

WRITTEN BY: JMS
APPROVED BY:
DATE: 9/90
REVIEWED BY: DY
DATE: 10/91

6903-019.SOP
MC PRODUCT TYPE 343 IN SPEC TANKS

OPERATOR'S NAME: _____ DATE: _____

| CHECK | ACTION STEPS (Capital Letters) and COMMENTS (Small Letters) |

- _____ 1. REVIEW JOB SAFETY INSTRUCTIONS.
BECOME FAMILIAR WITH THE CHEMICALS THAT YOU ARE WORKING WITH.
KNOW SOME OF THEIR CHARACTERISTICS. KNOW WHAT PROCEDURES TO
USE IN CASE OF A SPILL/RELEASE OR ACCIDENT.
- _____ 2. INSURE THAT YOU ARE WEARING PROPER SAFETY EQUIPMENT.
HARD HATS, SAFETY SHOES, SAFETY GLASSES AND ESCAPE
RESPIRATORS ARE REQUIRED WHEN WORKING IN ANY PRODUCTION AREA.
GOGGLES AND CHEMICALLY SAFE GLOVES ARE RECOMMENDED WHEN
CATCHING SAMPLES. A COMFO II MASK IS REQUIRED WHEN GAUGING
TANKS.

- _____ 3. SPLIT PRODUCTION TO SPEC 11 OR SPEC 12 AS PER LEAD OPERATOR.

IF NO PRODUCTION IS IN THE OLD SPEC FARM:

- _____ 4. OPEN THE PRODUCTION LINE INTO SPEC 1, MAKING SURE THAT THE
PRODUCTION LINES TO THE OTHER SPEC TANKS ARE CLOSED.
- _____ 5. FOLLOW THE PRODUCTION LINE TO THE MANIFOLD IN THE OLD SPEC
FARM, AND OPEN THE VALVE IN THE LINE THAT COMES FROM THE
PRODUCTION AREA IN THE UNIT.
- _____ 6. IN THE STAB FARM AREA, OPEN THE VALVE IN THE PRODUCTION
MANIFOLD THAT LEADS TO THE SPEC TANKS. PINCH BACK ON THE
VALVE THAT LEADS TO THE OTHER PRODUCTION TANK (STAB OR DAY)
SO THAT APPROXIMATELY 25 GPM IS GOING TO THE SPEC TANKS.
- _____ 7. ALLOW PRODUCTION TO FLOW INTO SPEC 1 FOR APPROXIMATELY 10 TO
15 MINUTES TO FLUSH THE PRODUCTION LINE.
- _____ 8. OPEN THE PRODUCTION LINE TO SPEC 11 OR SPEC 12 AS PER LEAD
OPERATOR. CLOSE THE PRODUCTION LINE TO SPEC 1. Note the
beginning level of the production tank so that the correct
amount of stabilizer can be added.
- _____ 9. NOTIFY THE LEAD OPERATOR AND THE MC OPERATOR THAT PRODUCTION
HAS BEEN SPLIT. ASK IF THE LEVEL IN THE PHASE SEPARATOR IS
OK.
- _____ 10. CHECK THE LEVEL IN THE PRODUCTION TANK PERIODICALLY TO MAKE
SURE THAT IT IS COMING UP AND TO PREVENT OVERFILLING. ALSO
CHECK TO MAKE SURE THAT THE OTHER SPEC TANK LEVELS ARE
HOLDING.

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IF PRODUCTION IS ALREADY IN THE OLD SPEC FARM:

- _____ 11. SKIP PROCEDURES 4 THROUGH 10.
 - _____ 12. OPEN THE PRODUCTION LINE TO SPEC 11 OR SPEC 12 AS PER LEAD OPERATOR. CLOSE THE PRODUCTION LINE TO THE CURRENT PRODUCTION TANK. Note the beginning level of spec 11 or 12 so that the correct amount of stabilizer can be added.
 - _____ 13. NOTIFY THE LEAD OPERATOR AND THE MC OPERATOR THAT PRODUCTION HAS BEEN SWITCHED TO SPEC 11 OR 12. ASK IF THE LEVEL IN THE PHASE SEPARATOR IS OK.
 - _____ 14. CHECK THE LEVEL IN THE PRODUCTION TANK PERIODICALLY TO MAKE SURE THAT THE LEVEL IS COMING UP AND TO PREVENT OVERFILLING. ALSO CHECK TO MAKE SURE THAT THE LEVELS IN THE OTHER SPEC TANKS ARE HOLDING.
- * ONCE PRODUCTION IS IN SPEC 11 OR SPEC 12, PRESTABILIZE WITH 30 GALLONS OF BLM:
- _____ 15. CHECK THE STABILIZER LINES ON THE SPEC TANKS THAT ARE NOT BEING STABILIZED TO MAKE SURE THAT THEY ARE CLOSED. OPEN THE STAB LINE ON THE PRODUCTION SPEC TANK.
 - _____ 16. IF THE BEGINNING LEVEL OF THE TANK WAS EMPTY, SET THE SMITH METER ON THE STABILIZING PUMP TO 30 GALLONS. IF THERE WAS A LEVEL IN THE TANK PRIOR TO SWITCHING PRODUCTION, ADJUST THE AMOUNT OF STABILIZER TO BE ADDED USING THE STAB PROGRAM.
 - _____ 17. CHECK THE BLOCK VALVES ON THE TBL/MC, TLE AND DME TANKS AND LINES TO MAKE SURE THAT THEY ARE CLOSED TO PREVENT CROSS CONTAMINATION. OPEN THE SUCTION VALVE AND THE BLOCK VALVES FROM THE BLM TANK TO THE STABILIZER PUMP.
 - _____ 18. OPEN THE SUCTION AND DISCHARGE VALVES ON THE STAB PUMP. OPEN THE VALVE ON THE STAB LINE LEADING TO THE SPEC TANK THAT IS BEING STABILIZED.
 - _____ 19. PULL THE HANDLE ON THE SMITH METER AND TURN ON THE PUMP. Don't leave the pump while stabilizing. The meter doesn't always shut off at the set amount.
 - _____ 20. AFTER THE SET AMOUNT OF BLM HAS PUMPED INTO THE PRODUCTION TANK, TURN OFF THE PUMP. CLOSE THE SUCTION AND THE DISCHARGE VALVES ON THE STAB PUMP.

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- * NOTE: To make MC product type 343 in Spec 11 or Spec 12, only 30 gallons of BLM is required. Therefore, when the tank is being prestabilized it is also being stabilized for the final product.

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21. BLOW THE STABILIZER LINE TO THE PRODUCTION TANK WITH N2 FOR APPROXIMATELY 5 MINUTES TO CLEAR THE LINE AND MAKE SURE THAT ALL OF THE BLM IN THE LINE GOES INTO THE TANK.

22. CLOSE ALL VALVES THAT WERE OPENED TO STABILIZE. DOUBLE CHECK TO MAKE SURE THAT THERE ARE NO LEAKS.

TOP OFF SPEC 11 OR 12 AT ⁶/₅ FEET AIR SPACE:

23. IF PRODUCTION IS TO REMAIN SPLIT TO THE OLD SPEC FARM TO ANOTHER SPEC TANK, TOP OFF SPEC 11 OR 12 AT ⁶/₅ FEET AIR SPACE. CHECK WITH THE LEAD OPERATOR TO FIND OUT WHICH SPEC TANK IS TO BE USED FOR PRODUCTION NEXT. OPEN THE VALVE ON THE PRODUCTION LINE TO THAT TANK. Note the beginning level. CLOSE THE VALVES ON THE PRODUCTION LINE TO SPEC 11 OR 12. NOTIFY THE LEAD OPERATOR THAT A TANK HAS TOPPED OFF.

24. IF PRODUCTION IS NOT TO REMAIN SPLIT TO THE OLD SPEC FARM, TOP OFF THE TANK 2 INCHES FROM THE TOP OFF LEVEL. CLOSE THE PRODUCTION VALVE LEADING TO THE OLD SPEC FARM AT THE PRODUCTION MANIFOLD IN THE STAB TANK AREA. OPEN THE PRODUCTION LINE TO THE OTHER PRODUCTION TANK (STAB OR DAY) WIDE OPEN.

25. NOTIFY THE LEAD OPERATOR AND THE MC OPERATOR THAT A TANK HAS TOPPED OFF AND PRODUCTION IS ALL IN THE STAB TANK AREA.

26. BLOW THE PRODUCTION LINE WITH N2 FROM THE MANIFOLD IN THE STAB TANK AREA TO THE SPEC TANK IN THE OLD SPEC FARM AREA FOR APPROXIMATELY 10 MINUTES.

27. CLOSE ALL VALVES IN THE PRODUCTION LINE FROM THE MANIFOLD IN THE STAB FARM AREA ALL THE WAY TO THE SPEC TANK IN THE OLD SPEC FARM.

* PUT SPEC 11 OR SPEC 12 ON RECIRCULATION AND SAMPLE:

28. CHECK TO MAKE SURE THAT THE SUCTION AND RECIRCULATION LINES AND VALVES ARE CLOSE THE OTHER SPEC TANKS. OPEN THE SUCTION VALVE AT THE TANK WIDE OPEN AND OPEN THE RECIRCULATION VALVE APPROXIMATELY HALF WAY.

* NOTE: A tank may be put on recirculation before it tops off. If this is done, note the time of top off to make sure that it recirculates for 8 hours after top off before a sample is caught. There may be a time when the tank cannot be put on recirculation before or at the time of top off due to other lines being used that tie in to the same lines of the tank. As soon as it is possible to put the tank on recirculation, do so and note the time. It must recirculate for 8 hours before sampling.

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- _____ 29. OPEN THE SUCTION AND DISCHARGE VALVES ON THE 343 PUMP. OPEN ALL OTHER BLOCK VALVES THAT MAY BE CLOSED BETWEEN THE TANK AND THE PUMP. DOUBLE CHECK TO MAKE SURE THAT ALL OTHER LINES THAT LEAD TO OTHER TANKS AND TO SHIPPING ARE CLOSED.
- _____ 30. TURN ON THE PUMP. DOUBLE CHECK TO MAKE SURE THAT THE PRODUCT IS FLOWING BACK INTO THE TANK.
- _____ 31. LET THE TANK RECIRCULATE FOR 8 HOURS. AFTER 8 HOURS OF RECIRCULATION, TWO 1/2 GALLON SAMPLES ARE CAUGHT AND BROUGHT TO THE MAIN LAB FOR ANALYSIS. TAG THE SAMPLE BOTTLES WITH THE TANK NUMBER, BATCH NUMBER OF THE TANK, AND PRODUCT TYPE FOR IDENTIFICATION. ALSO STATE ON THE TAG THE TESTS THAT NEED TO BE RUN BY THE LAB.

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SPILL/RELEASE POTENTIAL:

1. Make sure that all bleeds are closed and plugged.
2. Periodically check the level of the production tank to make sure that it is coming up and to prevent overfilling.
3. Periodically check the other tanks to make sure that the level is holding and not coming up.
4. Always check and double check valves to prevent cross contamination and other problems.
5. All valves in the old spec farm should be closed when not being used. Make sure that they are closed after each job is finished.