VI. TENTATIVE OPERATING INSTRUCTIONS

A. PREMIUM OPERATOR CHANGES

1. Synopsis of Changes

a. Biphenyl Feed

Biphenyl will now be fed to the continuous chlorinators, catalyst mix tank and head tank from the east biphenyl storage tank. The existing transfer line between the biphenyl storage tanks with a new line tied into the existing biphenyl feed line will be utilized. The west biphenyl storage tank will be used only for catching head tank overflow and will require only infrequent pumping out. When necessary the west biphenyl storage tank material will be used to charge the catalyst mix tank or head tank.

b. Flow from #9 Chlorinator

When making 1142, flow from the #9 chlorinator will go to the continuous blow tank through an existing line, before going to the intermediate storage tank.

c. Head Tank Changes

The head tank for charging the batch chlorinators has been modified to allow 600 gallons to be charged to the chlorinators. This line overflows to the #7 storage tank and will be used when charging boildown and off-gas condensate. The old overflow line at the 500 gallon level remains and will be used for biphenyl. Two remote controlled valves, one in each overflow line, are operated using a selector switch located on the handrail by the batch blow tanks.

A new charge line from the #7 storage tank pump to the head tank will be used to charge boildown to the head tank from #7 storage. A remote push-button station for turning the #7 storage pump on and off has been installed near the batch blow tanks.

2. Equipment

a. East biphenyl storage tank (Item 401).

b. East biphenyl storage tank pump (Item 402).

c. #7 Storage tank pump (Item 157).

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VI. TENTATIVE OPERATING INSTRUCTIONS (contd.)

A. PREMIUM OPERATOR CHANGES (contd.)

3. Equipment Function

a. The function of the east biphenyl storage tank is to hold liquid biphenyl until it can be used in the process.

b. The function of the east biphenyl storage tank pump is to charge biphenyl to the catalyst mix tank, continuous chlorinators, biphenyl head tank, #10 storage tank, west biphenyl storage tank, and circulate east biphenyl storage tank contents.

c. The function of the #7 storage tank pump is to circulate #7 storage tank contents and charge the head tank or #1 mix tank.

4. Changes to Control Loops, Inerlocks, and Alarms

a. Control Loops

(1) Biphenyl Feed to #6 Chlorinator - FICA-7

The function of this loop is to control the biphenyl flow to #6 chlorinator. It is equipped to control at two different ranges, one for making crude MCS-1109, and one for making 1142. A selector switch located near the top of #6 chlorinator must be set correctly for the instrument to control in the correct range.

(2) Specific Gravity Control #8 or #9 Chlorinator DRCA-39

The function of this loop is to control the specific gravity of the material in either #8 or #9 chlorinator. It is equipped to operate in two different ranges, one for Aroclor 1142 and one for crude MCS-1109.

b. Interlocks - No Change

c. Alarms

If the east biphenyl storage tank pump motor stops, an alarm will sound and the window in the telealarm panel marked, "biphenyl transfer pump shutdown", will light.

5. Start Up Instruction Changes

a. Catalyst Mix Tank

The only change is that biphenyl will come directly from the east biphenyl storage pump. Be sure the pump is running and the valves lined up to pump biphenyl to the catalyst mix tank. Push button

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VI. TENTATIVE OPERATING INSTRUCTIONS (contd.)

A. PREMIUM OPERATOR CHANGES (contd.)

5. Start Up Instruction Changes

switches for the east biphenyl storage pump are located at the pump and also at the top of the west biphenyl storage tank.

b. Continuous Chlorinator Changes

(1) Set the biphenyl flow control selector switch to control at the correct range for 1142 and close the valve in the biphenyl feed line for crude MCS 1109. Open the valve in the feed line used for 1142.

(2) Set the specific gravity controller selector switch to the correct range for making 1142 and be sure the instrument will be fed from the #9 chlorinator only.

(3) Be sure that the valves are lined up to feed biphenyl from the east biphenyl storage pump and that the pump is running.

(4) Start up as usual.

c. Batch Chlorinator Changes

(1) The head tank can be charged with either biphenyl to a 500 gallon level or off-gas condensate or boildown to a 600 gallon level.

(a) Biphenyl

Charge biphenyl as normally done except that the overflow selector switch must be turned to the left and the manual valve in the line from #7 storage must be closed. Make sure the valves in the biphenyl line from the east biphenyl tank pump are lined up and the pump is running.

(b) Off-Gas Condensate

Charge off-gas condensate as normally done except that the overflow selector switch should be turned to the right to allow the overflow to go to #7 storage. About 20% from the off-gas storage tank should fill the head tank.

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VI. TENTATIVE OPERATING INSTRUCTIONS (contd.)

A. PREMIUM OPERATOR CHANGES (contd.)

5. Start Up Instruction Changes (contd.)

(c) Boildown

Boildown will be charged using the #7 storage pump and the new line to the head tank. The new overflow line to #7 storage will be used so the overflow selector switch should be turned to the right. Turn the #7 storage pump on and off using the remote push button station near the overflow selector switch. Seven inches from #7 storage should fill the head tank. Charge the head tank in the usual manner.

(2) The batch chlorinators are otherwise operated normally.

6. Normal Operations

The conditions during normal operation should not be different than they were before the changes were made.

7. Shut Down Instructions

There are no changes to the shut down instructions.

8. General Information

(a) Biphenyl will be fed from the east biphenyl storage tank.

(b) The biphenyl feed to #6 chlorinator has a dual control range. Make sure the flow is lined up through the correct feed line and the selector switch is in the right position for the product you are making.

(c) The specific gravity controller also has a dual range and must be lined up and have the selector switch in the correct position.

(d) The head tank has two overflow lines. The higher one is for off-gas condensate and boildown. The lower one is for biphenyl. Be sure the selector switch is in the correct position.

9. Critical Control Points - No Change

10. Other Control Points - No Change

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