (#934196920).
Midnight Shift: Have fed all of the fresh material. Will start reducing temps on calciner.
Day shift: Feeding the last of the rescreen bags. Just have what is left in the hopper.
Afternoon Shift: All material has been fed. The calciner is in auto shut down. Will need to reverse it and clean it with Al/Ox sand.

Exhaust to 4A DC

#5 RC / Cu-3818:

We will only use Phibrotech copper and the material will be discharged onto a 120 bag. Feed rate is at 14.0 hz.
Midnight shift:
Day shift: Continued to run.
Afternoon shift: Continue to run.

Exhaust to 5A DC

Old Pfaudler – D-0754:

In addition to the drainage sample we were collecting we must also collect a sample of each batch (8 oz baggy) and a sample of the solution tank. Make sure that all samples are properly labeled. Send to the lab for evaluation – this is a customer request let's make it happen with EVERY batch we make. Make sure that we add on the batch sheet any drainage collected and add to the label of the sample the batch number.
Midnight Shift: Continue.
Day Shift: No batch made (backed up).
Afternoon Shift: Made next batch.

#6 RC / D-0754:

Remember that we are to take a single large sample (not two, just one) per MOD and we need to collect a chemi sample that will be collected only during midnight shift. When running, be sure to:
(1) Get pallet and empty bag weight, write with marker on side of pallet and on check-weigh sheet. On pallet mark it "Tare * lbs; (2) Fill bag, record net weight on sheet and add to tare weight; (3) Take full bag and pallet to check scale and re-weigh. Record check-weight on sheet and record difference on sheet.**
Midnight shift:
Day Shift: Calciner relit with the help of an electrician. Feed was restarted in the early afternoon.
Afternoon shift: Continue.

Exhaust to Sly Scrubber

PK Blender / Na Selexorb Intermediate next:

Work order written to have the PK gear break looked at before end seals can be replaced(blender swings freely and does not stop quickly enough to control)(6/5/14 M.V.).
Midnight Shift:
Day shift: Work order written to have the PK gear break looked at before end seals can be replaced (blender swings freely and does not stop quickly enough to control).
Afternoon shift: Maintenance corrected the issue with the gear break. The seals can now be repaired.

New Pfaudler / Cu 0226-start on Next Tuesday :

Need cleaning instructions
Midnight shift: No activity
Day shift:
Afternoon Shift: No activity but the MOD is in the department.

Abbe Blender – D-5206:

We can run on the weekend and off shifts. 20 additional bags of 5202 can be found at dock #2 across from building 31.
Midnight shift: No activity as last batches made afternoon shift
Day shift: No change. 20 more bags of raws are due in Today.
Afternoon Shift: No activity. Personnel used elsewhere.

National Dryer / D-5206:

Feed as material becomes available.
Midnight Shift:
Day shift: No change.
Afternoon Shift: No activity.

Tower 3 /Cu-0860:

Loaded. Started running. Sheaves have been changed
Midnight Shift:
Day shift: Loaded and running. Another couple of days.
Afternoon shift: Running.

Tower 6 / 930 VAM:

Loaded and running. Each tower load will take 5 super sacks filled with 8 drums.
Midnight Shift:
Day shift: Loaded and cooking. Will need to be unloaded 1st thing on 2nd shift.
Afternoon shift: Unloaded and reloaded the next tower load of VAM.

Harrop Kiln – Al-4096 XL

Need to load AL saggers that are clean.

North Screener / DPT-101:

We need to double band all of the socks to the bins BEFORE OPENING ANY BINS – use the newly acquired adjustable quick disconnect hose clamps. Make sure that we hit the MOD rate.
Midnight shift:
Day shift: Continued to screen.
Afternoon Shift: Continue.

South Screener / Change over to Cu-0860:

We need to double band all of the socks to the bins BEFORE OPENING ANY BINS – we have now in place the newly acquired adjustable quick disconnect hose clamps . Make sure that we hit the rate required.
Midnight shift:
Day shift: On hold for first load of Cu-0860.
Afternoon Shift: On hold.

#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.
Midnight shift: No change
Day Shift: No change
Afternoon 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.
Midnight shift: No change
Day Shift: No change
Afternoon shift: No change

TK #2 Change over to V 2010:

We can use V 2010, AL saggers that are clean, or new saggers.
Midnight shift:

Day Shift: Kiln was shutdown. Ok was given late in the shift to begin changing over saggers for v 2010.
Afternoon shift: No activity.

At screeners: all totes need to have two bands fastened to sock before opening a new tote.
Work notification to place duct work hangers on the second floor (bldg. 31) – 934147915.