

CW7

Interoffice Communication

To R. J. Andersen
From J. G. Dopper
Date July 28, 1980
Subject CertainTeed

The following are the transfer data for the transfer in July:

Transfer	Conoco	C.T.	Difference % of Conoco Volume
1.	441,398	434,640	(1.5)%
2.	327,987	318,790	(2.8)
3.	332,498	310,090	(6.7)
4.	431,366	347,320	(19.5)
5.	309,502	309,530	(0.01)
6.	406,055	327,370	(19.4)
7.	315,187	306,930	(2.6)
8.	322,050	322,340	0.1
9.	301,983	316,910	4.9
10.	392,930	328,440	(16.4)
11.	<u>310,101</u>	<u>312,340</u>	0.7
TOTAL	3,891,057	3,633,980	257,077 or 6.6%

1. The meter was calibrated.
2. If we take the 3 bad transfers out the difference would be about 1%.
3. I suggest, also for further study of the meter, that we make a complete list of transfer comparisons and record all the incidents, occasions, particular conditions, etc. to seek explanation for at least the big differences.
4. The general inaccuracies of a meter are believed to be ± 1-2%.
5. In the meantime, I suggest to take the weighted average as our billing numbers.

J. G. Dopper

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cc: JFS, JdB

CWH 000009456

Joe Ware



To SIS & CWT

Date 8-13-80

In talking to various people about the Certain-Teel transfer procedures I have found that we have several different line packing procedures in use which conform to the general transfer procedure but which differ from each other in some manner. I have put together a procedure which covers what I think most people are doing. Please review this procedure. If you are doing something different please write me a note so we can put together the best procedure possible.

Thanks, Joe

CWH 000009457

Certain-Teed Transfer Procedure

1. Certain-Teed will notify the VCM Plant that they desire a transfer of VCM. Transfers will normally be made on the evening shift or graveyard shift. No transfers of VCM to Certain-Teed will be made during ship or railcar loading.
2. Certain-Teed transfers will normally take place during a 5-7 day period each month. Therefore, whenever possible, isolate one sphere and dedicate it to Certain-Teed service during the transfer period.
3. The dedicated sphere will be circulated and sampled. Label the sample "Certain-Teed" and have copies of the analytical results distributed to the Shift Foreman, Traffic Coordinator, Process Superintendent and Operations Engineer. These analytical results are to be used until additional vinyl is added to the dedicated sphere. Analytical information will be transmitted to the Certain-Teed Operator on the "hot line" prior to the transfer.
4. The Certain-Teed valve in the refinery should be opened immediately prior to the transfer period and closed following completion of the 5-7 day transfer period and prior to any ship or barge loading. ~~Close~~ seal this valve in the closed position.

CWH 000009458

5. The VCM Plant will then make the proper valve adjustments to line up the dedicated sphere for a Certain-Teed transfer (i.e. isolate the railcar loading line and open up to the dock line).
6. Pack the dock / Certain-Teed line with one loading pump at high speed. Start the pump with the recirculation valve open to the dedicated sphere only. With the pump running close the recirculation valve and allow the pump discharge pressure to stabilize (min. 100 PSIG).
7. Shut down the loading pump after the transfer line ^{and leave the recirculation valve closed} is packed. The Shift Supervisor or Chief Operator will then take the start gauge (date, time, level, temp., pres.) in the same manner as is done during ship loading by the Inspector.
8. The Shift Supervisor and/or Chief Operator will calculate a stop gauge based on the quantity that the Certain-Teed Operator indicates he wants. This is an extra safety precaution to back-up Certain-Teed. Once the stop gauge is determined, the Certain-Teed Operator will be notified that he can begin his transfer from the CONOCO VCM Plant.
9. The valve at the Certain-Teed Plant will then be opened by the Certain-Teed Operator and the transfer started. Use only one pump for the Certain-Teed transfer.

10. The Certain-Teed Operator will monitor the level in their storage bullets. Each transfer will normally amount to 300,000 - 500,000 pounds.

11. The Certain-Teed Operator will then inform the VCM Plant when he is going to start closing the valve at the Certain-Teed end of the pipeline to stop the transfer. Certain-Teed personnel have been instructed to close their valve slowly to avoid overpressuring the system. The VCM Plant should contact Certain-Teed if the calculated stop gauge is reached and the Certain-Teed Operator has not terminated the transfer. The VCM Plant should terminate the transfer if there is any confusion.

12. Once the valve at Certain-Teed is closed, allow the transfer pump to continue running, with the recirculation valve closed, until the pump discharge pressure stabilizes.

13. The pump can then be shut and with the recirculation valve still closed, the Shift Supervisor or Chief Operator can take the stop gauge (date, time, level, temp, press.)

14. In between Certain-Teed transfers and during any given monthly Certain-Teed transfer period (5-7 days) the dock / Certain-Teed line should be floated at the dedicated sphere only.

CWH 000009460

15. Certain Teed transfer information should be sent to the Traffic Coordinator.

CWH 000009461