

DATE: 3/8/81

SOP23

FILE: SOP23TRN.HSU

Trans Heavies Still Startup

Before the startup of the trans Heavies Still can proceed, the entire TCE section must be shut down and pumped empty. The Trans Stripper must then be started up to provide feed for the Heavies Still. Check the proper SOP's and checklists for the procedures.

1. PUT THE HEAVIES STILL PCV ON AUTOMATIC AND MOVE THE SET POINT TO LESS THAN 1 PSIG. BLOCK IN THE NITROGEN MAKEUP VALVE. This will depressurize the column to a safe startup pressure.
2. AFTER VERIFYING THAT THE TRANS STRIPPER BOTTOMS IS IN SPEC, PUT THE STRIPPER BOTTOMS FORWARD TO THE TRANS HEAVIES STILL. The control room GC should be used to verify that the VDC concentration is below 25 ppm in the Stripper Bottoms.
3. AFTER THE STILL POT LEVEL HAS REACHED AT LEAST 50 %, START A SMALL STEAM FLOW TO THE HEAVIES STILL REBOILER. A slow heatup will avoid rapid pressurization and the loss of reboiler level.
4. MONITOR THE POT LEVEL CLOSELY. SHOULD THE POT FILL SO THAT THE LEVEL IS ABOVE THE FLOAT CHAMBER RANGE, SHUT OFF THE STRIPPER BOTTOMS UNTIL BOILUP BEGINS AND THE LEVEL IS KNOWN.
5. AFTER BOILUP IS ACHIEVED, STEAM CAN BE ADDED OR CUT TO MAINTAIN THE LEVEL IN THE REBOILER. Continue to monitor the pot level and adjust as necessary. Monitor the pressure on the column. If necessary, cut steam an feed to keep the pressure below 10 psig.
6. MONITOR THE HEAVIES STILL REFLUX DRUM LEVEL. WHEN THE LEVEL BEGINS TO RISE, BEGIN RAISING THE PRESSURE CONTROL SET POINT. The steam may have to be increased to compensate for the pressure increase.
7. ESTABLISH A REFLUX FLOW ONCE A 50 % LEVEL IS ESTABLISHED IN THE REFLUX TANK. This flow should be small at first (less than 20 gpm), but can be increased as the reflux drum level increases.
8. START THE HEAVIES STILL BOTTOMS PUMP AND ESTABLISH BOTTOMS RECIRCULATION. This is to be able to catch a representative sample of the bottoms for GC analysis. RUN A G.C. ON THE HEAVIES STILL BOTTOMS. START A BOTTOMS PURGE TO THE BOTTOMS PLANT IF LITTLE OR NO CIS OR TRANS IS PRESENT.
9. CONTINUE TO RAISE TEMPERATURE, PRESSURE, AND REFLUX UNTIL NORMAL OPERATING CONDITIONS ARE REACHED.
10. SAMPLE THE HEAVIES STILL BOTTOMS EVERY FOURS HOURS. BEGIN ADDING AIBN WHEN THE CIS IS ABOVE 20 %. INCREASE OPERATING TEMPERATURE IF TRANS IN THE BOTTOMS IS ABOVE 2%

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- _11. SAMPLE THE HEAVIES STILL REFLUX. PUT THE TRANS SECTION ON RECYCLE IF THE VDC IN THE REFLUX DRUM IS ABOVE 100 PPM.
- _12. PUT THE TRANS PRODUCTION FORWARD TO THE INTERMEDIATE STORAGE TANK WHEN THE REFLUX DRUM IS IN SPEC FOR TWO CONSECUTIVE SAMPLINGS.

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