
	GILES CHEMICAL ~ PREMIER MAGNESIA		
	Company Procedure		
	Title: LOTO Liquid Side Primary Digester	Number: S12-PR-200-089	
	Owner: Robert Willis	Revision: 01	
	Effective Date: 09/13/13	Page: 1 of 6	

1.0 Purpose

The purpose of this procedure is to define the process required to lock out the Liquid Side Primary Digester at the Manufacturing facility.

2.0 Scope

Use this procedure when shut down of the Liquid Side Primary Digester is needed for maintenance.

3.0 Responsibility

Maintenance and Production

4.0 Safety Considerations

Safety glasses and appropriate safety apparel is to be worn at all times.

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

- Lock
- Tag
- Lock out device

6.0 Procedure

The proper process to lockout Liquid Side Primary Digester (*Asset Tag #10131*) is as follows:

1. Notify all affected employees that the machine is being taken out of production. Lead Operator will be responsible for taking the tank out of production and notifying maintenance that tank is available for work. Procedure *Starting and Stopping Digesters (P12-PR-200-013)* should be followed before beginning lock out tag procedure for Liquid Side Primary Digester.

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2. After confirming that the Primary Digester that is being worked on is out of service, allow the liquid in the Mix Pot to clear up and then unplug the power supply to the Mix Pot motor and lock out using approved lock out device.



3. Next close the mix pot water supply valve and the density control valve and lock out.





4. Next lock out the Mother Liquor feeder valve located on the Salt side of the plant above the Primary Digester (Asset Tag #10154).



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5. Lockout the Acid Control Valve located on the wall directly behind the Digester. Diaphragm valve should be cut completely off and the ball valve(s) turned to the off position.



6. Remove the PH probe located in the discharge pipe of the Primary Digester and suspend in the proper solution in order to suspend the process.



7. Lockout the Gearbox and motor located on the Primary Liquid Side Digester using the approved lockout for the breaker located on the wall between the Digester Room and the Filter Press Room.



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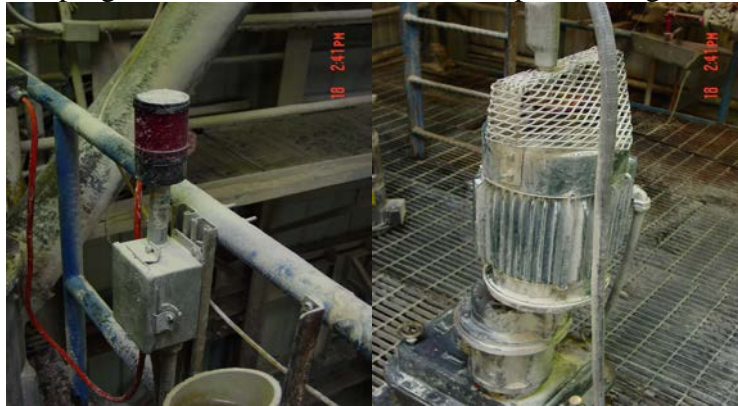
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8. Visually confirm that the gearbox and motor are not operational; this includes the stop light located on the handrail on top of the digester.



9. Attach drain hose to the drain valve located on the re-circulating loop on the Primary Digester floor level and to the Liquid Load Pump. Please note location of black hose for drainage of Primary Digester Liquid Side.





10. Attach inlet hose (Green hose in image) to the Liquid Load Pump and to the floor level valve on the Secondary Digester Liquid Side.



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11. Visually confirm that Digester has been drained below the blades on the Gearbox before moving to the next step of draining the Digester.



12. Attach a hose to the bottom drain valve located on the Digester and drain material into a hopper for disposal. Ensure that all material is removed from Digester before work begins.





13. Once Digester is empty, remove the hatch and discard the rubber gasket material. Always replace gasket with new material.



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14. Before entry into the Digester refer to Giles Procedure *Confined Space Entry Procedure (S12-PR-200-008)* and follow all safety rules and regulations regarding entry into the Digester.

Proper procedure to return equipment to operation:

1. Make sure all work is complete and all tools and maintenance equipment has been removed from the machine.
2. Notify all affected employees that equipment is about to be put back into service.
3. Remove ID tag with name, date and time.
4. Remove multi lockout device.
5. Turn disconnect to the on position.
6. Ensure that equipment is operational and available to be returned to production.

7.0 Reference Documents

Starting and Stopping Digesters (P12-PR-200-013)
Confined Space Entry Procedure (S12-PR-200-008)

8.0 Change Information

Document review- updated format using new template and numbering system.

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