

DEER PARK MANUFACTURING COMPLEX - REFINERY
HEALTH & SAFETY COMMITTEE MEETING
AUGUST 29, 1974

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MEMBERS

F. M. Dishaw*
H. J. Krebs*
R. D. Madsen*
T. A. Skeahan*
E. G. Suhr
R. L. Bryan*

ALTERNATES

J. W. Burks*
Dorothy Curlee
L. E. Jackson
R. L. Wege
J. B. Floyd

*Present at meeting

OLD BUSINESS

1. As requested, speed limit signs have been posted in the refinery and a safety handout is approved for giving to drivers entering the refinery.
2. The entire LOFU area was inspected by Engineering Services in March, 1974. Recommended repairs are underway.
3. The recommended repaving of the east employee parking lot is scheduled to begin September 3, 1974.
4. Unit inspection status reports were given to the Committee for the Marine docks, LOFU, Lube C, and power plant No. 2.
5. The following locations in the refinery have sanitary napkin dispensers: Refinery Laboratory, Clock House, Engineering Field Office, U.C.C., Lube Department and Research. A dispenser is to be installed in the west zone building.
6. The requested plumbing repairs have been completed in the ladies change house.
7. Portable radios are available in Engineering Field for all types of maintenance work (Recommendation 6-3 and 7-4).
8. Departmental work permits for Main Office Annex and the Clock House are issued by Personnel Department. Treasury Department personnel issue permits for the Cafeteria and Main Office.
9. A request was made to include the process unit trucks on the weekend safety check list (brakes, horn, wipers, glass, etc.).

NEW BUSINESS

1. As requested, Mr. D. H. McClintic, Manager Employee Relations, met with the Committee for one hour. The role anticipated for the Medical Director

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of the Deer Park Manufacturing Complex was discussed. Mr. McClintic also stated that an Industrial Hygienist will be hired for the Complex. More details will be forthcoming as progress is made in these areas.

The hourly members of the Committee had prepared a letter which was read for the benefit of the group. Mr. McClintic did not address each point raised in the letter; however, several of the items were discussed. A more comprehensive verbal reply will be made at the next meeting.

The salient points of the letter were as follows:

- a. Disappointment was expressed due to the Committee not being involved in the accident investigation involving the fatality of an employee working in close proximity of a power line. Also, concern was stated because a special Committee meeting was not called for discussing the accident.
- b. Other items of concern were the posting of the minutes of the Committee on the bulletin boards for involving all employees; an employee health and safety request form; outstanding health and safety requests should be addressed without undue delay; and Operations & Safety should routinely concentrate on correcting deficiencies in operating areas due to the one or two year cycle of inspections by the Committee.

Other topics of discussion not covered in the letter, related to the carpenter shop dust problem, tank water draw procedures in the Dispatching Department, and the use of an inspection check-off form.

The following items were discussed following Mr. McClintic's departure:

2. July safety statistics: 302 reported first aid cases, 18 doctor cases, one disabling injury and one fatality due to operating a crane in close proximity of a high voltage power line.
3. The fatality resulting from a crane operating under high voltage power lines was discussed in detail. Several questions were raised relating to the equipment and location of the accident.
4. The following suggestions relating to Aromatics-East were submitted by various members of the Committee:
 - ✓ a. Install an exhaust system with a 20-foot stack for removing vapors in the PXU Analyzer Building.
 - ✓ b. Install a closed pump bleeder header for the entire PXU in order to keep xylene vapors from being emitted from the inadequate draining sewer system.
 - c. The GC4 machine in the laboratory room uses hydrogen and air to propagate a flame. If the flame goes out, would the fuel escaping be enough to cause concern. The reference cell is exhausting 44 ml/min of helium and the T.C. column is exhausting 62 ml/min of helium as measured by the rotometer. It was expressed that the instrument should be moved outside in order to preclude breathing polluted or oxygen deficient air.
 - ✓ d. Request more frequent test of xylene vapors at the PXU area by the Safety Department. The results should be posted in the control room.

- e. The receiver house-fire extinguishers should be placed on brackets, shelves or in a cabinet.
 - f. The following vessels need platforms and ladders so the operators can safely operate valves: V-1259 (recycle intermediate storage), and V-1243 (C₃ dry gas storage), and V-1257 (melt intermediate storage).
 - g. The 200-lb. steam block valve on the northeast corner of the elevated south plot edge manifold needs to be repaired and a platform and ladder should be installed so the valve will not have to be closed by standing on top of piping with a large valve wrench and "cheater". Otherwise, the valve should be relocated.
 - h. Circuit breakers should be operated as described in the safety manual on p. 18, par. 4. High voltage breakers that have to be engaged with an elevating type mechanism are of great concern to the operators. A qualified electrician should engage these breakers.
 - ✓ i. The leaking equipment should be repaired at the PXU for reducing xylylene vapors. The odor is very strong in the pump area between P-4425 and P-4427, and also on the second stage centrifuge structure.
 - j. The platformer No. 2 steam drum sight glass breaks frequently. Safety concern was expressed due to the possibility of burns by the 650-lb. steam.
 - ✓ k. The H₂S leaks at HDU-1 should be repaired, especially around V-462.
5. The electric procedures were discussed.
 6. The repaired roof leak in the main shop electric area was reported to be leaking again.
 - ✓ 7. Bad H₂S odors were reported in the C.P. stabilizer compressor shed. The valve in the maintenance room has a bad handle, and the instrument tubing conduit opening to the control room is not sealed.
 - ✓ 8. Concern was expressed regarding the MEK odor in the chiller area. Continuous monitors were requested for the filter area.
 9. Thirteen or more lights are burned out in the main shop.
 10. A better system was requested for connecting chlorine cylinders at cooling towers Nos. 3 and 4.
 11. A request was made to issue sufficient Shell-Tox for killing wasp, etc., for maintenance work.
 12. Are the alky plant-York unit structure repairs progressing.
 13. Appropriate markings have not been placed around the main shop circuit breakers.

14. The change house shower heads do not have proper water temperature controls and several shower heads are missing.
15. The newly installed caged ladder is very close to the electric cable tray at the N.E. corner of the gas recovery fractionator area.
16. The (reported corroded) fuel gas header at the mol sieve has not been repaired.
17. A request was made to install larger platforms at the power plant No. 2 water treater for removing or changing the screens.
18. The Gaskin employees should be instructed to check with operations on jobs carrying over on the next shift. The contractor employees at times are not suitably attired and hearing protective devices are not supplied.
19. All refinery employees should comply with safety requirements concerning proper clothing, shoes, hard hats, etc.
- ✓ 20. A report was requested concerning the request made in the January meeting for installing a phenol vapor removal system at the Lube Department - phenol unit.
21. A request was made as to why the helium cylinder pressure relieved at the mol sieve unit on August 20, 1974.
22. A status report was requested for the Aromatics-East inspection.

Prior to the business meeting, the Committee inspected DU-2 in the Distilling Department. The following inspection items were noted for consideration:

SAFETY ITEMS

1. The top section of an extension ladder had been used by the crafts south of the analyzer building. Further, the ladder was not tied off at the top.
2. Rack the wash hose throughout the unit.
3. Remove the broken sample bottles at the sample box, crude column and the C.W. inlet header at south plot edge.
4. Relocate the gas cylinder under E-5108.
5. The storm sewer covers should have the debris removed for maximum surface water drainage.
6. The fan in the control room storage room requires a guard with no greater than 1/2-inch mesh.
7. Replace the defective roller ladder platform by P-5119.

8. Replace the steam lance by V-5114.
9. The elevated piping is a tripping hazard at P-5113 and E-5131-A. The hose should be racked at P-5113.
10. A portable fan is improperly guarded on the west side of the DIH column.
11. The trash cans should have covers.
12. The oily scaffold boards should not be used on the HFT exchangers.
13. The road barricade markers being used by the electricians' aerial lift were not adequate. Indicated that Safety Department did not have any more.
14. The lower working platforms under the air coolers do not appear adequate for escape purposes in case of a hydrocarbon leak or fire. Further, the platforms are not adequate for performing routine maintenance on the motor driver which must be removed. A monorail should be installed for safely moving motors, etc. to the north end of the exchange train. Remove the miscellaneous debris on the platforms under the exchanger banks.
15. Remove the top section of an extension ladder near air cooler E-5134-C.
16. A guard should be placed where the 3-inch lines come through the grating at E-5101-A.
17. Aluminum ladders are not to be used for changing lights, etc. Fiber glass or wooden ladders should be provided.
18. Many of the elevated walkways are obstructed and several platforms do not have chain guards.
19. The steam hose and lance should be replaced by P-5118 and replace the lance by P-5152. Also repair lance at V-5114.
20. Properly secure the freon bottle by the control room at the NE corner.
21. The vibrating lines should be secured on the crude furnaces. (Note: Job scheduled by Engineering for September 3, 1974).
22. Provide a rack for the wash hose at the base of V-5212.
23. Check the odor at the sewer by P-5103 (and around P-5152).
24. Replace the steam hose north of V-5117.
25. The hot recycle pump by DP-5125 is emitting vapors.
26. The portable ladder has a broken step south of E-5103.
27. Remove the ladder from the walkway at the west end of E-5134-D.
28. The 2-inch drain line from E-5126 should be relocated or removed to eliminate a tripping hazard.

29. Relocate the fire extinguisher south of the pitch system and replace the door.

✓ 30. The atmospheric PRVs release sour material.

31. Revise the small diameter pipe assemblies on the east and west ends of E-5124-F and G. The piping projects into the walkway.

32. Remove the temporary drain line by P-5158.

33. Remove the loose aluminum in piperack above P-5105.

34. Remove or reroute 2-inch drain from the bottom of V-5110.

35. The compressed gas bottle by the HDU heater needs a permanent bottle holder.

36. The air cooler fan guards do not conform to code.

37. The adequacy of the number of safety showers should be evaluated.

✓ 38. Gas odor on the east side of the road by the electric room and the east side of E-5106-B.

39. The fire hose is greasy by P-5127.

40. A ladder has no safety shoes by P-5040.

41. The steam hose should be replaced west of P-5117.

42. Identify the fire hose NW of X-5102.

43. Check the inspection dates of the fire extinguishers.

44. Color code or identify piping at the utility stations.

ELECTRICAL

1. The light fixture has fallen over on the top platform between the crude furnaces.

2. The terminal blocks and wiring should be covered behind the control panel.

3. Check the grounding of the air conditioner, electric water heater and the teletype machine.

4. The air conditioner electrical equipment appears to be uncovered on top the control room.

LEAKS AND SPILLS

1. Steam line leaking at the west side of the DIH column.

2. Clean up the drip pan and oily area next to V-5107.

LAM 030105

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3. Water leaking from coolers over pumps P-5127 and P-5154. Should be piped to grade.
4. The heavy oil/crude exchangers appear to have excessive leaks.
5. Leaking valves around E-5105A.

HOUSEKEEPING

1. Clean the laboratory bench and floor.
2. Remove pallet south of control room.
3. Remove scrap pipe etc. at SS-343 and SS-341 and SS-348 and east of P-5103.
4. Remove old conduit in the electric room.
5. Clean the area north of the recycle compressor.
6. Remove the roll of asphalt felt by E-5120-D.
7. The slab is oily by E-5108 and around SS-381.
8. Remove the trash under E-5106-D and E-5126-B.
9. Remove the insulation south of E-5102-B.
10. Remove the scaffolding and other debris by the lugger pan south of the vacuum column.
11. Oil on slab under PIC-718.
12. The trash should be removed from the analyzer building.
13. The slab is oily along the heater manifold and some of the steps are oily.
14. Remove the board attached to the rail on the south end of the south vacuum heater.
15. The HFT exchangers, etc. slab area is excessively oily on the west side of the unit.
16. The scaffolding not in use should be removed.
17. Remove the scrap tubing and wire behind the control room panel boards.
18. Remove the loose insulation on the platform at the S.W. corner of the north flasher furnace.
19. Remove scaffold above V-5113.
20. Clean the wash basin in the control room.

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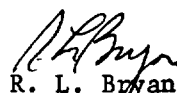
21. Remove the loose insulation on the column platform located south of the crude column.
22. Clean up the work area in the control room maintenance and storage room.
23. Remove oil/pitch, etc. from around P-5172, P-5161 and P-5126.

MISCELLANEOUS

1. Repaint the fire water block valve manifolds on the high volume water sprays.
2. The large butane vessel at the south end of the unit does not appear to have a pressure relief valve. Are the inspection records up to date, and the associated piping properly guarded?
3. The insulation cover is loose on the line to E-5102-B.
4. Replace the trash can in the restroom. Plastic liners should be used.
5. There is thermocouple wiring strung over the piping over E-5107, etc.
6. The door is off the analyzer building.
7. Inspect the armored flexible hose on the desulfurizer heater fuel gas system.
8. Inspect the corroded bolts on the fuel gas manifold at CV-148. Replace or paint.
9. The hydrogen compressor discharge piping should be inspected for vibration.
10. The instrument and piping on FI-1088 is vibrating excessively.
11. Replace the water hose supplying AR-141/142 with permanent piping.
12. Repair the north door handle in the electric room.
13. The analyzer building wiring should be in conduit and any open conduit should be sealed off.
14. The nitrogen hose should have a rack at the SE corner of the control room.
15. The pump should be covered on the B.P. analyzer.
16. Secure the acid injection piping west of P-5102 and 5103.
17. The shoes and hard hats on top of the slant-top lockers could fall off.
18. Are proper instructions given for taking hot pitch samples. Reported to ignite at time and water causes the material to spatter. Some type of cooler should be devised.

19. The boiler inspection permit on Y-5119 is possibly out of date.
20. The large can of grease in the maintenance room should be housed outside.
21. A bicycle rack should be located at the south door of the control room.
22. The Prestolite bottle should be located outside of the laboratory room.
23. The valve wheel is broken on E-5129-A.
24. The fixed ladder cage guard is bent at the SW corner of the unit.
25. Wooden scaffold above V-5113.
26. The sample station needs repairs east of P-5164.

PLAN FOR SAFETY


R. L. Bryan

cc: Head Office

- Manufacturing Engineering
- Department of Safety & Health Manager

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