OPERATING INSTRUCTIONS

MONTAR TRANSFER

1. This assumes that the Montar transfer trailer is in place with about 2000 gal. of scrap material and the #2 still is circulating through the coil.

2. When it is time to transfer bottoms, suck the furnace coil as is normally done.

3. When finished, close the new valve on the bottom of the furnace and open the valve which allows circulation into the side nozzle of the still.

4. Connect the flexible line from the new pump to the bottom trailer nozzle and the flexible lines to the top of the trailer.

5. Line up the valves to circulate the trailer and start it circulating.

6. Turn the steam on the Venturi fume removal jet to start it operating.

7. When ready to transfer, go to the 2nd level and look at the two pressure gauges. The pressure on the Montar line has to be higher than the pressure on the scrap circulating line.

8. If these pressures are not right, the pressure in the Montar line can be raised by partially closing the valve on the still, side nozzle. The pressure on the scrap circulating line can be lowered by pinching back the valve in the scrap circulating line, but the preferred way is to raise the Montar pressure.

9. When the pressures are adjusted correctly, the valve from the Montar line to the mixer can be cracked open. Do not open this valve full at this time. The expected transfer rate is about 10% of level in 15 minutes.

10. Watch for a temperature rise on the mixer thermometer indicating Montar flow. Check to make sure the Montar pressure is still higher. Also watch the trailer top to make sure there are no leakage or foaming over problems.

11. Continue to monitor both the pressures and temperatures frequently to be sure the flow of Montar into the scrap of Montar continues. Should the Montar pressure fall off, pinch back on the side inlet valve to the still.

PCB-ARCH-EXT0374531

OPERATING INSTRUCTIONS

MONTAR TRANSFER
(contd.)

12. When the still level recorder shows a level of 10%, close the valve to stop Montar flow to the mixer.

13. Add residue from the residue tank to a 50% level in the #2 still.

14. Flush the Montar addition line to the mixer by opening the addition valve to the mixer for about 15 seconds. Close the valve.

15. Open the valve to the furnace and close the bypass valve. The still can then be put back in operation.

16. Shut down the scrap circulating pump and blow the line as clear as possible with an air line attached to the blow out connection on the bottom of the trailer.

17. Close the valve on the pump discharge and check to see the flexible line on the bottom is empty by opening the blow out at the pump suction. Use a bucket to catch the scrap.

18. Unhook the flexible line and hang it on the column hook.

19. Shut off the steam Venturi and unhook the flexible lines from the top of the trailer. Hang the hoses on the hooks and close up the trailer. The trailer can be taken to the incinerator.

POTENTIAL PROBLEMS AND CORRECTIVE ACTIONS

1. Trailer Foams Over -

   If the operator observes foam coming from the top of the trailer, immediately stop adding Montar. Continue to circulate the scrap. At this point dilute the still with residue and begin clean up. Modifications to the procedure may be necessary.

PCB-ARCH-EXT0374532

OPERATING INSTRUCTIONS

MONTAR TRANSFER

POTENTIAL PROBLEMS AND CORRECTIVE ACTIONS (contd.)

2. Montar will not flow due to:

   a. Line Pluggage

      With the Montar transfer valve closed, attempt to blow the line clean with steam. If it is open try to transfer Montar again. If it still won't flow, inform supervision and wait for instructions or assistance.

   b. Pressure on Montar Too Low

      This should occur only if the level has been reduced too far. If the pressure will not come up even with the valve to the still closed and you have considerable level, inform supervision.

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4/20/72

PCB-ARCH-EXT0374533