Ethanolamines/Glycol Ethers
Tier 3 Procedure

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Issue Number: 1. 3
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Title: Swapping Pumps In Vacuum Service
References: Glossary Of Equipment Identification (Text # 114)

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1710 Swapping Pumps In Vacuum Service

1.0 Objective:

1.1 To achieve a swap of bottom or overhead pumps in vacuum service without upsetting the process.

2.0 Resp nsibility:

2.1 It is the responsibility of the operations supervisor and the senior operations specialist to ensure that this procedure is fully complied with.

2.2 It is the responsibility of the senior operations specialist and the operations specialist to ensure that this procedure is executed in a safe and efficient manner.

3.0 Safety notation:

3.1 Monogoggles, must be worn to perform this task. If a flexhose is used then rubber gloves and a slicker top must be worn.

4.0 Special Notations:

4.1 Monitor discharge pressure closely during swap of pumps.

4.2 When filling off line pump with product always purge liquid into a bucket and dispose of in the appropriate crude tank.

4.3 Make sure flex hose has a double block and bleed arrangement.

4.4 All bottoms pumps can be filled by using the overhead sealflush line. Once these pumps are full, they can be started as called for in this procedure.

5.0 Procedure:

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5.1 Locate stainless steel flex hose to be used for this job and check for contamination. Make sure mcc switch gear for pump to be swapped to is energized.

5.2 With suction and discharge blocked in on pump to be put on line connect flex hose from discharge sample point on the on line pump to the suction bleed of the pump to be put on line.

5.3 When suction is open, slowly open the discharge block valve while slowly cutting back on the flow from the on line pump. (the bleed valve to the flex hose)

5.4 If new pump looks ok, block in the flex hose and then block in the suction and discharge on the original pump before shutting it down. check for good snuffing box pressure.

5.5 Bleed pressure and liquid from flex hose before disconnecting hose. Flush hose and store in proper location.

5.6 Clean work area.

5.7 Notify control room that pump swap is complete.

6.0 Revisions:

Revision #1	04-20-93	Yearly Review
Revision 2	12/23/95	Yearly Review
Revision 3	12-11-95	Yearly Review

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