

Ethanolamines/Glycol Ethers

Tier 3 Procedure

Section Number: 1118
Issue Number: 1.4
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Revision Date: 12-13-95
Title: Loss Of P-104's
References: Glossary Of Equipment Identification (Text # 114)

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1118.Loss Of P-104's

1.0 Objective:

- 1.1 To provide a guide to the actions that should be taken in the event that we lose the on line P-104 and the spare will not start up or the spare is out of service for maintenance. To perform this task in an environmentally sound and efficient manner.

2.0 Responsibility:

- 2.1 It is the responsibility of the operations supervisor and the senior operations specialist to ensure that this procedure is understood and utilized in the event of such an emergency.
- 2.2 It is the responsibility of the senior operations specialist and the operations specialist to ensure that this procedure is executed in a safe and efficient manner.

3.0 Special Notations:

- 3.1 Emergency procedures are written with the intention of having in black and white what procedure should be followed under ideal circumstances. They do not take the place of common sense. If there is a fire, we have a fire department to handle it. Don't tackle something that could injure you because you don't have the experience or training to handle it. Small fires in trash cans or some insulation fires can be handled by most of us. Don't wind up aking the problem worst by getting hurt or rushing in and doing the wrong thing. The same thing applies to spills and other emergencies.

-----use common sense-----

- 3.2 If the plant will be down for an extended period of time the oxide line will have to be isolated, nitrogen purged, nitrogen padded and red tagged.

4.0 Procedure:

- 4.1 Lead senior operations specialist actions:

- 4.1.1 Direct board person to trip glycol ethers oxide system. (P-104 shutdown should shutdown this system, but verify anyway)
- 4.1.2 Keep finishing end running. (if possible)
- 4.1.3 Attempt to get the P-104 restarted.
- 4.1.4 Call Glycol 1 or Glycol 2.
- 4.2 Senior operations specialist (board person):
 - 4.2.1 Announce (on plant intercom) that the P-104 has tripped.
 - 4.2.2 Trip glycol ethers oxide system, if not already tripped.
 - 4.2.3 Switch T-110 bottoms to DV-113/114. If feed is not available put finishing towers on total reflux.
 - 4.2.4 Block in T-110 forward flow, block in catalyst and acid flows, stop any recycle flows to P-104 suction.
 - 4.2.5 Fully open FIC-1193 (control valve) to D-510, maintain shell pressures. Reduce 235 pound steam to E-110.
 - 4.2.6 Watch reactor and column temperatures close.
 - 4.2.7 Direct actions of outside operators.
 - 4.2.8 Manually block alcohol makeup control valve in control room (to DV-104 on PM series).
- 4.3 Operations specialist actions:
 - 4.3.1 Block in final oxide feed valve to R-101.
 - 4.3.2 Block in big steam block valve from R-101/102 to E-110.
 - 4.3.3 Switch T-110 bottoms to DV-113/114.
 - 4.3.4 Block in T-110 forward flow and shut down and block in discharge of bottoms pumps.
 - 4.3.5 Manually block alcohol emergency block valve at E-102.
 - 4.3.6 Call control room for further instructions.
 - 4.3.7 Swap T-120 (or T-115 is on high pm series), T-130 and Tt-140 over heads to empty tanks.

4.3.8 Block in recycle flows to P-104 suction and shutdown pumps used for this purpose.

Revisions

vision No. 1	06-30-92	Changed section 1118.1.1 to reflect environmental concerns.	Re
Revision No. 2	07-14-93	Yearly Review	
vision No. 3	12-22-94	Yearly review	Re
Revision 4	12-13-95	Yearly review	