

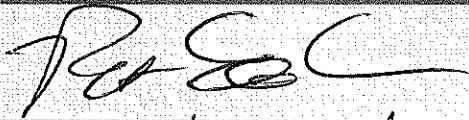

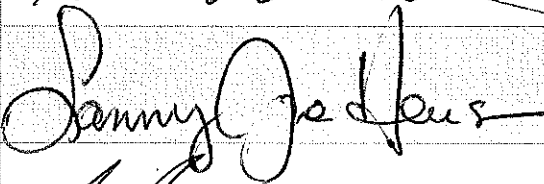

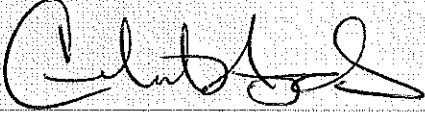

**GILES CHEMICAL ~ PREMIER MAGNESIA****Validation Protocol**

Title: Komline Filter Press Validation Protocol	Number: E17-VAL-PIQ-240
Owner: Kenneth Basehore	Revision: 0
Effective Date: 5/31/17	Page: 1 of 16



## I. Approvals

Signing below indicates agreement that the protocol is ready for execution of the Installation, Operational, and Performance Qualification for the Komline filter press model 1200-100S/50-64/32 (s/n AF-0228), located at 102 Commerce Street at the Main Plant production facility.

Project Member	Functional Area	Signature	Date
Patrick Owen	Engineering		5/15/17
Kenneth Basehore	Engineering		5/15/17
Sammy Henson	Maintenance		5/15/17
Jason Bumgarner	Production		5-15-17
Matt Haynes	Operations		5-15-17
Deborah Durbin	Quality		5-15-17

A final summary report that consists of results and conclusions based on the data collected after protocol execution will be written and approved. The executed protocol will be attached behind the report.

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## II. Purpose

The purpose of this protocol is to certify with documented evidence that Komline filter press model 1200-100S/50-64/32 (s/n AF-0228) functions as intended throughout its anticipated operating ranges. This protocol sets forth the objectives, methodology, documentation, and test activities needed to complete the Installation Qualification (IQ), Operational Qualification (OQ) and Process Qualification (PQ) for the filter press, located at 102 Commerce Street at the Main Plant production facility.

## III. Background

The Komline filter press model 1200-100S/50-64/32 (s/n AF-0228) was installed on site by contractors during late 2001. It is intended to receive a  $MgSO_4$  solution from the digesters. The solution is known as 'mud'. The mud is pumped through a series of filter screens pressed together with a hydraulic pump. The screens filter out insoluble impurities. The waste stream from the filter press is caked and hauled to a land fill. The product stream from the filter press (known as 'brine') is pumped to a storage tank, and is fed to the crystallizers to produce solid  $MgSO_4$  salt.

## IV. Overview

No other departments or systems will be affected by the installation of use or this equipment.

The following tests will be performed during this qualification:

- The unit is installed correctly, and with access to all required points
- The squeeze pressure is appropriate
- The associated pumps are installed correctly, with the correct rotation
- The filter cloths do not have creases or folds
- Brine clarity matches current filter press production

## V. System Description

1. The filter press is operated through a series of preprogrammed steps in a control interface.
2. The steps control the squeeze pressure, the product flow and flush timing.
3. Mud flows into the press, and brine is separated from insoluble impurities.

## VI. Scope

The IQ, OQ and PQ contained within this protocol is intended to certify with documented evidence that the Komline filter press model 1200-100S/50-64/32 (s/n AF-0228) is installed, operates and functions as intended throughout its anticipated operating ranges.

The product affected by this equipment is all salt produced in the Main Plant at 102 Commerce Street, Waynesville, NC.

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## VII. Roles and Responsibilities

### 1. Engineering

- Write and issue the protocol
- Investigate protocol deviation reports
- Execute the IQ, OQ and PQ portions of the validation
- Review the data and originate the interim notification to Quality Assurance
- Write and route the final report

### 2. Quality Assurance

- Review and approve the protocol
- Review and approve the raw data and notifications
- Review, approve and store the final report

### 3. Maintenance

- Provide equipment manuals needed to execute the validation
- Review and approve the protocol
- Review and approve the raw data and notifications
- Review and approve the final report

### 4. Production

- Review and approve the protocol
- Review and approve the raw data and notifications
- Review and approve the final report
- Assist, as needed with the execution of the IQ, OQ and PQ

## VIII. Test Program

### 1. Installation Qualification (IQ)

#### a. Objective

The objective of the installation verification is to document that the Komline filter press model 1200-100S/50-64/32 (s/n AF-0228) is installed correctly.



#### b. Equipment and Materials

- Komline filter press model 1200-100S/50-64/32 (s/n AF-0228)
- Mud Feed Pump Goulds model 3196 (s/n 797D421)
- Preheat pump Goulds model 3195 (s/n 712E591)
- Squeeze pump Grundfos model CR4-60\_U-G-A-AUU2 (s/n C41006066E)
- Cake wash pump Gould model 3657 (s/n J0144429)

#### c. Procedure

- Verify that the press is situated to allow sufficient room around the machine for access
- Verify that all pumps are situated to allow sufficient room for access
- Verify that the press is level

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- Verify that the pumps are level
- Verify that the electrical utilities fall within the manufacturers required ranges

d. Acceptance Criteria

Ensure that the installation is correct.

## 2. Operational Qualification (OQ)

a. Objective

The objective of the operational qualification is to ensure that the Komline filter press model 1200-100S/50-64/32 (s/n AF-0228) operates as intended by the manufacturer. The controls will be operated to test the ability of the vessel to start and stop as the circulation flow rate varies above and below the alarm limits.

b. Equipment and Materials

- Komline filter press model 1200-100S/50-64/32 (s/n AF-0228)
- Mud Feed Pump Goulds model 3196 (s/n 797D421)
- Preheat pump Goulds model 3195 (s/n 712E591)
- Squeeze pump Grundfos model CR4-60\_U-G-A-AUU2 (s/n C41006066E)
- Cake wash pump Gould model 3657 (s/n J0144429)

c. Procedure

- Verify that the squeeze pressure is appropriate
- Verify that the associated pumps work properly
- Verify that the pumps have the correct rotation direction
- Verify that the cloths do not have creases or folds

d. Acceptance Criteria

Verification that the tested operations operate as indicated by the designer's specifications.

## 3. Performance Qualification (PQ)



a. Objective

The objective of the performance testing is to document that the Komline filter press model 1200-100S/50-64/32 (s/n AF-0228) performs the functions required by Giles Chemical. This protocol will verify the following:

b. Equipment and Materials

- Komline filter press model 1200-100S/50-64/32 (s/n AF-0228)
- Mud Feed Pump Goulds model 3196 (s/n 797D421)
- Preheat pump Goulds model 3195 (s/n 712E591)
- Squeeze pump Grundfos model CR4-60\_U-G-A-AUU2 (s/n C41006066E)

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- Cake wash pump Gould model 3657 (s/n J0144429)

c. Procedure

- Verify that the press proceeds through the programmed steps correctly
- Verify that the brine clarity is not different than existing press brine clarity

d. Acceptance Criteria

The PQ will be accepted if the brine clarity is not different than existing press brine clarity, and if the press proceeds through the programmed steps correctly.

## IX. Calibration

Verify that all instruments used are within the calibration dates.

- Calibrated multimeter

## X. References

None

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**Installation Qualification (IQ)****1. Equipment**

Device	Calibration Date	Calibration Expiration	Verified By	Date
Multimeter Model: Fluke 114 S/N: 36250117WS				

Expected	Actual	Pass/Fail	Verified By	Date
Komline Press Model: 1200-100S/50-64/32 S/N: AF-0228				
Mud Feed Pump Model: 3196 S/N: 797D421				
Preheat Pump Model: 3195 S/N: 712E591				
Squeeze Pump Model: CR4-60_U-G-A-AUU2 S/N: C41006066E				
Cake Wash Pump Model: 3657 S/N: J0144429				

**2. Acceptance Testing**

Expected	Actual	Pass/Fail	Verified By	Date
There is sufficient room around the press to allow access doors and panels to be opened	There ____ sufficient room around the press to allow access doors and panels to be opened.			
There is sufficient room around the mud feed pump to allow maintenance	There ____ sufficient room around the mud feed pump to allow maintenance			
There is sufficient room around the preheat pump to allow maintenance	There ____ sufficient room around the preheat pump to allow maintenance			
There is sufficient room around the squeeze pump to allow maintenance	There ____ sufficient room around the squeeze pump to allow maintenance			

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<b>There is sufficient room around the cake wash pump to allow maintenance</b>	There ____ sufficient room around the cake wash pump to allow maintenance			
<b>The press is level</b>	The press ____ level			
<b>The mud feed pump is level</b>	The mud feed pump ____ level			
<b>The preheat pump is level</b>	The preheat pump ____ level			
<b>The squeeze pump is level</b>	The squeeze pump ____ level			
<b>The cake wash pump is level</b>	The cake wash pump ____ level			
<b>All four pumps are 230 VAC 3PH</b>	All four pumps ____ 230 VAC 3PH			

**3. Acceptance of Testing and Review**

<b>Expected</b>	<b>Actual</b>	<b>Pass/Fail</b>	<b>Verified By</b>	<b>Date</b>
<b>All actual results match the expected values.</b>	All actual results ____ the expected values.			
<b>The relevant standard working procedures are approved</b>	The relevant standard working procedures ____ approved			
<b>List the procedure numbers</b>				
<b>Results reviewed and accepted by</b>				

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**XI. Operational Qualification (OQ)****1. Equipment**

Expected	Actual	Pass/Fail	Verified By	Date
<b>Komline Press</b> Model: 1200-100S/50-64/32 S/N: AF-0228				
<b>Mud Feed Pump</b> Model: 3196 S/N: 797D421				
<b>Preheat Pump</b> Model: 3195 S/N: 712E591				
<b>Squeeze Pump</b> Model: CR4-60_U-G-A-AUU2 S/N: C41006066E				
<b>Cake Wash Pump</b> Model: 3657 S/N: J0144429				

**2. Acceptance Testing**

Expected	Actual	Pass/Fail	Verified By	Date
<b>The press is stopped</b>	The press ____ stopped			
<b>Press open filter</b>	The press _____.			
<b>Ensure that none of the clothes have creases or folds</b>	The cloths _____ have creases or folds			
<b>Press close filter</b>	The press _____.			
<b>From the Main Screen, press the 'Go to Advanced' button</b>	The button _____ pressed			
<b>The program steps are displayed</b>	The program steps _____ displayed			

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<b>Record the program steps</b>				
<b>Navigate to the 'Filter Setpoints' screen</b>	The 'Filter Setpoints' screen ____ displayed			
<b>Change the 'Feed Low Flow to End' setpoint to 50 GPM</b>	The setpoint ____ changed			
<b>Change the 'Feed Low Flow to End' setpoint to 30 GPM</b>	The setpoint ____ changed			
<b>Record the 'Final Squeeze Pressure'</b>	____ psi			
<b>Press start conveyor</b>	The conveyor ____.			
<b>Press stop conveyor</b>	The conveyor ____.			

**3. Acceptance of Testing and Review**

<b>Expected</b>	<b>Actual</b>	<b>Initials</b>	<b>Date</b>
<b>All actual results match the expected values.</b>	All actual results ____ the expected values.		
<b>The IQ section is complete with no deviations</b>	The IQ section ____ complete with no deviations		
<b>Results reviewed and accepted by</b>			

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**XII. Performance Qualification (PQ)****1. Equipment**

Expected	Actual	Pass/Fail	Verified By	Date
<b>Komline Press</b> Model: 1200-100S/50-64/32 S/N: AF-0228				
<b>Mud Feed Pump</b> Model: 3196 S/N: 797D421				
<b>Preheat Pump</b> Model: 3195 S/N: 712E591				
<b>Squeeze Pump</b> Model: CR4-60_U-G-A-AUU2 S/N: C41006066E				
<b>Cake Wash Pump</b> Model: 3657 S/N: J0144429				

**2. Acceptance Testing**

Expected	Actual	Pass/Fail	Verified By	Date
<b>The press is stopped</b>	The press ____ stopped			
<b>Press open filter</b>	The press _____.			
<b>Ensure that none of the clothes have creases or folds</b>	The cloths _____ have creases or folds			
<b>Press close filter</b>	The press _____.			
<b>From the Main Screen, press the 'Go to Advanced' button</b>	The button _____ pressed			
<b>The program steps are displayed</b>	The program steps _____ displayed			

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<b>Record the program steps</b>				
<b>Navigate to the 'Filter Setpoints' screen</b>	The 'Filter Setpoints' screen ____ displayed			
<b>Record the 'Final Squeeze Pressure'</b>	_____ psi			
<b>Press start conveyor</b>	The conveyor _____			
<b>Press 'Start Filter'</b>	The press _____ started			
<b>The press progresses through the program steps</b>	The press _____ through the program steps			
<b>The mud feed pump has the correct rotation, and is working correctly</b>	The mud feed pump _____ the correct rotation, and is working correctly			
<b>The preheat pump has the correct rotation, and is working correctly</b>	The preheat pump _____ the correct rotation, and is working correctly			
<b>The squeeze pump has the correct rotation, and is working correctly</b>	The squeeze pump _____ the correct rotation, and is working correctly			
<b>The cake wash pump has the correct rotation, and is working correctly</b>	The cake wash pump _____ the correct rotation, and is working correctly			
<b>Collect a beginning brine sample for lab analysis</b>	The sample _____ collected			
<b>Collect a middle brine sample for lab analysis</b>	The sample _____ collected			

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<b>Collect an ending brine sample for lab analysis</b>	The sample _____ collected			
<b>Collect a BME brine sample from a different filter press</b>	The sample _____ collected Press s/n: _____			
<b>The six samples show no difference in clarity</b>	The six samples _____ difference in clarity			
<b>The press is stopped</b>	The press _____ stopped			
<b>Ensure that none of the clothes have creases or folds</b>	The cloths _____ have creases or folds			

**3. Acceptance of Testing and Review**

<b>Expected</b>	<b>Actual</b>	<b>Initials</b>	<b>Date</b>
<b>All actual results match the expected values.</b>	All actual results _____ the expected values.		
<b>The IQ section is complete with no deviations</b>	The IQ section _____ complete with no deviations		
<b>The OQ section is complete with no deviations</b>	The OQ section _____ complete with no deviations		
<b>The relevant standard working procedures are effective</b>	The relevant standard working procedures _____ effective		
<b>List the procedure numbers</b>			

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Results reviewed and accepted by

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### XIII. Protocol Deviation Report Log

Log each protocol deviation report in the table below. Attach PDRs to this protocol.

PDR #	Description	Protocol Section	Date Initiated	Date Resolved

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### XIV. Signature Identification Log

Identify in the table below any personnel involved in the execution of this protocol.

Name	Affiliation	Signature	Initials	Date

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