

Lime Activation & Conveyor(s) Procedure

Press Conveyor System

Conveyors #A, #B, #C, and #D are controlled individually using the Main (ECC) or Remote (Press Panel Misc) PLC touch screen and move the sludge from the presses into the Pugmill

Conveyor #A

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located at Press Conveyor Disconnect Panel – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Press conveyors screen
 - Conveyor #A Start button – **ON**

Conveyor #B

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located at Press Conveyor Disconnect Panel – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Press conveyors screen
 - Conveyor #B Start button – **ON**

Conveyor #C

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located at Press Conveyor Disconnect Panel – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Press conveyors screen
 - Conveyor #C Start button – **ON**

Conveyor #D

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located at Press Conveyor Disconnect Panel – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Press conveyors screen
 - Conveyor #D Start button – **ON**

Pugmill

- Visually check Pugmill for obstructions or hazards prior to starting
- Main power disconnect located at Press Conveyor Disconnect Panel – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Press conveyors screen
 - Pugmill 1 Start button – **ON**
 - Pugmill 2 Start button – **ON**

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Lime Screw

- Visually check Lime Screw is clear of obstructions and hazards prior to starting
- Main power disconnect located at Press Conveyor Disconnect Panel – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Press conveyors screen
 - Lime Screw Start button – **ON**

Lime Screw Speed Controller

Lime Speed Controller is located on the Press Panel Misc; and is adjusted to obtain desired, final product, pH based on permit requirements

- Lime Speed Controller – **ADJUSTED**

Lime Vibrator

Lime Vibrator On/OFF switch is located on the Solids Handling Building side of Press #1(upper level) and provides power to the Lime Vibrator Control Box

- Power switch – **ON**

Lime Vibrator Control Box

(Lime Vibrator Control Box located at the bottom of the lime silo)

- Power switch – **ON**
- Range Control – **0 –10 NORMALLY 5**

Dryer Conveyor System

Conveyors #0, #1, #2, #3, #4, #5, #6, #7, and #8 are controlled individually using the Main (ECC) or Remote (Press Panel Misc) PLC touch screen and move the sludge from the Pugmill through the Dryer system out to the final pile

Conveyor #0

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located in ECC – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Dryer conveyors screen
 - Conveyor #0 Start button – **ON**

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Conveyor #1

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located in ECC – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Dryer conveyors screen
 - Conveyor #1 Start button – **ON**

Conveyor #2

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located in ECC – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Dryer conveyors screen
 - Conveyor #2 Start button – **ON**

Conveyor #3

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located in ECC – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Dryer conveyors screen
 - Conveyor #3 Start button – **ON**

Conveyor #4

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located in ECC – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Dryer conveyors screen
 - Conveyor #4 Start button – **ON**

Conveyor #5

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located in ECC – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Dryer conveyors screen
 - Conveyor #5 Start button – **ON**

Conveyor #6

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located in ECC – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Dryer conveyors screen
 - Conveyor #6 Start button – **ON**
 - Belt speed can be adjusted with VFD located on main disconnect

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Conveyor #7

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located in ECC – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Dryer conveyors screen
 - Conveyor #7 Start button – **ON**
 - Belt speed can be adjusted with VFD located on main disconnect

Conveyor #8

- Visually check conveyor for obstructions or hazards prior to starting
- Main power disconnect located in ECC – **ON**
- Using the Main or Remote PLC touch screen – **Select Press Convoys Screen**
- Dryer conveyors screen
 - Conveyor #8 Start button – **ON**
 - Belt speed can be adjusted with VFD located on main disconnect