

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

Safety

The Vinyl and Yard Departments operated with one first aid type injury in October.

Shift safety meeting topics for the month included Fire Training. Annual field fire training exercises were conducted.

Production

October

1. Production, MM Lbs.	36.6
2. Daily Production Rate, M Lbs./C.D.	1180.5
3. Total Charges	895
4. Charges, Reactor Batches/C.D.	28.9
5. Reactor Stream Factor	90.5
6. Dryer Rate, Average Lbs./Hr.	10,300
7. Dryer Stream Factor	59.7
8. Accounting Days	31

Vinyl Department production for October was 36.6MM pounds.

Reactors

The reactor stream factor for October was 90.5%. Downtime in the reactor area occurred as follows:

- 1) Operational Downtime: Accounted for 67.1% of the total downtime and was due to reactor recovery scheduling conflicts, no place to dump reactor slurry, downtime due to a power outage and subsequent start-up on October 9, and downtime associated with BASF production run.
- 2) Maintenance Service Downtime: Accounted for 2.8% of the total downtime and was due to cleaning reactor AMS injection ports and slow vent lines.
- 3) Maintenance Repair/Revision Downtime: Accounted for 30.1% of the total downtime and was due to twelve reactor valve changeouts, agitator seal replacement on 743, steam line installation on 745 for the BASF test run, fluid coupling replacement on 600, and downtime in the old module to replace wire from transformer to motor breakers that shorted out on October 2, 1985.

Dryers

The dryer stream factor for October was 59.7%. Downtime in the dryer area occurred as follows:

- 1) Reactor Limited Production: Accounted for 89.7% of the total downtime. Dryers were shut down when possible for energy conservation.

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- 2) Operational Downtime: Accounted for 7.6% of the total downtime and was due to centrifuge plugging, burner flameouts, dryer cleaning, transfer activator problems, downtime due to power outage on October 9, and downtime on number 6, 7, and 8 rotary dryers and the fluid bed dryer as a result of a shortage in wiring between a transformer and motor breakers.
- 3) Maintenance Repair/Revision Downtime: Accounted for 2.7% of the total downtime and was due to activator, centrifuge and screener repairs.

Product Quality Summary

<u>Resin Type</u>	<u>Prime</u>	<u>"B"</u>	<u>"H"</u>	<u>% of Total Production</u>
5265	4,435,990	171,040	-	12.6
5305	2,512,300	169,860	-	7.3
5385	19,396,014	-	-	53.1
5425	5,842,128	-	-	16.0
5465	2,450,480	-	-	6.7
Debox	-	1,214,180	-	3.1
Sifter Overflow	-	-	98,604	0.4
Pond Resin	305,840	-	-	0.8
Total	34,942,752	1,555,080	98,604	100.0

Quality performance for October was 99.7% customer grade with 0.3% "H" grade production.

A total of three railcars were shipped as "B" grade during the month which represented 2.2% of the 134 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>
9/05/85	10/11/85	PTLX 41839	American Hoechst	5305	Particle Size ⁽¹⁾
10/12/85	10/25/85	PLWX 44726	American Hoechst	5305	Particle Size ⁽¹⁾
10/01/85	10/25/85	VIPX 45805	Extrusion Technologies	Resifted Sifter Overflow	Quality

- (1) This material was produced during BASF test runs.

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The vinyl area received sixteen short lead time emergency type orders comprising 7.9% of the 202 Aberdeen resin shipments in October.

Monthly Variable Cost Performance

Variable costs for the month were unfavorable at \$244.2M resulting from an overall unfavorable price variance of \$162.9M due to price and a net unfavorable efficiency variance of \$81.3M. Resin variable cost for the month was 18.134¢/lb. vs. the budgeted 17.429¢/lb.

The \$162.9M unfavorable price variance was primarily attributed to higher than budgeted pricing for VCM, \$184.2M.

The \$81.3M unfavorable efficiency variance can be attributed to unfavorable VCM efficiency, \$32.7M; and unfavorable variances due to higher than budgeted off-grade production. Pond resin was dried during the month which contributed to the favorable off-grade efficiency variance.

VCM efficiency for the month was 1.00670 lbs. VCM/lb. PVC versus the budgeted 1.0005 lbs. VCM/lb. PVC.

Fiscal year 1985 variable cost efficiency variances in the Vinyl Department totaled \$81.3M unfavorable.

Energy Performance/Progress

1. Plant energy consumption for October totaled 2357 BTU/lb.
2. A total of five steam leaks and three steam trap were repaired during the month.

General

1. Packaging for the month totaled 573,454 pounds.
2. Resin raw material in the 744 account totaled \$245.0M at month end.
3. A test was run to produce 5305 using BASF technology. The porosity was increased and the glassy content was reduced in the resin. Particle size control was poor. Further work is planned.