

### HAZOP on Distillation column

Guide word	Deviation	Possible causes	consequences	Action record
No	No flow	<ul style="list-style-type: none"> <li>• Pipe blockage</li> <li>• Control valve shut</li> <li>• Valve fail</li> <li>• Pump failure</li> <li>• Tube blockage and leakage</li> </ul>	<ul style="list-style-type: none"> <li>• Column dry out</li> <li>• Possible dangerous concentration</li> <li>• No operation</li> </ul>	<ul style="list-style-type: none"> <li>• Install low level alarm</li> <li>• Check maintenance</li> <li>• Make bypass</li> <li>• Emergency plant shut down</li> </ul>
Less	Less flow	<ul style="list-style-type: none"> <li>• Pipe blockage</li> <li>• Control valve shut</li> <li>• Valve fail</li> <li>• Pump failure</li> <li>• Tube blockage and leakage</li> </ul>	<ul style="list-style-type: none"> <li>• Changes in product quality</li> </ul>	<ul style="list-style-type: none"> <li>• Install low level alarm</li> <li>• Check maintenance</li> <li>• Make bypass</li> <li>• Emergency plant shut down</li> </ul>
More	More flow	<ul style="list-style-type: none"> <li>• Control valve is fully opened</li> <li>• Increase pumping capacity</li> <li>• Control valves failure</li> </ul>	<ul style="list-style-type: none"> <li>• Flooding in the column</li> <li>• Change in product quality</li> <li>• Rise in bottom</li> <li>• Temperature increases</li> </ul>	<ul style="list-style-type: none"> <li>• Install high level alarm</li> <li>• Install control</li> <li>• Check maintenance</li> </ul>

# Hazop Analysis For Distillation Column

**Scott C. Dulebohn**



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