

#1 TRI STILL

I WE HAVE CHANGED CONTROLS ON THE #1 TRI STILL AS FOLLOWS:

① THE STEAM WILL NO LONGER BE USED TO CONTROL TEMP.

STEAM IS ON THE RIGHT (OPPOSITE TO LEFT) CONTROLLER. SINCE THERE IS LITTLE PRESSURE CHANGE IN THE STEAM, RUN THE CONTROL ON MANUAL. STEAM FLOW INDICATION IS ON THE GREEN PEN NEXT TO THIS CONTROLLER. (0-10000 DPH.)

② THE REFLUX IS CONTROLLED BY THE REFLUX DRUM LEVEL CONTROLLER (THIS IS THE OLD RECYCLE CONTROLLER). REFLUX WILL BE AUTO CONTROLLED BY THE LEVEL IN THE REFLUX DRUM. RUN THIS ON AUTO.

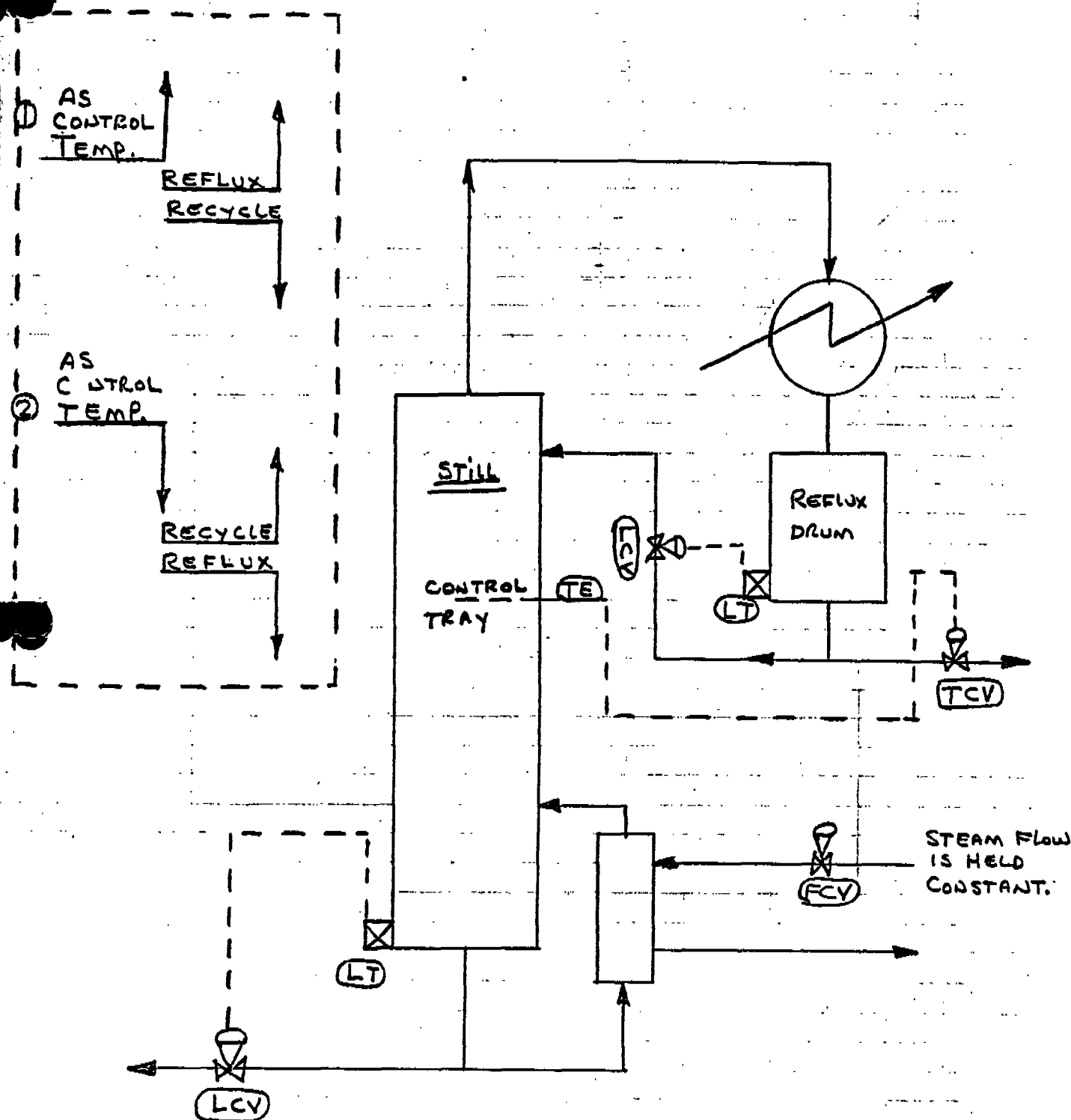
③ REFLUX FLOW INDICATION IS THE SAME.

④ THE RECYCLE IS CONTROLLED BY TEMP OF THE CONTROL TRAY. THE TEMP IS IN THE SAME PLACE, BUT THE RECYCLE ^{FLOW} IS WHERE THE OLD STEAM FLOW USE TO BE. WHEN CONTROL TEMP DROPS, THE RECYCLE WILL INCREASE, AND VISA VERBA. RUN ON AUTO.

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Subject to Protective Order
of 14th Judicial District Court
No. 91-1145

SL 020153

MATERIAL BALANCE CONTROL



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8/24/74

S.O.P. GUIDELINES FOR STILLS

1. P/T STILL

TCE IN OUHD - ^{NIL - .02}
~~.015 - .020~~

2. TRI STILLS

CCl₄ IN BOTTOMS @ .010 - .020%

EDC IN BOTTOMS @ NIL - .010%

IF EDC IN UPPER RANGE,
DROP P/T OUHD TO LOWER RANGE

TRI IN OUHD. @ ~~120%~~ < 1%

3. HEAVY STILL

UNSYM IN OUHD ^{.06 - .07}
~~.05 - .06~~ %

4. PER STILLS

TCE IN BOTTOMS @ ^{NIL - .02}
~~.015 - .020~~ %

PER IN OUHD @ ~~60%~~ 60% → 70%

IMMEDIATELY
RUN OUHD COMP. ON AUTOLAB IF:

1. #1 TRI RECYCLE IS 3 GPM OR MORE
2. #2 " " " 4 " " "
3. #1 PER " " 1 " " "
4. #2 " " " 3 " " "

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SOP #1 PER STILL

FEED: 0-9 GPM DO NOT RUN OVER 9 GPM
9 GPM = ~ 87 TPD.

STEAM: VARIES W/ FEED. @ 9 GPM $\approx$ 2000 MM

REFLUX: VARIES W/ COMPOSITION OF OVHD & BOTTOM

RECYCLE: VARIES W/ OVHD COMPOSITION.

BOTTOMS COMPOSITION:

TCE - CONTROLLING FACTOR ON STILL
CONCENTRATION OF TCE SHOULD BE
0.03 - 0.04 %. BOTTOMS SAMPLE SHOULD
BE RUN ON STILL LINE GC TWICE (2)
PER SHIFT TO DETERMINE OPERATING
CONDITIONS.

OVERHEAD COMPOSITION:

PERCHLOR - CONTROLLING FACTOR
IF PER $>$ 50% DECREASE RECYCLE
& INCREASE REFLUX.

IF PER $\leq$ 50% INCREASE OR HOLD SAME
ON RECYCLE, DEPENDING ON INCREASING
OR DECREASING LEVEL IN REFLUX DRUM.

CONTROL TEMP:

TEMP @ TRAY #48 SHOULD BE @
255 - 260 °F W/ BOTTOMS PRESSURE ~10-12#
BOTTOMS TEMP @ 10-12 PSI 278 - 284 °F.

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STANDARD OPERATING PROCEDURES FOR SAMPLES

A review of samples, work load, etc., indicates the following procedures should be tried and will be assigned until conditions change.

1. Auxiliary will catch and run the first set of samples. He is to report any out-of-spec samples immediately to the Lead Operator.
2. All Operators are responsible to check results to-determine status of operations and potential changes to be made.
3. The Auxiliary will catch the second set of samples. The Reactor Operator and Still Operator are to run the samples and record results.
4. Whenever changes in operations have been made, each Operator will catch and run appropriate sample to determine results of change.
5. Operators should catch and run extra samples whenever necessary to determine status of operations.
- 6. Lead Operator has at his discretion the authority to modify the above and request whoever has the time to run samples. If Reactor Operator and/or Still Operator is busy, the Auxiliary can run second set or special samples; otherwise each operator is to run his samples.

Hopefully, this procedure will accomplish the desired goals. If not, they can be modified. With the Auxiliary catching and running the first set, the Operators can get their first set of rounds made and determine what needs to be done. As changes are made, the Operator can catch his sample and get own result without waiting on Auxiliary. Operator can apply his choice of which sample needs to be run first. Finally, this should allow Auxiliary to get to other jobs which are needed.

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Walter L. Oglesby

cc: R. P. Lynch
Shift Engineers

NOTE:

IT IS NOT NECESSARY TO RUN 2 SETS OF REACTOR CAUDES EACH SHIFT, UNLESS LO. OR R. OPERATOR SEE A NEED FOR A FOLLOW UP TO BE RUN. THIS ALLOWS TIME FOR STILL CONTROL SAMPLES TO BE RUN, WHICH ARE ALSO IMPORTANT TO REACTOR OPERATIONS. HOWEVER, KEEP THE AUTO LAB BUSY EVERY MINUTE. ALL SAMPLES ARE HELPFUL IN FINDING PROBLEMS. A SECOND SET OF R. CAUDES WILL

D.R. Munn