

Oklahoma City PVC Plant
Progress Report
March, 1990

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WILLIAM L. McCLAIN

LABORATORY - R.S. Battles

A. CUSTOMER RELATIONS

Complaints:

There was one complaint in March. Cotter merchandise received one car with wet resin. The car was returned to OKC with two compartments full of wet resin.

B. RESIDUAL VINYL CHLORIDE

	<u>Shps</u>	<u>D301</u>	<u>D302</u>	<u>D303</u>	<u>D304</u>	<u>D305</u>	<u>D306</u>
Average	1.1	279	238	247	242	299	222
Std. Dev.	0.2	84	94	84	97	125	107
6-Month Avg.	1.1	315	264	271	291	274	186
Cpk	1.5	0.5	0.6	0.6	0.5	0.3	0.6
Spec Limit	2.0	400	400	400	400	400	400

C. PARTICLE SIZE ANALYSES

Shipments

	<u>40</u>	<u>60</u>	<u>80</u>	<u>100</u>	<u>120</u>	<u>140</u>	<u>200</u>	<u>PAN</u>	<u>>140</u>
Average	0.0	0.8	28.2	26.2	22.3	13.4	6.8	1.8	8.7
Std. Dev.		0.2	2.1					0.4	0.8
6-Month Avg.	0.0	1.7	29.9	26.0	20.7	12.9	6.1	1.6	7.6
Cpk								2.7	247
Spec Limit								5.0	20.0

D. MOISTURE ANALYSES (Specs: Ships .13 Max, Customers 0.30 Max)

SHIPMENTS

Average	0.09
Std. Dev.	0.01
6-Month Avg.	0.09
Cpk (internal)	1.3
Spec Limit (Internal)	0.13
Cpk (Customer Spec)	7.0
Spec Limit (Customer)	0.3

E. BULK DENSITY (Specification: 0.510 - 0.576) (Reported "As Is")

SHIPMENTS

Average	0.571
Std. Dev.	0.010
6-Month Avg.	0.564
Cpk	2.0
Spec Limit	0.510

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LABORATORY - (Cont'd)

F. INHERENT VISCOSITY (Specification: 0.895 - 0.95)

	<u>Shipments</u>
Average	0.902
Std. Dev.	0.009
6-Month Avg.	0.909
Cpk	0.3
Spec Limit	0.895

G. COLOR

Shipments:	<u>L</u>	<u>a</u>	<u>b</u>
Average	96.2	-0.3	2.2
Std. Dev.	0.6	-	0.1
4 month average	98.6	0.3	1.8
Cpk	0.00	-	0.03
Spec Limit	97.0(Min)		3.0(Max)

H. CONTAMINATION

Shipments	Black	Brown	Total
Average	9	23	32
Four Mo. Avg.	10	24	34
Cpk (Pipe)	-	-	3.6
Cpk (Siding)	-	-	1.3
Cpk (Type 1)	2.8	3.3	-
Spec Limit (Pipe)			150
Spec Limit (Siding)			75
Spec Limit (Type 1)	35	100	

Bulk density lower spec changed to .510 from .512 in December.
IV spec changed to .895 to .95 (from .90 to .95) in December.
B-color spec changed to 3.0 (from 3.5) in December.

Color procedure was modified in mid-January.

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