

HAZOP example – output

Guide Word	Deviation	Possible Causes	Consequences	Action Required
NONE	No flow	No hydrocarbon available from storage Transfer pump fails (motor fault, loss of power, impeller corroded etc.)	Loss of feed to reactor. Polymer formed in heat exchanger As above	1) Ensure good communication with storage area 2) Install low level alarm on settling tank Covered by 2)
MORE	More flow More pressure More temperature	Level control valve fails to open, or LCV bypassed in error Isolation valve or LCV closed when pump running High intermediate storage temperature	Settling tank overfills Line subjected to full pump pressure Higher pressure in transfer line and settling tank	3) Install high level alarm 4) Check size of overflow 5) Establish locking-off procedure for LCV bypass when not in use 6) Install kickback on pumps 7) Install warning of high temperature at intermediate storage

Hazop Analysis For Distillation Column

**Dipesh Shikchand Patle, Gade Pandu
Rangaiah**

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