

CKR INDUSTRIES, INC.
Winchester, TN
Long Range Compound Forecast (pounds/week)

02-Jun-89
04:44 PM

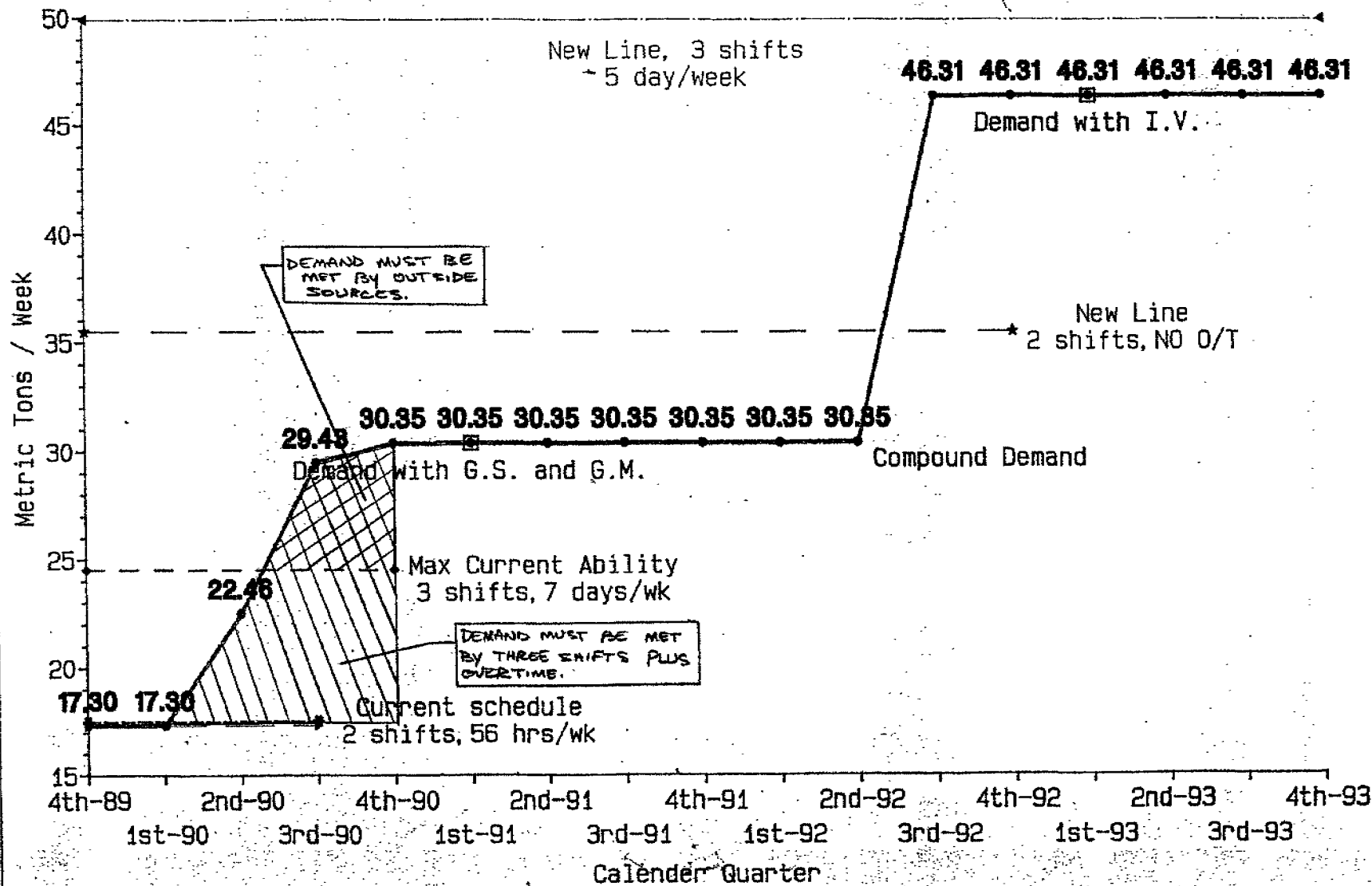
VINYL	1st Qtr 1989	2nd Qtr 1989	3rd Qtr 1989	4th Qtr 1989	1st Qtr 1990	2nd Qtr 1990	3rd Qtr 1990	4th Qtr 1990	1st Qtr 1991	2nd Qtr 1991	3rd Qtr 1991	4th Qtr 1991	1st Qtr 1992	2nd Qtr 1992	3rd Qtr 1992	4th Qtr 1992
Nissan	6,836	6,836	6,836	6,836	6,836	6,836	6,836	6,836	6,836	6,836	6,836	6,836	6,836	6,836	6,836	6,836
Honda	8,342	8,342	12,000	12,000	12,000	12,000	12,000	12,000	12,000	12,000	12,000	12,000	12,000	12,000	12,000	12,000
ASC	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
SIA	0	0	0	2,182	2,182	2,182	2,182	2,182	2,182	2,182	2,182	2,182	2,182	2,182	2,182	2,182
Inland	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Totals	15,178	15,178	18,836	21,018	21,018	21,018	21,018	21,018	21,018	21,018	21,018	21,018	21,018	21,018	21,018	21,018
Tons/mo.	27.3	27.3	33.9	37.8	37.8	37.8	37.8	37.8	37.8	37.8	37.8	37.8	37.8	37.8	37.8	37.8

RUBBER	1st Qtr 1989	2nd Qtr 1989	3rd Qtr 1989	4th Qtr 1989	1st Qtr 1990	2nd Qtr 1990	3rd Qtr 1990	4th Qtr 1990	1st Qtr 1991	2nd Qtr 1991	3rd Qtr 1991	4th Qtr 1991	1st Qtr 1992	2nd Qtr 1992	3rd Qtr 1992	4th Qtr 1992
Nissan	26,177	26,177	26,177	26,177	26,177	26,177	41,549	41,549	41,549	41,549	41,549	41,549	41,549	41,549	41,549	41,549
Honda	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
ASC	1,265	1,265	1,265	1,265	1,265	1,265	1,265	1,265	1,265	1,265	1,265	1,265	1,265	1,265	1,265	1,265
SIA	0	0	0	3,060	3,060	3,060	3,060	3,060	3,060	3,060	3,060	3,060	3,060	3,060	3,060	3,060
Inland	0	0	0	7,680	7,680	19,000	19,000	21,010	21,010	21,010	21,010	21,010	21,010	21,010	21,010	21,010
Webasto																
Magna																
Totals	27,442	27,442	27,442	38,182	38,182	49,502	64,874	66,884	66,884	66,884	66,884	66,884	66,884	66,884	66,884	66,884
Tons/mo.	49.4	49.4	49.4	68.7	68.7	89.1	116.8	120.4	120.4	120.4	120.4	120.4	120.4	120.4	120.4	120.4
** Total	42,620	42,620	46,278	59,200	59,200	70,520	85,892	87,902	87,902	87,902	87,902	87,902	87,902	87,902	87,902	87,902

CHARDO 02101

CKR INDUSTRIES, INC.

Mill Room
Metric Tons/Week



CHARDO 02102

stabilizing
CPG-1



Tom Judy
John Thomson

1-24-96

3268

3260

1.565

1.445

Better Running

Stability - Possibly

Schulman

50 ft. min. SCREW 75 RPM

Pc .40 Kg

3260 - 3 way Blend

Temp. Chry down

28 Min 90 RPM

P. 45 Kg.

- Analysis -

Stability etc. weak in Part ? - Jim - Hoag -

Oxy 240 Prim. for 1st

Used 60,000 1.1000 80000 oxy been on going

Bernie Cook
Robert Scott

PVC Consultant
Plant Mgr

Jon Thorne
Tom Judy
Jim Hacy
Mr. Otoni
Dick Z
Jan 25

7. Have Occidental compare V-3260 to 3268

~~2. With attempt to match Schulman compound. Quality and Cost~~
Mr Otoni

Mixing Notes

V Procedures

2. Mixing Temp. - Low - Kingman Higher

Cooling - 2. Cooling. Batches not separate

Pelletizing - 1. Cooling Tank

2. Extrusion Temp.

Blending - of material - Virginia and OR Pellet's

CRB blend and it runs consistent

Should Get Formal Approval Per Mr. Otoni or Jon Thorne
2 weeks of Nissan after data. One month total

Jon Thorne and Tom Judy

Schulman Foster, Vol. Cost, consistent

Rubber Gait - Stone Skids

1.4% will Run scrap

Volume

Jan. 25, 1990

3268 CPS-1 Runs Better, CPS-1 is stabilizer

3260 No CPS-1 - Poorer stability causing variation?

Check Heat stability @ 350°F 3260 vs 3268 vs Schulman

✓ Occidental Analyzing Schulman. Should have Chardon ³²⁶⁰ Analysis.
+ Brookender tests complete. waiting for report.

Color can be problem (More Dense, darker) with Lower Sp.Gr
* Schulman material. May need rematch on some colors even if chardon match.
Schulman: 7069-E-01

● Will attempt to match Schulman based on analysis and lab tests

Oxy 240 has been the main resin since CKR compounds conceived. Only resin in CKR. May have used some Borden or Vygon in past. At least six months on oxy 240 only. All other materials also single source.

TRY - V OXY 250 resin

5/ Stabilizer System

2/ TEP for chlorowax

3/ Process Aids for internal Lubes

4/ Lower Gravity

Letter from Occidental visit. and W charts
Water on screw?

Melt Flow Tester. oxy not sure how much help