

Ethanolamines/Glycol Ethers Tier 3 Procedure

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Title: Procedure for PICS Organization and Procurement

Procedure for PICS Organization and Procurement

1.0 Objective:

To have a set plan for generating PICS, and an organized procedure for filing and recording them.

2.0 Responsibility

It is the responsibility of the person generating the PICS to follow this procedure to insure all PICS produced are meaningful and correct. These criteria are necessary to establish meaningful operating parameters for the plant.

3.0 PICS Procedure:

1. Call up the PDP 11 screen numbers and type "C". Press return. Type "C" again. Press return. Wait for beep. Type "RE". Press return. Type "RE". Press return.
2. Call up the VAX screen numbers on the VAX computer and press the "PRINT" button.
3. Arrange the PICS in the order shown for each series, separating all perforations.
4. When generating a PIC for the PM Series, go to the MOD 5 computer in the control room and print out the T-115 screen. If T-115 is not up, follow these instructions:
 - a) Type Q and hit return to bring up the "GPI" Operator Menu."
 - b) Type 16 for Display Graphics and bring up the "Section Summary."
 - c) Type 2 for T-115 which brings up the "Flowsheet Summary."
 - d) Type 1 to view the T-115 screen.
 - e) Press the COPY button on the keyboard for a printout.

Below is a list of screens to be taken off the PDP 11 and VAX computers in the control room for each plant or series. Put sheets in this order.

AMINES

EB Series

PM Series

__ FS # 166	__ FS # 63	__ FS # 167	__ 6	__ FS # 167	__ 6
__ FS # 165	__ 16	__ FS # 165	__ FS # 10	__ FS # 165	__ FS # 10
__ 21 (Vax)	__ FS # 64	__ FS # 108	__ 7	__ FS # 108	__ 7
__ 13	__ 17	__ 21 (Vax)	__ FS # 11	__ 21 (Vax)	__ FS # 11
__ 18	__ FS # 104	__ 3	__ 8	__ 3	__ 8
__ FS # 5	__ 11	__ 2	__ FS # 12	__ 2	__ FS # 12
__ 12	__ FS # 168	__ 4	__ 23	__ 4	
__ FS # 56	__ FS # 58	__ FS # 5	__ FS # 186	__ FS # 5	__ T-115
__ FS # 57	__ 9	__ FS # 6		__ FS # 6	__ MOD 5
__ FS # 190	__ 59	__ FS # 7		__ FS # 7	__ Chart
__ FS # 60	__ FS # 115	__ FS # 8		__ FS # 8	
__ FS # 61	__ 34	__ FS # 187		__ FS # 187	__ 23
__ FS # 62	__ 23	__ FS # 9		__ FS # 9	__ FS # 186
__ 15	__ FS # 189				

5. ____ Obtain two consecutive hourly tank level sheets from the PDP 11 printer and place on the bottom of the PIC. The times should correspond to the time the other PICS were taken.

6. ____ Using the PDP 11, run the "curplan" program to obtain a list of Amine, EB, or PM series tank level histories. Follow these instructions:

- a) At the PDP 11 terminal in the control room, type "CURPLAN."
- b) Press Y to obtain a printout of the tank levels and place on the bottom of the PIC.

7. ____ Obtain a DAILY PROCESS SAMPLE SHEET for the desired campaign following these instructions. Again, the time should correspond to the time the other PICS were taken.

- a) From the lab LIMS menu, type or point the arrow to RPP or Daily Process Sample Sheet and hit return.
- b) Select the campaign for the desired campaign PICS you need. "A" for Amines, "E" for EB Series, and "P" for PM Series. Press return.
- c) Press enter to have the sample sheet printed out to the control room.
- d) Place the sample sheet on the bottom of the accumulated stack.

8. ____ Staple the PIC vertically along left edge of papers.

9. Summarize the PIC by writing the following level drops/hr on the front page along with the ____ VAX oxide rates and ____ VAX alcohol /oxide ratios.

9.1 EB Series

____ level drop for DV-113
 ____ level drop for DV-106B
 ____ level drop for DV-108A/B

9.2 PM Series

- ___ level drop for DV-114
- ___ level drop for DV-115
- ___ level drop for DV-106A
- ___ level drop for DV-108A/B
- ___ level drop for T-130 BTM's (DV-115/143B) for Hi-PM
- ___ level drop for DV-143A rise/drop

10.0 All PICS will be stored in one of two areas:

The **CONTROL ROOM PICS BINDERS**, or
the **CONTROL ROOM PICS LIBRARY**.

10.1 CONTROL ROOM PICS BINDERS

These "Binders" contain hand picked sets of PICS from each of the three Dethanolamines/Glycol Ethers series. Each PIC contains unique characteristics to their respective series. As the campaigns change and updated PICS become available, **operations will be in charge of replacing old PICS when a better set becomes available**. In order for these "Binders" to be a useful tool, operations must use and update them.

10.1.1 These PICS are the preferred operating parameters for the conditions identified.

10.1.2 PICS should not be removed from the binders unless it is being replaced by a better set. This is to insure that the binders remain complete.

11.0 CRITERIA FOR ADDING/REPLACING PICS:

11.1 New and/or modified flow rates.

11.2 Quality improvements.

11.3 Significant changes to the system. (T-115 usage, different # steams, etc.)

11.4 When two PICS seem identical, compare their VAX dollar meter steam to feed ratios. If money was saved on steam, replace the old PIC with it's new counterpart. Make a note of why on the new PIC's cover page.

***Before 4/12/96 the dollar meter was incorrect. Compare PICS starting after that date only.

11.5 New PICS should be closely scrutinized when deciding if they belong in the **CONTROL ROOM PICS BINDERS**. The intent of the binders is for PICS at key conditions, not necessarily every way we ever run the plant. Therefore, we should try to limit the sets of PICS in the BINDERS. Extra conditions should go in the Library.

12.0 CONTROL ROOM PICS LIBRARY

12.1 Although extra PICS are not kept in the control room "Binders," they provide a historical reference for each series and the changes taken place in years past. They may also aid in training new employees. Do NOT throw away extra PICS. This collection is NOT intended for everyday use.

12.2 All extra PICS will be filed in the back of the control room in the file drawer marked **PICS LIBRARY**. They are arranged by date and the three major series. As PICS accumulate monthly or bimonthly, create new files to store the respective PICS and label these dates accordingly (for instance, PM 2-3/96 or Amines 4/96).

12.3 When a "Binder" PIC is replaced with a new one, the old PIC should be filed in the control room PICS "Library" according to date. All old PICS are already recorded in the "Library" spreadsheet, as described in the following section.

13.0 SPREADSHEETS

There are two spreadsheets associated with the PICS.

1. The DOWANOLS PICS LIBRARY spreadsheet and,
2. the CONTROL ROOM PICS BINDER spreadsheet.

13.1 The Dowanol PICS "Library" spreadsheets need to be updated after all PICS have been taken. The spreadsheet is listed under \\glyether\forms\PICS as "LIBRARY." Also under the "PICS" icon on the control room workstations. Fill in each column appropriately and save.

13.2 The Control Room PICS Binder needs to be updated with each addition or substitution of PICS, and a new print out obtained for the binder. The spreadsheets are listed under \\glyether\forms\PICS as "BINDERS." Also under the "PICS" icon on the control room workstations. Fill in each column appropriately and save.

14.0 SCHEDULING

14.1 PICS for the Amines plant will be taken the 1st Saturday of every month as a job on the "Weekly Checklist."

14.2 PICS for the HI-PM mode and EB mode (start) will be taken after each series has lined out after a swap over. The Tier 3 "Glycol Ethers Series Swap Over" will remind operations to add this job to the control room wipe board.

14.3 PICS for the Semi-Continuous mode and EB mode (end) will be taken before the next series swap. The Tier 3 "Glycol Ethers Series Swap Over" will remind operations of this job before shutting down.

14.4 PICS near the end of the HI-PM mode will be taken prior to the Semi-Continuous run. Operations will be reminded of this job in the Tier 3 "Semi-Continuous Mode Operation" procedure.