

TO W. Miringoff
FROM J. T. Sweeney ✓
SUBJECT Flemington Monthly Report
April, 1981

At Piscataway
At Flemington

DATE May 1, 1981

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June 14, 1981
Burdane

HIGHLIGHTS

1. Production at 7.629 M Lbs. was 96.4% of the monthly budget, resulting primarily from delays encountered during the CBS Type 318 development program.

Initial feedback from CBS concerning the quality of the new Type 318 resin appears favorable.

2. Five rows of lifting flights were removed from the "B" Dryer to increase retention time and thus reduce the Karl Fisher water analysis on Type 315 resin. The first test run of Type 315 manufactured after the flight removal showed positive results.
3. The new overhead silo/blending installation was successfully put into service.
4. Conversion cost for April is projected at 10.09 ¢/Lb. vs. 9.52 ¢/Lb. budget.

Major elements are:

Low production	-	0.36 ¢/Lb. (1)
Fuel Oil Price	-	0.13 ¢/Lb.
Electricity Usage	-	0.18 ¢/Lb. (2)

- (1) CBS product development program.
- (2) Use of mechanical refrigeration - seasonal.

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I. PRODUCTION

- A. Production in April was 7.629 M Lbs. This represented 96.4% of the monthly budgeted rate and 93.5% of the standard production rate.
- B. Productivity delays encountered during the month were as follows:
 - 1. CBS Type 318 development program = 469 M Lbs.
This included:
 - a. Manual cleaning of all reactors.
 - b. Jet cleaning of strippers.
 - c. Plant operations involving lengthy space charging.
 - d. Type 318 formulation involving low charge H2O temperature, elimination of EHP catalyst, and reduction in Lauroyl Peroxide Catalyst.
 - 2. Removal of five rows of lifting flights in the "B" Dryer to provide more residence time in an effort to reduce the Karl Fisher water analysis on Type 315 resin = 62 M Lbs.

The above two items accounted for a total productivity delay of 531 M L

II. QUALITY

A. "RFT"

"RFT" for April was good at 94.3%.

B. Grade III Summary

Grade III production in April was 3.1% resulting primarily from system cleanouts of the new overhead silo installation.

C. Custom Relations

The Plant experienced two customer rejections in April:

- 1. Nixon - one truck - contamination.
- 2. CBS - one railcar compartment - contamination.

$$\frac{\text{Lbs. rejected}}{\text{Lbs. produced}} = \frac{0.088 \text{ M Lbs.}}{7.629 \text{ M Lbs.}} \times 100 = 1.15\%$$

III. YIELD

Yield was 96.6% vs. 97.1% standard. The lower yield resulted from the transfer of 35 M Lbs. of off-spec recovered monomer to a railcar for disposal.

IV. OVERTIME

Controllable overtime in April was high at 23.9%. Vacation Coverage, absenteeism, job vacancy coverage, training and special testing work for the CBS program were the main factors.

V. GENERAL OPERATIONS

A. Reactor Building VCM Level

Reactor Building VCM level for April was low at 0.3 ppm.

B. Safety

1. OSHA Days Away from Work Cases = 0
2. OSHA Restricted Duty Cases = 0

The Plant has now worked 528 consecutive days without a lost time injury.

C. Expansion

1. The overhead silo installation was put into operation early in the month; however, several open items remain to be completed on this project.

During initial operation it was discovered that it was not possible to feed both drying systems into a single overhead silo as originally engineered. The absence of this mode of operation considerably reduces the flexibility of the overhead silo installation. The problem appears to be caused by inadequate air venting capacity. Engineering is currently investigating a method to correct this problem.

2. Installation of new slurry electromagnets and centrifuge feed pumps is nearing completion.

D. "B" Dryer Revision

Several rows of lifting flights were removed from the "B" Dryer in an effort to provide more retention time and thus reduce the water content of the resin. Preliminary Type 315 tests conducted after completion of the flight removal produced Karl Fisher residual water results of 0.06 - 0.09%, well within the critical Keysor specification of 0.15%. This project is receiving high priority with further testing currently being implemented.

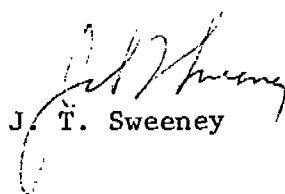
E. PERSONNEL

1. Mr. J. Sapienza, Reactor Operator, was promoted to Poly Foreman.
2. Mr. D. Hutchins, Poly Foreman, resigned to take a position in a family business.
3. Mr. J. Barboni was hired as Reactor Operator.
4. Mr. J. Trimmer, Storekeeper, resigned effective May 1, 1981.

VI. SUMMARY - Attached.

VII. CAPITAL SPENDING STATUS REPORT - Attached.

VIII. MANUFACTURING COST PROJECTION - Attached.


J. T. Sweeney


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JTS/DMH/jmk