



ESCAMBIA PLANT
INTEROFFICE MEMORANDUM

To: Mr. R. E. Davis

Date: October 5, 1972

From: E. A. Primeau

Copies:

Re: PVC Monthly Report
September, 1972

SUMMARY

Prime production for September was 5,015M lbs. versus a budget of 4,929M lbs. and a September 20 forecast of 5,100M lbs. Off-grade, tailings and sweeps amounted to 77M lbs. which represents 1.5% of total production versus a budget of 5.2%. A total of 577 charges were made, an average of 19 per day.

The variance generated by PVC for September is (\$4,365) unfavorable. The variance resulted from:

1. PVC Bulk (\$5,332)
2. PVC Packaging 967

The forecast variance on September 20 was \$16,500 favorable. The items affecting the variance are as follows:

	<u>Forecast</u>	<u>Actual</u>
Raw Material	\$ -	(\$8,388)
Process Costs	8,100	537
Volume	8,200	4,919
Machine Hours	(2,400)	(2,400)

Analysis of Variance

Raw materials were unfavorable because of the low production of off-grade resin (77M lbs. vs. 270M lbs. budgeted) resulting in less by-product credit.

Process costs were at budgeted level being \$500 favorable.

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The volume variance of \$4.9M was due to production of 86M lbs. of prime resin above budget.

Machine hour variance of (\$2,400) unfavorable is due to the 30-day month.

October production is projected to be 5,300 M lbs. and variance is expected to be \$3,000 favorable.

DISCUSSION

During September, eight resin types were produced. Two types, 1230-P and 2200, accounted for 70.6% of the prime production. Average number of charges per day was 19. The 1230P production was 1,929 M lbs. produced in 208 batches. Average yield was 642 lbs./hr. versus a budget of 579 lbs./hr. Only minor contamination problems occurred during the month resulting in the production of no off-grade resin.

The Quality Control Laboratories continued their control analyses using inherent viscosity as part of the product unification program. The initial problems with technique were resolved and the results are within normal analytical precision.

The request for the replacement stainless steel reactor, agitator and drive was approved and the equipment ordered. Expected delivery date is January 15, 1973, and installation by mid-February 1973.

The Alpine mill operated 159 hours on overtime this month to produce fushion-grade resin.

All but two of the 11 reactors were solvent cleaned this month. Shutdowns every two to three days were necessary on the Artisan unit to keep it operable. However, sufficient clean solvent was produced to continue the cleaning program.

After reviewing the pilot plant studies made by Artisan, it was recommended to make a plant test run using M-pyrol (N-methyl pyrrolidone). The recommendation was approved and 6000 gallons of M-pyrol was ordered and received on September 28. Test runs using M-pyrol have been scheduled during October.

A program to test EDTA in the 1230-P charges to reduce reactor fouling was started the last week of September. Initial results show a marked reduction in fouling. This work will continue in October.

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STATISTICS

	<u>September</u>		<u>Year to Date</u>	
	<u>Actual</u>	<u>Budget</u>	<u>Actual</u>	<u>Budget</u>
Prime Product				
Homopolymer	5,015	4,269	54,498	51,970
Copolymer	0	660	6,429	8,030
Subtotal	5,015	4,929	60,927	60,000
Off-grade				
Homopolymer	0	-	840	-
Copolymer	0	-	504	-
Tails	59	-	1,065	-
Sweeps	18	-	98	-
Subtotal	77	270	2,507	3,291
Total Production	5,092	5,199	63,434	63,291
Off-grade, % of total prod.	1.5	5.2	4.0	5.2
Bulk Production, % Prime	60.0	-	53.0	-
VCM Efficiency, %	92.0	94.8	94.0	94.8
Reactor Availability, %	92.6	88.5	88.7	88.5
Production, #/gal. yr.	1,279	1,258	1,277	1,258
Off-Grade Analysis				
	<u>Type</u>	<u>Lot No.</u>	<u>Quantity</u>	<u>Reason</u>
	0	0	0	0
Product Sequence				
	<u>North Line</u>	<u>Batches</u>	<u>South Line</u>	<u>Batches</u>
	2200	37	1230	63
	1225	35	2160	14
	2200	78	1225	35
	8217	10	2250	20
	2200	31	1230	20
	3185	10	2225	24
	1225	26	1230	125
	2200	49		
		276		301

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Downtime Analysis

	<u>September</u>		<u>Year to Date</u>	
	<u>Hours</u>	<u>%</u>	<u>Hours</u>	<u>%</u>
Cleaning Reactors	640	8.1	7,021	7.3
Schedule Charges	157	2.0	2,455	2.6
Behind on Recovery	145	1.8	1,456	1.5
Hold to Drop	105	1.3	383	0.4
Plugged Drop Valves	20	0.3	290	0.3
Change Types	14	0.2	660	0.7
Slow Drying	31	0.4	452	0.5
Hydraulic Motor Maint.	25	0.3	259	0.3
Miscellaneous	86	1.1	1,572	1.6
	1,223	15.4	14,548	15.1

Production Summary

<u>Type</u>	<u>August</u>	<u>September</u>	<u>Year to Date</u>
1185	0	0	48
1200	0	0	2,173
1225	759	878	9,599
1230P	2,752	1,945	18,328
1250	0	0	1,241
2160	0	107	1,181
2185	0	0	1,209
2200	1,014	1,635	14,726
2225	216	191	1,631
2250	550	155	5,458
3185	0	72	996
6150	0	0	6,429
8217	0	91	317
Floor Sweeps		18	98
		5,092	63,434

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Personnel

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