

**IFFCO**

**INDIAN FARMERS FERTILISER COOPERATIVE LIMITED**  
**PARADEEP UNIT**  
**SHIFT INCHARGE LOG - PHOSPHORIC ACID PLANT**

Date / Shift		7/04/2014 °A°		Production in Shift : 584 MT / 8 Hrs.	
Shift Attendance		OT	Leave details		Eqpt Utilisation (Nos / Hrs)
Panel D. Parida, S. Seal, K. Agarwal, A.P. Singh, Subudhi,					Poklain
Field Kuldeep, Abimav, Narwal Singh, T. Sahar, R.K. DHA,					Payloader
OSL Mukhtar, R.S. Choudhary, N.S. Yadav, S.K. Pandey,					JCB
Rock Flow / Sulf. Acid flow to Reactor :					
Ball mills in operation : A, B, D				SST Lvl / Den 54%	
Readiness / Limitations : C ⇒ to be checked.					
Reactor conditions : 1.527, 1.285, 1.8					
Reactor level (Free board) 1.9 mtr.					
Agitators in line 15 (Fifteen)					
Vac. Clrs	110	111	112	113	Pre Cond pumps I / One
Vac	260	—	280	280	181 Ready
Amps	21.5	—	19.3	19.6	182 Running
ΔT °C					183 Running
Belt Filters in operation		A, B, C, D, E			
Readiness / Limitations :					
F ⇒ return acid d/c has leakage					
G ⇒ U/M.					
Evaporators in operation / FSA		A, C, E, G			
Readiness / Limitations :					
B ⇒ U/M					
E ⇒ U/M.					
Tanks	Lvl	Transfer to DAP		Process Water Cons (Avg m <sup>3</sup> /hr) 346 m <sup>3</sup> .	
411	150	WA (O)	525	Gypm pond Lvl (O / N) :	
412	99	WA (N <sub>1</sub> )	922	Gypm p/p i/l : 291	
413	72	WA (N <sub>2</sub> )	—	HW/CW p/ps i/l : 05 / 04	
414	92	WA (N <sub>3</sub> )	—	Pond rtn p/ps : (O/N)	
Pump Tk.	73	S (O)	—	Guard Pond Level : 1.6 M	
FSA Tk.	79/89	S (N)	253	C. T. Make - up Water : Pond water.	
AP 25V 6666 :					
AP 317A 4666 :					
AP 317A 5999 :					
AP 317A 4567 :					

*[Signature]*

BALLMILL

- \* B/M-C → manway box up over. ~~→~~  
Outlet HP, Inlet LP → not healthy.
- 21-D → <sup>gland leakage</sup> attended. Again started.
- B/M-B → 21 discharge line reducer leakage.
- B/M-A → discharge common line (elbow) leakage.
- B/M-A → feed chute leakage.

REACTOR

- \* V/C-111 → Secondary ejector leakage attended.  
→ Flash cooler cleaning U/P  
→ primary ejector to be opened & cleaned  
→ Suction reducer welding job U/P  
→ Cable connection job over. Dir. to be checked.
- \* 170A to be boxed up
- \* Air line has leakage near cir. 113
- \* V/C-110 MP steam line has leakage.

B/F & Filtration

- 232 F → spool piece changed and G.B replaced with a rod. to be checked.  
→ Return acid d/c. pipe changing U/P.
- P-240C → Casing has a pin hole.
- 250 & 251 F → leakage in Dis. common line elbow. Attending U/P.  
pollution sump pump elastomer changed.
- 232 E → flashhead flange leakage. Flashhead to be changed (ring damaged)
- B/F A → cloth to be changed and Gypsum dis. line has leakage
- B/F B → 4" wash d/c pipe has hole.
- old pond pump No: 04 cable connection pending.

Eva & Storage:-

- \* P-621 → U/M. Decoupled. base work to be done.
- \* Eva. A feed line elbow flange leakage attended.
- \* Eva. R → vortex breaker to be repaired  
→ 310 B - cable connection done. Dir to be checked.  
→ 330 B motor pulley to be fixed.
- Eva. E → Dis. Vertical bellows removed. Reducer work to be repaired
- 310 F → gland leakage to be attended.
- 390 has gland leakage / P 443 has gland leakage
- T-414 sludge cir. line has hole. M seal was applied
- WN2 - line cleaning U/P.
- FSA - Transfer pump - 1 gland leakage / FSA tanker loading pump

① UP Singh ② SK. Shamim ③ M. B. Alibek ④ G. C. Sahoo ⑤ SK. Gufran  
 ⑥ S. Singh

BP Helper = 19 + 181 = 23



**INDIAN FARMERS FERTILISER COOPERATIVE LIMITED**

**PARADEEP UNIT**

**SHIFT INCHARGE LOG - PHOSPHORIC ACID PLANT**

Annexure -  
Sheet - 3 of 4

Date / Shift		7/4/2014 - B Shift			Production in Shift : 555 m <sup>3</sup> / 8 Hrs.	
Shift Attendance		OT	Leave details		Eqpt Utilisation (Nos / Hrs)	
Panel Ankit, S. Mishra, P. Prasad, S.K. Patra,					Poklain	
Field C.K. Barik, Md. Shohid, D. Beura, S. Singh, P.C. Nayak					Payloader	
OSL		B.C. Das			JCB	
Rock Flow / Sulf. Acid flow to Reactor :			180 / 80			
Ball mills in operation : B, D - utility water			SST Lvl / Den 57%			
Readiness / Limitations * B/M - A shell leak.						
* B/M - C						
* P-032 Running / P-031, 033 Ready						
Reactor conditions : 1.55 / 1.28 / 1.25						
Reactor level (Free board) 1.8 mtr						
Agitators in line 15						
Vac. Clrs	110	111	112	113	Pre Cond pumps I / One	
Vac	235	41m	320	270	181 Ready	
Amps	22.1		17.5	20.0	182 ? Running	
ΔT °C					183 ?	
Belt Filters in operation			* B/F - A, B, C, D Running			
Readiness / Limitations :						
* B/F - E under washing						
* B/F - F not ready.						
* B/F - G u/m.						
Evaporators in operation / FSA			* Ev - A, C, G under prod.			
Readiness / Limitations : * Ev - D (SATW) 50/50 under circulation.						
Tanks	Lvl	Transfer to DAP		Process Water Cons (Avg m <sup>3</sup> /hr) 300 m <sup>3</sup>		
411	100	WA (O)	630	Gypm pond Lvl (O/N) : 128 / 185		
412	100	WA (N <sub>1</sub> )	663 (6.2%)	Gypm p/p i/l : 291		
413	76	WA (N <sub>2</sub> )	-	HW/CW p/ps i/l : 5/4		
414	95	WA (N <sub>3</sub> )	-	Pond rtn p/ps : (O/N) 173 O/N		
Pump Tk.	90	S (O)	-	Guard Pond Level : 1.7 mtr		
FSA Tk. A		S (N)	-	C. T. Make - up Water : pond water.		
B						

Rock feeding / 100% per / gate no - 12 / by gravity / 1039  
 conveyor 1030 belt damaged portion cutting done  
 & new belt of same length joint done. Trial  
 taken. ok.

Jordan rock unloading started at 8:00 pm in 1038  
 site

B/M-A feed spool leak attended. / MS7 pump common dis. line  
 has leak / shell naxax belt has leak

P-021 B dis. reducer leak attended.

P-021 D has gland leak.

P-031 gland leak attended & dis. 7-piece leak attended.

B/M-C w/a gate opened.

PLC having some instrument problem. pressures not  
 showing healthy.

Reactor feed pumps pushing feeder valve is very  
 hard

### Reactor

\* VIC-110 running without MP steam.

\* VIC-111 sup<sup>o</sup> reducer & dis. bellows positioned, bolts  
 to be fitted & bolted.

\* VIC-113 pump pulley got damaged.

\* P-120 A to be made ready.

### B/F B/M's

\* B/F-A cloth to be changed. / \* B/F-B but tracking up.

\* B/F-D Gyr. kopper oil has hole.

\* B/F-E P.250-251 E common dis. line has flange leak.

\* B/F-F R/A downcomer pipe changing job up.

\* P-240 C casing has pin hole.

\* P-298 G-box motor changed, running

\* Old pond P-M-04 cable conn pending.

### Evap's

\* P-340 H dis. topism reducer to be changed.

\* P-310 B coupling pending. / vortex breaker to be repaired.

\* Ev-E dis. leak metal work done. Rubber lining pending.

\* P-390 gland leak attended.

\* P-443 has gland leak.

\* P-413 gland leak attended.

\* T-416 dis. elbow has hole.

\* T-411 VSD belt to be changed.

\* P-496 alignment coupling done & lined up for CA. 75.

\* P-310 T gland leak to be attended.

\* P-621 casing cover & impeller taken out.

\* WWS cleaning up in old storage area.

SIC

*(Signature)*

Dy. General Manager (PAP)