

Ethanolamines/Glycol Ethers

Tier 3 Procedure

Section Number: 1706
Issue Number: 1.5
Original Date: 11-11-91 **Author:** Michael Viator
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Title: Leak Checking Distillation Towers
References: Glossary For Equipment Identification (Text # 114)

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1706 Leak Checking Distillation Towers

1.0 Objective:

- 1.1 To determine, by pulling a full vacuum, the leak rate of any given distillation tower.
- 1.2 To ensure that on startup no air is introduced into any tower affecting product quality.

2.0 Responsibility:

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

3.0 Special Notation:

- 3.1 EJ-180/280 will pull all towers onto the control charts except the following:

3.1.1 T-140 = 0 - 50 scale

3.1.2 T-250 = 0 - 50 scale

3.1.3 T-260 = 0 - 15 scale

3.1.4 T-271 = 0 - 10 scale

4.0 Procedure:

- 4.1 Close all lines to and from tower. This includes suction to pumps, sample points, check tanks, and control loops.
- 4.2 Put ej180 / 280 on tower and pull down to lowest vacuum. If the pressure does not come onto the control chart, place the tower on it's ejector until a full vacuum is obtained.
- 4.3 After pressure has lined out for 30 minutes, isolate tower from ejector and record beginning time and pressure.

4.4 Wait about 15 to 30 minutes and record ending time and pressure.

4.5 Input recorded information into GPI site-specific operator menu to find if the tower has an acceptable leak rate.

5.0 Revisions:

Revision #1	04-19-93	Yearly Review
Revision #2	12-23-94	Yearly Review
Revision #3	12-11-95	Yearly Review
Revision #4	01-27-98	Revised 2.1, 2.2, 4.5
Revision #5	03-19-98	Revised 2.1 Deleted 2.2