
	<b>GILES CHEMICAL ~ PREMIER MAGNESIA</b>		
	<b>Company Procedure</b>		
	Title: <b>Acid Unloading Procedure</b>	Number: <b>P12-PR-200-005</b>	
	Owner: <b>Patrick Owen</b>	Revision: <b>08</b>	
	Effective Date: <b>08/20/2014</b>	Page: <b>1 of 9</b>	

## 1.0 Purpose

This procedure explains how to properly unload sulfuric acid railcars.

## 2.0 Scope

This procedure applies to all incoming sulfuric acid railcars.

## 3.0 Responsibility

Material Handler is responsible for performing this procedure.

Lead Operator is responsible for being the second person during hook-up in case of emergency.

## 4.0 Safety Considerations

1. Before approaching the Tank Car containing Sulfuric Acid put on the following Personal Protective Equipment: Safety Goggles, Face Shield, Acid Suit, and Rubber Gloves.
2. Ensure the brake is set and place the chocks in front of and behind the wheel.
3. The warning sign (blue) must be in place during unloading.
4. Giles lock must be on track derail before hooking up cars.

Safety is a condition of employment. Employees are not authorized to work in an unsafe manner and are prohibited from harming the environment of the facility or community.

## 5.0 Materials/Equipment

- proper clothing and gear for acid work
- tool or wrench

## 6.0 Procedure

This section provides specific directions for unloading Sulfuric Acid, a hazardous chemical.

Employees must receive hands on training and complete an *Acid Unloading Test (P12-PR-200-F005)* with a score of 70% or higher prior to proceeding with any unloading tasks.



### Prepare for Unloading and Refilling:

#### Storage Tanks

1. Make sure that the storage tank(s) can accommodate the contents of the rail car.
2. Ensure that there is no pressure on the tank to be filled.
3. Open the dump valve to the storage tank to be filled.

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	<b>GILES CHEMICAL ~ PREMIER MAGNESIA</b>		
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	Owner: <b>Patrick Owen</b>	Revision: <b>08</b>	
	Effective Date: <b>08/20/2014</b>	Page: <b>2 of 9</b>	

4. If swapping tanks is necessary, refer to the *Acid Tanks and Supply Pumps (P12-PR-200-004)* procedure.
5. Inspect all ports on the storage tanks to make sure they are secure.

### **Rail Car**

1. Obtain an *Acid History Log (P12-PR-200-F007)* from the documentation system and fill out all appropriate information following the *Acid History Log Procedure (P12-PR-200-007)*
2. Make sure hand brake on Rail car is engaged
3. Assure the derail and caution signs are in place.
4. Assure derail lock is in place
5. Make sure wheels are Blocked or Chocked.

### **Obtain an Acid Sample**

1. Obtain the special dipstick used for sampling an acid car, and a sample bottle
2. Put on safety equipment before going up on the car.
3. Align safety hoop walkway with top of acid car ladder.
4. Let the safety hoop down and extend the walkway to the acid car.
5. Check the hatch to make sure the Load Seal is intact. If it is not, inform the Safety or Plant Manager. Do not unload the car until told to do so. The acid may have been tampered with.
6. Check the safety vent (rupture disk) to insure the cap is intact.
7. Carefully depressurize the car by slowly removing the air inlet plug and opening the air valve.



8. Remove the sample bottle cap, put it aside, and screw the bottle firmly into the perforated bottle cap attached to the stick.
9. Remove the dump cap and lower the bottle and stick through and down into the acid, thus filling the bottle.

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## GILES CHEMICAL ~ PREMIER MAGNESIA

### Company Procedure

Title: Acid Unloading Procedure

Number: P12-PR-200-005

Owner: Patrick Owen

Revision: 08

Effective Date: 08/20/2014



Page: 3 of 9



10. Retract the bottle carefully.
11. Replace cap and rinse acid residue from out side of sample bottle
12. Label sample properly and place in Acid Cabinet as a retained sample

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	GILES CHEMICAL ~ PREMIER MAGNESIA		
	Company Procedure		
	Title: Acid Unloading Procedure	Number: P12-PR-200-005	
	Owner: Patrick Owen	Revision: 08	
	Effective Date: 08/20/2014	Page: 4 of 9	

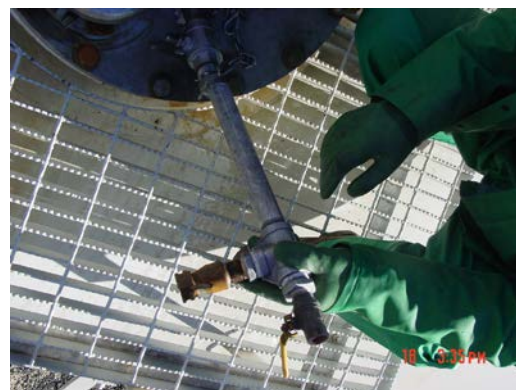
### Prepare the Car for Unloading

1. Check the unloading hose and fittings for damage or wear.
2. Remove the plug from the discharge hose.
3. Check the gaskets on the quick-coupling on the discharge hose. Replace if necessary.
4. Check bolts on load hole and tighten if necessary.
5. Connect the proper Discharge pipe to the discharge port of the Acid car.

6. Connect the unloading hose to the discharge port on the tank.
7. Connect the small air line to the Discharge pipe acid shutoff valve actuator.





8. Coat the threads of the air inlet pipe with Teflon paste or tape.
9. Connect the air supply hose to the tank car air inlet port.



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	Owner: <b>Patrick Owen</b>	Revision: <b>08</b>	
	Effective Date: <b>08/20/2014</b>	Page: <b>5 of 9</b>	

### Transfer Acid to the Storage Tank

1. Check the acid transfer line at the storage tanks to assure that the acid will go to the proper storage tank.
2. Close the air dump and open the valve on the air supply line to pressurize the car. (20 psi).
3. Close the shutoff air dump and open the valve to the acid shutoff valve.



4. When acid is moving through the line (you can tell by the weight), start the acid offloading pump.



5. Do not run the pump if no acid is in the line. Running the pump dry will destroy it.





### **WARNING:**

**Never pressurize the car to more than 30 psi  
(20 psi is preferred to unload with the pump)**

### Attend the Unloading

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	GILES CHEMICAL ~ PREMIER MAGNESIA		
	Company Procedure		
	Title: Acid Unloading Procedure	Number: P12-PR-200-005	
	Owner: Patrick Owen	Revision: 08	
	Effective Date: 08/20/2014	Page: 6 of 9	

Continuously check the acid transfer line for leaks.

If a leak occurs – **immediately do the following.**



1. Press one of the emergency air stop buttons (on the rack, near the pump switch, or inside the plant door)



2. Open both the air bleed offs as a precaution
3. Wait for the leak to subside
4. Stop the acid unloading pump if it has not stopped in 10 seconds
5. Carefully open the vent valve on the top of the rail car to ensure the car is depressurized
6. Notify the Safety and/or Plant Manager
7. Neutralize the spill(s) with lime.
8. If the spill is larger than 50 gallons, call 911.
9. If only a small spill, large quantities of water may be used, but only at the direction of the Safety or Plant Manager.
10. After the leak has been repaired check the entire system, as above, before resuming the unloading.

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	Company Procedure		
	Title: Acid Unloading Procedure	Number: P12-PR-200-005	
	Owner: Patrick Owen	Revision: 08	
	Effective Date: 08/20/2014	Page: 7 of 9	

### Complete the Unloading

The acid pump will stop and rushing air in the acid line indicates that the acid is out of the car.

1. An audible alarm will sound 15 minutes after the acid car is empty  
(air remains on during this 15 minutes to ensure acid line is clear )
2. Close the main air supply valve and open the dump.
3. Remove the air supply hose.
4. Ensure the car is depressurized by opening the vent valve on the top of the tank.
5. Disconnect the acid line, replace the plug, and carefully place back in rack.
6. Close the small air line and open its dump.
7. Remove the small air line.
8. Remove the Discharge pipe (Christmas Tree).





**Extreme care should be taken when handling Acid Hose.  
Major safety issues can come from damage**

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	Title: Acid Unloading Procedure	Number: P12-PR-200-005	
	Owner: Patrick Owen	Revision: 08	
	Effective Date: 08/20/2014	Page: 8 of 9	

### Prepare the Acid Rail Car for Release to the Railroad

1. Inspect the hatch cover gasket for damage and replace it if necessary.
2. Replace the educator pipe cap and tighten it with the chain in place.



3. Replace the air inlet plug and tighten it with the chain in place.
  - a. **Both the educator pipe and inlet plug must be "Tool Tightened"** before releasing to the railroad. ( firmly tighten each with a tool or wrench )



4. Confirm that the rupture disk assembly is intact.
5. Add a return seal on hatch cover and note seal number on Acid History Log
6. Store all hoses and couplings on the racks, clear of the siding and rail cars.
7. Pull the walkway in and raise the safety hoop to the upright position.
8. If the drip pan has water in it (verify with pH paper if there is any question), squeegee the water out of the pan.
9. Check the general condition of the rail car, (placards, ladders, hand rails, platforms, etc.), and report any problems to the appropriate personnel.
10. Confirm the railcar lining inspection date is not expired.
11. Remove the wheel chocks and the warning sign.
12. Sign off on *Acid History Log* and notify the appropriate personnel that the car is ready for release.



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	Effective Date: 08/20/2014	Page: 9 of 9	

## 7.0 Reference Documents

<i>Acid Unloading Test</i>	<i>(P12-PR-200-F005)</i>
<i>Acid Tanks and Supply Pumps</i>	<i>(P12-PR-200-004)</i>
<i>Acid History Log Procedure</i>	<i>(P12-PR-200-007)</i>
<i>Acid History Log</i>	<i>(P12-PR-200-F007)</i>

## 8.0 Change Information

Added the training requirements to the procedure and added all referenced documents to the Reference Documents section.

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