

VINYL - D. W. Hollis/M. L. NathanSafety

The Vinyl and Yard Departments operated without an injury in June.

Shift safety meeting topics for the month included annual VCM Health Training, Noise Safety and Asbestos Training.

<u>Production</u>	<u>June</u>	<u>Y.T.D. (Fiscal 1985)</u>
1. Production, MM Lbs.	28.8	309.2
2. Daily Production Rate, M Lbs./C.D.	960.3	1132.8
3. Total Charges	726.0	7546.0
4. Charges, Reactor Batches/C.D.	24.2	27.7
5. Reactor Stream Factor	78.0	89.1
6. Dryer Rate, Average Lbs./Hr.	7443.0	9685.0
7. Dryer Stream Factor	67.2	62.3
8. Accounting Days	30	273

Vinyl Department production for June was 28.8MM pounds which was 103% of the Business Area's targeted level of 28.0MM pounds.

Reactors

The reactor stream factor for June was 78.0%. Downtime in the reactor area occurred as follows:

- 1) Operational Downtime: Accounted for 89.9% of the total downtime and was due to reactor scheduling conflicts, no place to dump reactor slurry, downtime due to severe weather conditions, and a planned outage in the old module for inventory control purposes. The plant took advantage of the outage to complete shutdown type maintenance work. All old module reactors were hydroblasted and dye checked. The old module reactor condensers were also chemical cleaned.
- 2) Maintenance Service Downtime: Accounted for 1.3% of the total downtime and was due to cleaning reactor AMS injection ports and slow vent lines.
- 3) Maintenance Repair/Revision Downtime: Accounted for 8.8% of the total downtime and was due to nine reactor valve changeouts, agitator seal replacement on 500, condenser cleaning on 744, and cooling water jacket repairs on 743 and 744.

Dryers

The dryer stream factor for June was 67.2%. Downtime in the dryer area occurred as follows:

- 1) Reactor Limited Production: Accounted for 80.6% of the total downtime. Dryers were shut down when possible for energy conservation. The fluid bed dryer was shut down in conjunction with the old reactor module outage.

VINYL - Continued

Dryers - continued

- 2) Operational Downtime: Accounted for 12.0% of the total downtime and was due to centrifuge plugging, burner flameouts, dryer cleaning, transfer activator problems, and downtime due to power outages.
- 3) Maintenance Repair/Revision Downtime: Accounted for 7.4% of the total downtime and was due to activator, centrifuge and screener repairs. The fluid bed dryer hot water panels were reinstalled during the month.

Product Quality Summary

<u>Resin Type</u>	<u>Prime</u>	<u>"BC"</u>	<u>"H"</u>	<u>% of Total Production</u>
5265	1,727,791	-	-	6.0
5305	4,589,950	-	-	15.9
5385	14,388,501	388,390	-	51.3
5425	5,467,988	-	-	19.0
5465	1,597,010	-	-	5.5
Debox	-	507,500	-	1.8
Sifter Overflow	-	-	142,878	0.5
Pond Resin	-	-	-	-
Total	27,771,240	895,890	142,878	100.0

Quality performance for June was 99.5% customer grade with 0.5% "H" grade production.

A total of five railcars were shipped as "B" grade during the month which represented 4.7% of the 107 total resin hopper cars shipped.

<u>Load Date</u>	<u>Ship Date</u>	<u>Car No.</u>	<u>Customer</u>	<u>Product</u>	<u>Reason</u>
5/07/85	6/11/85	PLCX 42666	Gamma	Resifted Sifter Overflow	Quality
5/17/85	6/13/85	ERLX 6192	United Plastics	Resifted Sifter Overflow	Quality
5/28/85	6/13/85	VIPX 45833	Gamma	Resifted Sifter Overflow	Quality
5/20/85	6/13/85	PLCX 43872	Grifco	Resifted Sifter Overflow	Quality
6/11/85	6/26/85	PLWX 44292	Vulcan	Resifted Sifter Overflow	Quality

The vinyl area received sixteen short lead time emergency type orders comprising 7.5% of the 212 Aberdeen resin shipments in June.

Monthly Variable Cost Performance

Variable costs for the month were favorable at \$1167.0M with \$1262.9M due to price and (\$95.9M) due to efficiency. Resin variable cost for the month was 20.032 ¢/lb. vs. the budgeted 24.103 ¢/lb.

VINYL - Continued

Monthly Variable Cost Performance - continued

The \$1262.9M favorable price variance was primarily attributed to lower than budgeted pricing for VCM, \$1235.2M; VCM freight, \$22.8M; Lupersol 223M initiator, \$13.6M; and utilities, \$10.2M.

The \$95.9M negative efficiency variance can be attributed to unfavorable VCM efficiency, \$139.1M.

VCM efficiency for the month was 1.02841 lbs. VCM/lb. PVC versus the budgeted 1.0050 lbs. VCM/lb. PVC. Year-to-date efficiency is 1.00129.

Year-to-date variable cost efficiency variances in the Vinyl Department totaled \$681.9M favorable.

Energy Performance/Progress

1. Plant energy consumption for the month totaled 2522 BTU/lb.
2. A total of seven steam leaks and one steam trap were repaired during the month.

General

1. Packaging for the month totaled 476,678 pounds.
2. Resin raw material in the 744 account totaled \$194.0M at month end.