

Acme Coke
11236 S. Torrence Ave.
Chicago IL 60617



acmecoke.com

Document archive

Lidman Training Guides
Dated: 1996

Recovered from site on July 4 2020

Training Guide
3-25-96
Lidmen Work Procedures

1. Opening Ovens

- a. Lidmen is to verify pushing and charging schedule with the Charging Shift Manager prior to start of shift.
- b. Lidmen will pull down damper arms on ovens to be pushed and charged as indicated on pushing schedule.
- c. Lidmen will insert side steam pipe into standpipe with cross "T" in direction desired. (Make sure your face shield is in place, hot gases and flames could escape from side steam opening).
- d. Lidmen will open Riser Cap, then using lid bar tap center charging lid to relieve pressure and decrease popping, then remove lid slowly. Be aware of wind direction when pulling off lids.

2. Cleaning Goosenecks

- a. Insert sizing disc into gooseneck opening, move disc towards back of gooseneck. Pull disc back towards you, turn disc 1/4 turn and repeat 3 times. If sizing disc will not go into back of gooseneck lidmen is required to do one of the following.
 1. Waterblast gooseneck.
 2. Chip gooseneck with chipping gun.
 3. Chip gooseneck with air knocker.After gooseneck has been cleaned, disc should move freely all the way to the back of the gooseneck.
- b. Inspect gooseneck liquor spray pattern, if spray is plugged or pattern is abnormal notify your Supervisor.

3. Reaming Steam Jets

- a. Be sure aspiration steam is off before removing steam plug.
- b. Remove aspiration steam plug with wrench.
- c. Insert reamer, turn as reamer advances thru back of steam jet.
- d. Remove reamer when steam jet is cleaned.
- e. Replace steam plug and tighten with wrench.

4. Cleaning Standpipes

- a. Inspect Standpipe from Collector Main area, Remove fluff carbon and excessive carbon build up with 16' air lance. If Standpipe requires decarbonizing notify Supervisor immediately

5. Inspecting All Charging Holes

- a. Direct side steam pipe to blow up on oven, turn on steam
- b. Inspect all charging holes for excess carbon.
- c. Remove carbon with chipping bar or lid bar.
- d. If charging hole is plugged use air lance to unplug.
- e. Turn steam off and remove blow pipe, use a small piece of Kao-wol to cover side steam plug opening, close side steam plug and tap with a lid bar to insure a good seal which will prevent any emissions from escaping.

6. Sweeping Battery Top

- a. Have proper tools, a good broom and shovel, wheelbarrow.
- b. Sweep all loose coal and debris on battery top between standpipe and along Larry car rails into piles near lids of ovens to be pushed and charged on your pushing schedule.
- c. Sweep up coal spillage under charging bins. (Be aware of Larry Car movement at all times, Notify Larry Car operator when attempting to clean under coal bins.)

LIDMEN- RESPONSIBILITIES AND WORK PRACTICES

1. Stay Alert to the movements of the Larry Car. Never stand between the stand pipes as the Larry Car passes. SAFETY dictates you be on the West Side of the battery.
2. At the start of the shift, insure you have the proper tool needed to do your job. Inspect the tools for serviceability. Notify your SUPERVISOR of any missing or defective tools. (Brooms, Lidbars, Dippers, Steam plug wrench and Reamer, Disc. On the collector main you should have a 50' air hose and 16' air lance in each section.
3. Ovens are normally pushed in series of Five, at the start of the shift the first series to be pushed shall be dampered off and the lids removed as necessary.
4. Steam jets shall be reamed on the ovens to be pushed, and also the assist oven to be used.
5. The Goosenecks shall be cleaned. The Disc (sizing tool) shall be inserted into every Gooseneck and must hit the damper pan. If this cannot be done, the Gooseneck must be Waterblasted or chipped until the disc will fit. The Gooseneck Liquor Spray shall be inspected for proper spray pattern. Any unacceptable spray pattern must be reported to your Supervisor.
6. The Standpipe shall be Inspected and cleaned as necessary to assure at least a 10" opening. Side steam must be inserted into the standpipe blowing down in order to safely inspect and clean the standpipe.
7. All Lids will be removed from the oven to be charged. The charging holes will be inspected and cleaned as necessary, this is to include the holes used for the u-tube.
8. Prior to the Larrycar moving into position to charge the oven. The charging steam of the assist oven shall be turned on, and then the west lid of the assist oven shall be removed. Set the u-tube in position.
9. After the oven is charged, leveled, and the chuck door is closed the Larrycar east drop sleeve shall be raised and the lidmen will replace the east charging hole lid immediately.
10. The center charging hole drop sleeve is raised, and the lidmen will replace the center charging hole lid next.
11. The west charging sleeve shall be raised and the lid replaced before the Larry Car begins to travel to the coal bins. Raise the u-tube and move it to one side replace both lids on the 4th holes.
12. All loose coal shall be swept into the charged oven through the charging hole one at a time. Only ONE Lid can be off at a time. Loose coal shall be swept from Toe Plate to Toe Plate and Rail To Rail.

13. All three charging hole lids and the 4th hole lids will be sealed with slurry. Then the charging steam valves of the charged oven and assist oven will be turned off. (steam removed from ovens)

14. After the series is completed, you will again check the Charging Steam Valves of the ovens charged and the assist ovens to insure that all steam has been removed from the ovens.

15. There are general precautions to be aware of i. e. When inspecting and cleaning uptakes always insert side steam blowing down. Always use platforms to inspect uptakes. Assume all iron work is hot, assume all tools are hot, lid bars, steam plug wrench, stem jet reamer, and steam plug. Always use a stand when cleaning goosenecks, waterblasting, and chipping. Stay upwind of fire from open charging holes and open standpipes. The heat escaping from the open charging holes of pushed ovens is as hazardous as the fire from ovens not yet pushed. Do not stand above pusherside doors being removed.

16. Drink plenty of liquids during the Summer and on HOT days. Giving your body plenty of fluids will prevent over heating problems.

17. The proper amount of clothing must be worn to provide adequate insulation from the heat. Special consideration must be paid to protecting your feet, extra socks should be worn, wooden shoes are available if needed.

18. All regular safety equipment must be worn at all times. It is YOUR responsibility to insure your safety items are in good condition and replaced when necessary.

19. Safety items such as monogoggles and wooden shoes are available upon request.

THIS IS NOT A COMPLETE SUMMARY OF YOUR JOB DESCRIPTION. IF YOU HAVE ANY QUESTIONS CONSULT YOUR SUPERVISOR .

Employee Name _____

Date Completed _____

Clock Number _____

Supervisor _____