

Ethanolamines/Glycol Ethers

Tier 3 Procedure

Section Number: 33
Issue Number: 2.1
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Title: Catalyst Mix D-105/107
References: Glossary Of Equipment Identification (Text # 114)

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33. Catalyst Mix D-105/107

1.0 Objective:

1.1 To ensure that the process of mixing catalyst in D-105 and D-107 is done in a safe manner and to further ensure that the finished product after mixing meets the required specifications of the glycol ethers system.

2.0 Responsibility:

2.1 It is the responsibility of the operations personnel to ensure that this procedure is fully complied with and executed in a safe and efficient manner.

3.0 Special notations:

3.1 D-105 and D-107 are both catalyst mix tanks. However they are independently designated to a specific glycol ethers series. D-105 is for "EB" series and to be filled (65% level) with EB and D-107 is for "PM" series and to be filled with DPM (55% level).

3.2 While the tanks are filling, they must be monitored at all times.

3.3 In the event the roll clamp is not available there is a manual drum dumper that can be used. Make sure that the drum is secured by the chain. It maybe necessary to block rear tires due to incline at tanks. The dump shoot will not be able to be used. The lid must be lifted in order to do this task, this is a hydraulic lift tool, take notice of leaks when pumping drum into place.

4.0 Safety notations:

4.1 Safety toe shoes, rubber gloves, dust mask and monogoggles are required to perform this job.

5.0 Procedure:

5.1 Determine the need to mix catalyst by checking the feed tank level (D-106A for "PM" series and D-106B for "EB" series) or by request of the board operator.

5.2 With the power switch "off" try to reset trip solenoid, it should not reset and product inlet valve should be "closed". Turn power "on", set pneumatic set point to 25% and reset solenoid, check product inlet valve to be sure it is "open". Turn power switch "off", solenoid should trip and product inlet valve "close". Turn power back "on" reset solenoid, slowly lower pneumatic set point until solenoid trips and closes product inlet valve. Reset the pneumatic set point according to check sheet. Note: Both pneumatic set point and high level switch trips the solenoid thus closing the product inlet valve.

5.3 Select product from storage depending on series and start filling the proper mix tank. Check the level set point from the check sheet and set the drum trip setpoint. (DV-136 DPM and DV-126 EB) note: It is necessary to have overhead and wall fans on to minimize vapor and KOH dust.

5.4 Make sure all valving is properly aligned on D-105/107 then start P-105 or P-107 and agitator to circulate the tank. Visibly check agitator coupling to insure agitator is turning. Drum level should be 55% in D-107 ("P" Series) and 65% in D-105 ("E" Series).

5.5 Install dump cone onto a KOH drum making sure iris valve on cone is closed. Using roll clamp tow motor set drum on top of dump shoot. Note: be careful not to let the entire weight of the drum rest on the cone. This makes the iris valve difficult to open and damage to the cone may result.

5.6 Open iris valve about 1/3 and hook up air hose to vibrator on the cone and start air.

5.7 After dumping is complete, remove drum and check shoot slide for build-up. If there is a build-up use the metal probe to push KOH down the chute into the drum.

5.8 Circulate tank for one hour prior to transfer.

5.9 At the board operators request pump catalyst mix over to the proper tank. When transfer is complete check for proper alignment of valving on D-105/107.

5.10 Fax order sheet to the raw material coordinator when inventory is 25 drums.

6.0 Revisions:

Revision 1	1/15/98	Revised 2.1 and 5.10 Deleted 2.2
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