

INTER-OFFICE MEMO **TENNECO CHEMICALS, INC.**

TO J.T. Sweeney AT Flemington DATE October 7, 1975
 FROM W.C. Champion AT Burlington COPY TO T. Cader
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SUBJECT Testing Time -
 Flemington Quality Control Laboratory

The attached table outlines the estimated testing time distribution for the 6 Flemington hourly Quality Control technicians, on a weekly basis. This table shows a different distribution from that generated prior to start-up because of revised testing frequencies and different product distribution.

The table assumes a production rate of 6MM pounds per month with an average lot size of 52M pounds, for a total of 27 lots per week. Based upon September figures, an additional 6 lots per week are bagged and graded, for the following totals:

27 lots produced and graded/week	
20 - 315	} --based-on-September distribution
2 - 314	
4 - 391	
1 - 389	
6 lots bagged and graded/week	

33 lots graded/week
 and 30 bulk shipments/week

The figures are also based upon a reduction in contamination and magnetic particles testing from once every half hour to once per hour.

For our current staff (4 shift, 1 day, 1 4-12), we have available 217 man-hours per week, assuming 7 working hours per 8-hour shift. The current analysis shows that the proposed test frequencies can be accommodated in 210.6 hours per week, leaving 6.4 hours for special testing, retests, clean-up, etc.. Under present work schedules, however, this does not allow for release testing of bulk shipments on a weekend, which can only be handled on an overtime basis.

As we have discussed, it is desirable to have bound acetates run by the hourly technicians. This can best be done by the day man, so that the testing and results can be closely monitored. Testing of each lot produced (at 0.35 hours per test) would require 9.5 man-hours/week. Our current good control suggests, however, that a frequency of every third lot - with a time requirement of 3.2 man-hours per week - may be adequate. If you agree, we will begin training on that basis.

W.C. Champion
 W.C. Champion (jlt)

Attachment

WCC/jst

COLORITE 009872

TIME DISTRIBUTION
FLEMINGTON QC TESTING - HOURLY TECHNICIANS

TEST	UNIT TIME, HRS	FINISHED RESIN		RAW MTLs/IN PROCESS		BULK RELEASE	
		FREQ.	HRS/WK	FREQ.	HRS/WK	FREQ.	HRS/WK
RELATIVE VISCOSITY	0.7	1/LOT	23.1	-	-	1/SHPMT	21.0
VOLATILES	0.1	-	-	4/LOT	13.2	4/SHPMT	12.0
CONTAMINATION	0.1	-	-	1/LINE HR.	33.6	4/SHPMT.	12.0
BULK DENSITY	0.1	1/LOT	3.3	-	-	-	-
SCREENS	0.4	1/LOT	13.2	-	-	-	-
HEAT STABILITY	0.9	1/5 LOTS	5.9	-	-	-	-
BROOKFIELD VISC.	0.5	EA. 315	10.0	-	-	-	-
PRESSOUT FLOW	0.2	EA. 314	0.4	-	-	-	-
HARD PARTICLES	0.2	1/LOT	6.6	-	-	4/SHPMT	24.0
RECOVERED MONOMER	0.5	-	-	1/DAY	3.5	-	-
DMW CONDUCTIVITY	0.1	-	-	1/DAY	0.7	-	-
SLURRY PH	0.1	-	-	16/DAY	11.2	-	-
INCOMING VCM	0.5	-	-	1/DAY	3.5	-	-
" VACM	0.2	-	-	1/DAY	1.4	-	-
OTHER RM TESTING	2.0	-	-	PER WK	2.0	-	-
PILOT PLANT SAMPLES	2.0	5/WK	10.0				
TOTAL TIME, HRS/WEEK			72.5		69.1		69.0

TOTAL HOURS AVAILABLE	217.0
TOTAL HOURS NEEDED	210.6
NET AVAILABLE	6.4

WCC
10-7-75

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