**WORK INSTRUCTIONS FOR** **GRAPHITE SOLUTION/RAM COKE FINES ADDITION TO LIME TANK**

**Responsibility:** PCM Incharge

**Identified Hazards:**

1. Fall of a person
2. Contact with lime powder/Ram car Fines
3. Nonuse of PPE & WI
4. Improper house keeping
5. Inadequate local illumination.
6. Getting entangled with lime stirrer

**Significant Aspect:**

1. Water consumption, depletion of natural resource.
2. Dust generation

**Procedure|:**

* Unauthorized operation or repair of any equipment is a punishable offence.
* Ensure that person doing this activity is wearing all PPE viz dust mask, safety goggle, safety shoes hand gloves.
* Shift graphite bags collected from bag house to lime tank. Ram car fines which are stored in container to be added through the 10 mm mesh provided above the lime tank.
* Add sufficient amount water
* Stir well and allow the slurry to settle.
* Carefully pour top solution into the tank.
* Left over slurry to be discarded/dumped in baghouse dumping chamber.
* Commercial graphite bags can directly be used in the lime tank.
* Ideally graphite or ram car fines and hydrated lime to be used in the ratio 50:50 depending on the availability of ram car fines. Graphite addition or ram car fines may be increased if required to achieve desired pig quality but at the same time less of hydrated lime should not impair PCM operation viz loose pigs falling below PCM/pigs not getting detached from moulds. Ram coke fines to be used strictly with the help of 10mm screen and during ram coke fine usage graphite and hydrated lime to be reduced.
* Addition to be carefully monitored by maintaining specific gravity.
* Solution in the range of 1:15 to 1:20 units. Empty bags/buckets to be shifted to designated place.

|  |  |  |
| --- | --- | --- |
| **Prepared By:**  Head – Production PID I | **Reviewed & Issued By:**  Management Representative | **Approved By:**  Head – Pig Iron Division |
| **Signature:** | **Signature:** | **Signature:** |
| **Date: 15.07.2022** | **Date: 15.07.2022** | **Date: 15.07.2022** |

|  |  |  |  |
| --- | --- | --- | --- |
| **Amendment Record** | | | |
| **Revision date** | **Manual Section ref. and para** | **Brief details of revision** | **New Revision No.** |
| 15.07.2022 | Procedure for graphite solution/Ram coke fines addition to lime tank | Change in format | 05 |
|  |  |  |  |