

Ethanolamines/Glycol Ethers

Tier 3 Procedure

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Title :Mixing Triethanolamines Eighty Five (T-85) In Check Tanks
References :Glossary Of Equipment Identification (Text #114)

230 Mixing Triethanolamines Eighty Five (T-85) In Check Tanks

1.0 Objective:

1.1 This procedure allows the operator to mix diethanolamines (dea) and triethanolamines (tea) in the check tanks to make T-85 one batch at a time.

2.0 Responsibility:

2.1 It is the responsibility of the operations supervisor and then senior operations specialist to ensure that this procedure is fully complied with.

2.2 It is the responsibility of the senior operations specialist and the operation specialist to ensure that this procedure is executed in a safe and efficient manner.

3.0 Rerun Header Flushing Procedure:

3.1 Line up DV-262A/B to DV-243A through the rerun header.

3.2 By coordination between the outside operator and the board operator pump approximately 500 pounds of dea to DV-243A.

3.3 Line up DV-272A/B to DV-243A and repeat process as stated in 14.3.2 but from DV-272A/B to DV-243A.

4.0 Special Notation:

4.1 The flushing procedure may not be necessary if it is known that the rerun header last contained dea or tea.

4.2 Note: After T-85 is pumped to 85 tank or loading the 272A/B check tank must be flushed with good T-99 and check tank line must be flushed to 277/278 to clear line.

5.0 Mixing Procedure:

5.1 Swap T-271 overheads when the level in DV-272A/B reaches 107,000 pounds.

5.2 Line up DV-262 A/B to DV-272 A/B through the rerun header.

5.3 By coordination between the outside operator and the board operator pump approximately 13,000 pounds of dea to DV-272 A/B to bring the level up to 120,000 pounds. (this must be done slowly to avoid over-shooting the amount of dea needed)

5.4 Put DV-272 A/B on recirculation for a minimum of one hour and analyze the tank.

5.5 If the analysis is within the specification range for T-85 (11.3% to 12.5%) obtain approval to transfer to storage.

5.6 If the analysis does not fall within the specification range for % dea, consult with the ethanolamines engineer or use the calculation program in the computer to get new figures for the amounts of dea or tea to bring the tank into the specification range.

6.0 Revisions:

6.1	Revision No.1	04-19-93	Yearly Review
6.2	Revision No.2	12-20-94	Yearly Review
6.3	Revision No.3	12-29-95	Yearly Review
6.4	Revision No.4	02-19-96	Added 4.2