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VISTA

To: T. H. Huffman

From: D. C. Skokna
Date: April 23, 1990

Interoffice
Communication

Subject: ABERDEEN MONTHLY PROGRESS REPORT
MARCH, 1990

Safety

There was one first aid care reported during March. As of March 31, the Aberdeen plant's employees have worked 3922 days (5,209,719 manhours) since the last lost time injury.

<u>FY 1990 Key Statistical Information</u>	<u>March</u>	<u>Y.T.D.</u>
PVC Production, MM Lbs.	40.2	219.8
Reactor Stream Factor, %	93.7	86.3
Resin Quality, % Prime	98.2	96.7
VCM Efficiency, Lbs./Lb.	1.0029	1.0011
Flexible Compound Production, MM Lbs.	6.3	36.1
Flexible Compound Quality, % Prime	98.1	98.0
Rigid Compound Production, MM Lbs.	5.8	28.4
Rigid Compound Quality, % Prime	100.0	99.5
Plasticizer Production, MM Lbs.	1.3	9.0
Plasticizer Quality, % Prime	79.0	88.2
Energy Use, (EUI, %)	< 0.7>	< 10.0>
Fixed Cost Variance, \$M	< 5.3>	135.9
Variable Cost Efficiency Variance, \$M	204.0	447.8

Capacity Utilization Factors

Resin	106.3	99.0
Flexible Compound	80.4	77.1
Rigid Compound	95.1	78.7
Plasticizer	55.4	71.9

Operations

A temporary clean wall injection system was tested on D745, but it failed due to inadequate dispersion of the clean wall agent. A modified system will be tested in April.

A trial run to make 5305 using decalcified water was successfully completed. Samples were sent to customers and BASF for evaluation.

In the compound unit, some twenty-four hours were devoted to PLENEX polymers development on Line I.

Rigid compound demand continued to be strong with 2.5MM pounds being tolled for Gold Bond.

CCR 000006335

T. H. Huffman

4/23/90

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Costs

Variable costs were favorable due to good raw material efficiencies in the resin unit and flexible compound unit, and to product mix effects in the flexible and rigid compound units.

Fixed costs were essentially at budget.

OMP

1. Ninety-five percent of the plant's natural teams met during March. Ratings for the plant's thirty-eight natural teams as of 3/31/90 were 5.1 - up two points from the last measurement.
2. The finalized version of the Q-Scorecard was presented to the facilitators. The facilitators are responsible for helping to communicate the details of the Q-Scorecard to all employees.
3. A full review of Uniroyal specifications was performed. These specifications will be proposed to Uniroyal by Marketing for their approval. The specifications include the most recently requested requirements.



Doug Skokna
Plant Superintendent

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SAFETY - B. L. Trego

	<u>March</u>	<u>Fiscal</u> <u>Y.T.D. 1990</u>	<u>Fiscal</u> <u>Y.T.D. 1989</u>
First Aid	1	7	6
OSHA Recordable	<u>0</u>	<u>3</u>	<u>2</u>
Total Injuries	1	10	8
Number of Restricted Workday Cases	0	2	1
Number of Lost Workday Cases	0	0	0

Injuries by Department

Vinyl Operations	0	0	0
Compound Operations	0	2	2
Maintenance	0	6	6
Laboratory	1	1	0
Receiving/Warehouse	0	0	0
Office	<u>0</u>	<u>1</u>	<u>0</u>
Totals	1	10	8

Injuries by Type

Cuts and Abrasions	0	2	1
Eye Injuries	0	1	0
Burns	0	2	2
Bruises	0	1	2
Strains/Sprains	0	0	2
Stings	1	2	0
Other	<u>0</u>	<u>2</u>	<u>1</u>
Totals	1	10	8

Non-Occupational Injuries

Lost Workday Cases	0	3	2
Days Lost	0	84	42

Safety Record

Last lost time injury - 7/5/79
Days since - 3922
Employee hours since - 5,209,719

On March 31, 1990, the employees of the Aberdeen plant completed 3922 days with no lost time injury.

Topics for the plant safety meetings during the month included reviews of the new Plant Safety Handbook, Safety Attitude, Contractor Safety, Off-the-Job Safety, and Severe Weather Operations.

CCR 000006338

SAFETY - Continued

A seatbelt survey was done to see how many Aberdeen employees wear seatbelts to work. It showed that over 40% wear seatbelts now versus 27% in a similar 1987 survey.

Annual physical examinations were given this month. The Health Examinetics van was here during the week of March 5, 1990.

Routine dosimetry results for the month were:

<u>Chemical</u>	<u>< PEL</u>		<u>> PEL</u>	
	<u>Number</u>	<u>Percent</u>	<u>Number</u>	<u>Percent</u>
VCM	77	100.0	0	0.0
Lead	17	100.0	0	0.0
Total Particulates	6	100.0	0	0.0

Monthly Injury Summary

<u>Injury Class</u>	<u>Department</u>	<u>Description</u>
FA	Laboratory	Wasp sting, left arm.

CCR 000006339

QUALITY MANAGEMENT PROCESS - M. R. Kane

The finalized version of the Q-Scorecard was presented to the facilitators. The facilitators are responsible for helping to communicate the details of the Q-Scorecard to all employees.

Ninety-five percent of the plant's natural teams met in March with 100% expected in April.

A full review of Uniroyal Plastics specifications was performed. These specifications will be proposed to Uniroyal by Marketing for their approval. The specifications include the most recently requested requirements.

CCR 000006340

COST VARIANCES - D. C. Skokna

Variable Costs

<u>Product</u>	<u>March, 1990 Variance, \$M</u>		
	<u>Efficiency</u>	<u>Price</u>	<u>Total</u>
PVC	\$68.5	\$551.5	\$620.0
Flexible Compound	53.1	186.8	239.9
Rigid Compound	70.7	143.2	213.9
Plasticizer	<u>11.7</u>	<u>19.3</u>	<u>31.0</u>
	\$204.0	\$900.8	\$1104.8

PVC - Raw material usage and product mix were both favorable. Debox production was 55% below budget.

Flexible Compound - Raw material use was \$25.7M favorable, and product mix was \$24.3M favorable.

Rigid Compound - Essentially all of the favorable variance was a result of the product mix.

Plasticizer - High "VRP" production was the primary cause of the favorable variance.

Price Variances

	<u>\$M</u>
- VCM	\$540.1
- Resin to Rigid Compound	143.7
- Resin to Flexible Compound	138.6
- 610P to Flexible Compound	13.5
- Natural Gas	12.2
- Other Price Variances	<u>52.7</u>
Total	\$900.8

Fixed Cost Variances

	<u>\$M</u>
- Payroll and Benefits	<\$37.3>
- MM&C	17.8
- Miscellaneous	11.8
- TI&D	5.9
- Clearances	<u>< 3.5</u>
Total	<\$ 5.3>

CCR 000006341

Payroll and Benefits - Overtime was high in maintenance for Welex repairs in the rigid compound unit, repairs to the Line III FCM compounder, and centrifuge repairs in the resin unit. Compound department overtime was high due to vacations, illnesses, and National Guard duty.

M. M. & C. - Contract costs were below budget, but these were partially offset by material costs for compound unit repairs and centrifuge repairs.

COST VARIANCES - Continued

Miscellaneous: Major variances in this category were:

- Packaging Supplies - \$17.3M favorable.
- Operating Supplies - \$10.3M unfavorable (due primarily to preparing for work stoppage).
- Casualty Loss - \$13.2M unfavorable (due to Workman's Compensation payments).

VINYL - J. D. Olson, J. M. Vinoski

Safety

The Vinyl Department had no first aid or OSHA recordable injuries during the month of March.

The monthly safety meeting topic was "Off-the-Job Safety".

General

1. The temporary BUS-80 injection system was tested on D745 in March. The system failed to keep the reactor walls clean due to inadequate dispersion of the BUS-80 in the reactor. The test was discontinued and a new test with a modified injection system is planned for April.
2. The decalcified water test run was completed in March. High resin calcium levels are believed to cause Klockner's graininess problem. Tests show the 5305 resin produced with decalcified water had 4 ppm calcium (20% of normal). Samples were sent to Klockner and BASF, and results are expected in April.
3. The resin raw materials in the 744 account were valued at \$414.5M.

	<u>March</u>	<u>YTD</u>
- Production, MM Lbs.	40.2	219.7
- Daily Rate, M Lbs./C.D.	1295.6	1207.1
- Capacity Utilization Factor, %	106.3	99.0
- Total Reactor Charges	95.6	5159.0
- Charges/C.D.	30.8	28.3
- Reactor Stream Factor, %	93.7	86.3
- Rotary Dryer Stream Factor (#4-#8), %	84.6	75.4
- Fluid Bed Dryer Stream Factor, %	1000.0	90.2
- Resin Quality, % Prime	98.2	96.7

Reactor Downtime

Hours

- | | |
|--|-------|
| - Operational downtime (recovery scheduling conflicts, rinsing chem wash tanks, New Module rinse/charge water conflicts, no place to dump, waiting on Q.C. data before charging, and O-ring leaks). | 241.3 |
| - Maintenance downtime (hydroblast reactors and drill condenser on D745, replaced agitator seal on D400, replaced control room Topaz battery backup unit, and miscellaneous valve and instrument repairs). | 224.7 |

CCR 000006343

VINYL - Continued

<u>Dryer Downtime</u>	<u>% of Total Downtime</u>
- Reactor limited production.	78.2
- Operational downtime (centrifuge plugs, dryer cleaning, and flameouts).	8.3
- Maintenance downtime (centrifuge repairs, replace #6 Bird, shear pins, exhauster maintenance, sparge pipe replacement, Bird boot repairs).	13.5

Key Maintenance Work - J. B. Autrey, J. B. Hegwood

- Reactor 745 was shut down for hydroblasting and condenser drilling during the month as part of the contamination control program.
- The S.A. module Westfalia centrifuge was shut down for preventive maintenance work during the month. A factory representative along with a mechanic disassembled and reconditioned the centrifuge.
- Number 8 Bird centrifuge was removed from service during the month and replaced with a spare. The centrifuge that was removed was rebuilt and will be used as a sparge.
- The old reactor unit recovery condensers were shut down during the month for cleaning because of pluggage.
- The motor on the west fan of #6A cooling tower was replaced because of bad bearings and windings.
- Reactor 400 was shut down for seal replacement on two different occasions during the month. The two seal failures were caused by a plugged lip seal flush line. The line was plugged with resin which stopped the flow of water to the seal.
- The vinyl control room Topaz unit was taken out of service and replaced with the Topaz unit from the compound control room because of bad batteries and a bad system control board. A Topaz service technician is being brought in to service both units and make any needed repairs.
- There were eight major valves changed out in the reactor area during the month.

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