

VINYL - P. E. Markey/M. L. Nathan

Safety

The Vinyl and Yard Departments operated without an injury during October.

Shift safety meeting topics included: "Chainsaw Safety" for all shifts; and "Forktruck Training" which included classroom as well as field training for two Vinyl/Yard shifts. The remaining two shifts will be trained in early November.

A meeting was held with all vinyl shift supervisors to discuss the 1984 Safety Program. A safety audit checklist for each operator classification was prepared and implemented during the month.

<u>Production</u>	<u>October</u>	<u>Y.T.D.</u>
1. Production, MM Lbs.	32.8	325.2
2. Daily Production Rate, M Lbs./C.D.	1057.4	1068.5
3. Total Charges	776	7782
4. Charges, Reactor Batches/C.D.	25.0	25.6
5. Reactor Stream Factor	77.5	82.9
6. Dryer Rate, Average Lbs./Hr.	7851	7182
7. Dryer Stream Factor	62.4	68.9
8. Accounting Days	31	304

Production

Vinyl Department production for October was 32.8MM pounds which was 95.3% of the budgeted production volume.

Reactors

1. The new module was down from 10/22 until the end of the month for inventory control. During this shutdown, capital project work and various other maintenance items including eighteen valve changeouts were performed. The resulting stream factor penalty was 16.6%.
2. Replacement of D-600 agitator seal **resulted** in a 0.19% reactor stream factor penalty.
3. Reactor jacket welds on D-743 and D-700 reactors resulted in a stream factor penalty of 0.83%.
4. Two valve changeouts and maintenance on reactor valves during normal production periods resulted in a stream factor penalty of 0.19%.

VINYL - ContinuedReactors - continued

5. Miscellaneous maintenance items including D-600 steam eductor cleaning, D-500 safety disc changeouts, and D-300 agitator coupling changeout resulted in a reactor stream factor penalty of 0.4%.
6. Downtime, due to recovery system scheduling conflicts, resulted in a stream factor penalty of 2%.
7. Downtime due to pluggage of the old module slurry dump line resulted in a stream factor penalty of 0.78%.

Dryers

1. Production was essentially reactor limited in October. Dryers were shut down as needed for energy conservation purposes. The associated stream factor penalty was 22.2%.
2. Dryer downtime, due to a shortage of material as a result of the new module shutdown, contributed 13.5% to the monthly dryer stream factor penalty.
3. Dryer downtime, due to a shortage of material as a result of pluggage in the old module slurry dump line, contributed 1.39% to the monthly dryer stream factor penalty. During this period, the fluid bed dryer was cleaned.
4. Routine dryer cleaning resulted in a stream factor penalty of 0.75%.
5. Dryer centrifuge pluggage resulted in a stream factor penalty of 0.39%.
6. Downtime due to bottlenecks in the sifter and pneumatic transfer systems resulted in a stream factor penalty of 0.52%.
7. Downtime, due to dryer burner flameouts, resulted in a stream factor penalty of 0.24%.
8. Maintenance on dryer centrifuges, sifters, activators, etc. resulted in a stream factor penalty of 0.57%.

VINYL - ContinuedProduct Quality Summary

<u>Resin Type</u>	<u>Prime</u>	<u>"BC"</u>	<u>"H"</u>	<u>% of Total Production</u>	<u>Budgeted Prime Product Mix %</u>
5265	2,154,432	49,150	-	6.7	12.5
5305	2,291,896	-	-	7.0	11.25
5385	21,625,644	-	-	66.1	57.5
5425	5,194,156	-	-	15.8	13.75
5465	1,398,400	-	-	4.2	5.0
Sifter Overflow	-	-	66,845	0.2	-
Pond Resin	-	-	-	-	-
TOTAL	32,664,528	49,150	66,845	100.0	100.0

Quality performance for October was 99.7% customer grade with 0.1% "BC" production and 0.2% "H" grade.

A total of four railcars were shipped as off-grade during the month which represented 4.16% of the 96 total resin hopper cars shipped.

<u>Ship Date</u>	<u>Car No.</u>	<u>Customer</u>	<u>Product</u>	<u>Reason</u>
10/18/83	CONX 45293	Continental Plastics	Resifted Sifter Overflow	Quality
10/25/83	PTLX 41589	Continental Plastics	Resifted Sifter Overflow	Quality
10/25/83	PTLX 41632	Continental Plastics	Resifted Sifter Overflow	Quality
10/31/83	PTLX 41650	Continental Plastics	Resifted Sifter Overflow	Quality

The vinyl area received thirty-three short lead time emergency type orders comprising 16.0% of the 206 Aberdeen resin shipments in October.

Monthly Variable Cost Performance

Variable costs for the month were favorable \$958.3M with \$702.5M due to price and \$255.8M due to efficiency. Resin variable cost for the month was 22.329 ¢/lb. vs. the budgeted 25.258 ¢/lb.

VINYL - ContinuedMonthly Variable Cost Performance - Continued

The \$702.5M favorable price variance was primarily attributable to lower than budgeted pricing for VCM, \$328.5M; lower than budgeted pricing for VCM freight, \$257.8M; lower than budgeted pricing for Lupersol 223 initiator, \$41.8M, and lower than budgeted pricing in the utilities area, \$59.5M.

The \$255.8M favorable efficiency variance can be attributed to favorable variances of \$74.1M in VCM efficiency, \$84.6M in the utilities area, \$25.2M due to deviation from the budgeted product slate, and \$72.7M due to lower than budgeted off-grade production.

VCM efficiency for the month was 1.00199 lbs. VCM/lb. PVC vs. the budgeted 1.01277 lbs. VCM/ lb..PVC. Year-to-date VCM efficiency is 1.00466.

Year-to-date variable cost efficiency variances in the Vinyl Department totaled \$1.75MM favorable.

Energy Performance/Progress

1. Plant energy consumption for the month was 2474 BTU/lb.
2. A total of thirty-five steam leaks and six air leaks were repaired in the plant during October. Seven steam traps were also replaced.
3. The recently installed cold water rinse project was started up in October. The project is expected to save 6MMM BTU/yr in energy usage.

General

1. Packaging for the month was 795,375 pounds.
2. Research and PED support were on hand during the month for additional production trials of a new chain transfer agent (CTA) for use in low molecular weight resin production. Some problems were encountered with poor particle size distribution in the experimental resin production. This completed the first phase of the test program with additional plant runs scheduled for November.
3. Resin raw material inventory in the 744 account totaled \$187.1M at month end.
4. A total of three coarse batches were produced during October. Two of the batches were associated with the new chain transfer agent (CTA) test run and the third was caused by a faulty colloid addition valve on 744 reactor.
5. Ken Taylor with Management and Training Systems was in the plant during October to conduct a training needs survey in the vinyl area. The purpose of the survey was to identify any training deficiencies and define a training program for all Vinyl/Yard Department operations personnel. The plant has received a copy of the training audit along with a proposed operator training program. This contractor was used with a high degree of success at the Lake Charles LAB plant.