

FEB 28 1969

Chono

SPA REQUEST - SPA No.: 735-1

1	P. E. - Burlington
2	P. F. Albanese
3	M. G. Caine
4	H. B. Carr
5	H. H. Duhamel
6	E. Farber
7	J. C. Fisher
8	C. W. Johnston
9	R. W. Kulick (A)
10	E. Rad
11	G. I. Rozand
12	P. R. Scarito
13	D. H. Weintraub (A)
14	W. D. Wesely (B)
15	M. W. Williams
16	R & D Log Book
17	Extra
18	Extra

COPY ____ OF ____

C O N F I D E N T I A L

TENNECO CHEMICALS, INC.

TENNECO PLASTICS DIVISION

SPECIAL PRODUCT ADJUSTMENT - EXTENSION

Date: <u>February 28, 1969</u>	SPA No.: <u>735-1</u>
Approved by:	Plant: <u>Burlington</u>
R & D: <u>P.F. Alfano (AVW)</u>	Product Identification: <u>389</u>
Manufacturing: <u>[Signature]</u>	Formulation No.: <u>C-2593L-35</u>
Requested by: <u>Customer Service Lab.</u>	Series No.: <u>699---</u>
	Issued by: <u>A. V. Wagner</u>

Objective:

Establish a specification within the AMP that will correlate with Capitol's extrusion test. The differences experienced in particle size between the drier composite sample and the preshipment sample will be examined.

Marketing Justification:

This extension is necessary to meet Capitol's requirements and maintain the 400,000 - 500,000 pounds per month sales volume.

Product Disposition:

Disposition of resin produced under this SPA extension will be administered by D. Johnson.

COLORITE 015564

References:

1. Special Product Adjustment Report No. 674, dated February 5, 1969.
2. SPA 674 and 12 Extensions.

Technical Justification:

Lot 699005 was accepted by Capitol Records. The audio, staining, and biscuit appearance were acceptable, however, the extrusion rate was long (48 seconds). Capitol complained also that the resin particle size became finer after mixing in the Henschel mixer. This was substantiated by Customer Service Laboratory by running screen analysis on the resin before and after Henschel mixing.

The preshipment particle size of this lot was 16% on 80 mesh (finer than the target of 23%) and this fineness was reflected in the slow extrusion rate. Therefore, this SPA will target on a coarser particle size (25% on 80 mesh).

SPECIAL PRODUCT ADJUSTMENT - EXTENSION

FORMULATION

SUSPENSION RESINS

SPA No.: 735-1

Formulation No.: C-2593L-35

Issued by: A. V. Wagner

Product Identification: 389

Date: February 28, 1969

Series No.: 699---

<u>WEIGHT</u>	<u>RAW MATERIAL</u>	<u>CONDITIONS</u>
9,140	Vinyl Chloride	Agitation: 110 rpm
1,340	Vinyl Acetate	Reaction Temp.: 150°F
72	TCE	Charge Temp.: 125 - 130°F
16,900	Water	Fixed Weight Vent: None
13	Lauroyl Peroxide	Recovery Press.: 35 psig
17	Rozic	Antifoam: Colloid 581B
17	Colic	Antistat: Ammonia
2 lbs. 2 ozs.	L-522 Silicone	Stripping: Up 185° 15 min. and down

Special Charging Procedures:

Use standard 389 charge procedure.

Special Instructions:

1. Take two, one hundred pound preshipment samples. (1) After 20,000 pounds are transferred. (2) After 40,000 pound are transferred.
2. Take a one pound drier sample each hour besides the regular sample.
3. Take a one pound preshipment sample each hour.

SPECIAL PRODUCT ADJUSTMENT - EXTENSION

PRODUCT QUALITY TESTS

SUSPENSION RESINS

Product Identification: <u>389</u>	SPA No.: <u>735-1</u>
Formulation No.: <u>C-2593L-35</u>	Plant: <u>Burlington</u>
Series No.: <u>699---</u>	Issued by: <u>A. V. Wagner</u>
Limitation: <u>9 Batches</u>	Date: <u>February 28, 1969</u>

Q. C. LABORATORY TESTS

<u>TESTS</u>	<u>TARGET PROPERTY</u>	<u>TESTS</u>	<u>TARGET PROPERTY</u>
Relative Viscosity	<u>1.65 - 1.69</u>	Contamination	<u>25 (max.)</u>
Fisheyes	<u> </u>	Plaque Color	<u> </u>
Dry Blend Time	<u> </u>	Tinius-Olsen	<u>0.38 - 0.48</u>
Bulk Density	<u>39 (min.)</u>	Brabender Consistency	<u>880 - 1020</u>
Dry Resin Flow	<u>Flow #1</u>	Clarity	<u> </u>
Heat Stab., Static	<u>90% (min.)</u>	Particle Size +60	<u>0 - 8</u>
Volatiles	<u>1.5% (max.)</u>	+80	<u>12 - 34</u>
Total Acetate	<u>10.5 - 12</u>	-200	<u>0 - 10</u>

Special Instructions:

1. Forward cup sample of preshipment sample to R & D for total acetate.
2. Run standard preshipment sample tests.