

Technical Summary

AP00045604

LABORATORY

Special work in the laboratory this month centered primarily with the DNT start, assistance with the startup of the ammonia plant with new sulfur-removal carbon and low temperature shift catalyst, and detailed work in the amines development area.

The laboratory did an excellent job in the DNT project in supplying the necessary information and working closely with the Biazzi people in verifying that the product produced was satisfactory. Messrs. Marlow, Wolfe, Barber, and Fowlkes all collaborated in this DNT work and in the development of a successful method for extracting TNT from some of the off-spec DNT produced.

A catalyst was found which successfully converts DEA to MEA and TEA. It appears practical to utilize two converters in parallel to provide additional quantities of TEA while producing MEA in the normal manner.

ENGINEERING

Major projects completed this month are reviewed below.

The DNT plant is substantially over budgeted investment. This appears to be the result of a misunderstanding of the complexity of this project both by Chemico and Escambia. However, the plant will do an excellent job of producing product, and can readily be expanded. It appears that the total project economics will not be greatly affected by the overrun, assuming that sales proceed up to an ultimate level of 40 MM lbs/yr.

The IBN project investment was completed this month with the installation of the 200,000 gallon storage tank. This job will be closed out.

The new 600# boiler will be completed during November. The decision was made to proceed on an overtime basis to complete the boiler early because of the need for steam and the need to have the old B&W boiler down for maintenance as soon as possible.

The amines plant expansion is continuing on schedule with completion estimated by April 1, 1967. It is hoped to have the 66" ammonia column usable as a batch still the last week in December. Other phases of the project will be completed in February and March, depending on the delivery of key equipment.

PLANT IMPROVEMENT

Mr. Bodamer has been assigned to activate the amines pilot plant. As soon as the necessary operating people are available, work will commence.

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The first phase of the program consists of distillation studies on DEA, TEA, and DIPA to prove out the separations planned and the suitability of the equipment.

Necessary plant assistance work in the amines area will be handled by R. E. Jones. The principal effort here has to be to establish operating conditions and process controls which will maintain yields and production rates at maximum. He also will cover any assistance desired or necessary in the ammonia-methanol-nitric acid area.

While the DNT operation has been satisfactorily proved, it is necessary to evaluate what must be done to minimize the sulfuric acid use and to determine what combination of nitric and/or sulfuric acid concentration might be used to minimize the sulfuric acid cost if it is not possible to dispose of the spent sulfuric acid in the fertilizer operation.

Mr. R. W. Beech, who joined Escambia in October, is developing the above mentioned information and also will detail the process changes necessary to bring the DNT production rate to a 20 MM lbs/yr. rate and a 28 MM lbs/yr. rate. If the Wyandotte and Olin sales approach the projected rates, it will be necessary to have a DNT plant expansion completed by August 1, 1967 to the 20 MM lbs/yr. rate and by January 1, 1968 to the 28 MM lbs/yr. rate.

As soon as Mr. Beech is through with this phase of the work, he will be assigned to other plant improvement projects.


J. C. Dorsey, Jr.

mdc

AP00045606

OCTOBER, 1966

SUMMARY OF PROJECT WORK STATUS

Project No.	Title	Appropriation M\$	Committed M\$	Revised M\$	Completion Date	Remarks
6501	Water Softeners to Provide Water for Boiler	18.0	13.9	18.0	12/15/66	Equipment due early Dec. Field piping in progress.
6509	Air Condition & Enclose Wet Bay Control Room	6.0	5.4	5.4	10/31/66	Complete.
6533	Ammonia Recovery Pressure Control System	3.3	1.5	3.3	12/1/66	Instruments all received. Waiting for available instrument manpower.
6565	DNT Plant	1070.0	1330.0	1330.0	10/1/66	Job complete. Letter being issued on overrun.
6585	Equipment to Produce IBN & DEA - Amines	223.9	234.7	234.7	10/26/66	Job complete.
6604	New 600 psi 100,000#/Hr. Boiler	320.0	286.0	320.0	12/1/66	Field work on schedule. All equipment on hand.
6605	Upgrading Water Treatment	105.0	103.3	105.0	12/15/66	Field piping in progress. Equipment due early Dec.
6613	Product Coating System - NP	15.5	7.5	15.5	Indefinite	Clay feeder installed on temporary basis for test run.
6616	Provide Offices, Locker Room and Storage	14.3	none	14.3	Indefinite	Approval still pending.
6617	Additional Bulk Car Loading Facilities - PVC	10.4	10.1	10.4	10/31/66	Completed during month.
6632	H.P. Water Pump, H.P. Scrubber - No. 1 Plant	4.0	1.5	4.0	Indefinite	Installation dependent on Production's decision as to proper use of pump.
6635	Plant Steam Recorder	1.8	1.2	1.8	Indefinite	Waiting for shutdown to install.
6640	Maintenance Shop - Area B	26.0	20.0	26.0	1/31/67	Foundation work started. Building, heating and air conditioning equipment ordered.
6642	Purchase of Lab Equipment	23.4	9.9	23.4	Indefinite	
6647	Ammo-Phos Production	200.0	208.0	208.0		Job complete.
6650 6652	Amines Plant Expansions	1360.0	466.1	1360.0	4/1/67	Major equipment on order. Job on proposed schedule.
1580-18829	Independent Raw Water Supply - PVC	9.7	7.6	9.7	12/1/66	Work in progress.
1580-18862	Revise Condensate System from PVC Dryers	3.0	5.1	3.0	11/30/66	Foundations and pumps were installed. Proceeding with piping and electrical as manpower permits.
1580-18870	Connect Well Water System Between PVC and MeOH	2.7	none	2.7	Indefinite	Approved during month.
1580-18871	Install Monitor Nozzles at NH ₃ and MeOH Synthesis	4.4	none	4.4	Indefinite	Approved during month.
1770-6003	PVC Reactor Reglazing	38.0	23.1	38.0	Indefinite	Spare reactor being reglazed at Glasco with scheduled shipping date of December 2.

11/7/66
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ESCAMBIA CHEMICAL CORPORATION

Interoffice Memorandum

To: Mr. T. L. Carey

Date: November 2, 1966

From: E. M. Spurlock

Re: Monthly Report - Personnel Department - October, 1966

PERSONNEL

Activity for the Month

<u>Division</u>	<u>No. of Employees 9/30/66</u>	<u>October Additions</u>	<u>October Separations</u>	<u>No. of Employees 10/31/66</u>	<u>1966 Budget</u>
Admin. & General	57	1	3	55	56
Research	57	0	1	56	59
Agri. Chemicals	163	3	3	163	160
Industrial Chemicals	16	0	1	15	18
Production	<u>444</u>	<u>9</u>	<u>9</u>	<u>444</u>	<u>406</u>
Totals	737	13	17	733	699

There were 177 walk-in applicants, 128 applications were issued and 11 were received by mail. Forty-six applicants were interviewed and 41 were tested.

TRAINING

School was held for the operation of forklifts and 4 forklift operators were licensed.

School was held for the operation of trackmobiles and 2 trackmobile operators were licensed.

Training in the use of hand fire extinguishers and wheeled extinguishers was held for all Process Operators on A,B and C shifts who had not had this training on four or more occasions.

Two supervisors attended the National Safety Congress.

SAFETY

The Corporation worked approximately 130,000 man-hours during the month.

The approximate man-hours and the days worked to date without a disabling injury are as follows:

Personnel

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<u>Division</u>	<u>Man-hours</u>	<u>Days</u>
New York Office	362,000	1,914
Research Division	859,000	3,394
Atlanta Division	20,898	18
Pensacola Plant	102,000	41
Corporation	55,500	18

The Atlanta Division experienced two disabling injuries during the month.

The PVC Laboratory completed ten years without a disabling injury.

Medical Section

The Medical Section treated 17 injuries for Escambia and 31 for Carroll, performed 7 pre-employment and 17 annual physicals and gave a total of 28 immunization injections.

EMPLOYEE RELATIONS

One 5-year service award was presented.

Two 10-year service awards were presented.

Plans have been made for Escambia Wives' Luncheon. This annual event will be held at Scenic Hills Country Club on November 9, 1966.

LABOR RELATIONS

We have received a petition from the United Association of Journeymen and Apprentices of the Plumbing and Pipefitting Industry of the United States and Canada, AFL-CIO Local No. 366, through the National Labor Relations Board to represent the Maintenance employees.

INSURANCE

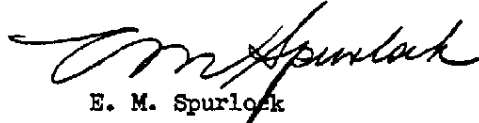
We paid a total of 75 claims under our Group Hospitalization program which amounted to a total of \$ 14,714.62 during the month of October.

We settled the following claims during the month of October:

Six claims amounting to \$ 1,581.69 under our Automobile Physical Damage Insurance.

Two claims amounting to \$ 1,316.55 under our Public Liability and Property Damage Insurance.

Two claims amounting to \$ 428.40 under our Manufacturers Output Insurance.


E. M. Spurlock

EMS:kc

AP00045609

PRODUCTION MONTHLY REPORT

November, 1966

AP00045610

ESCAMBLA CHEMICAL CORPORATION

Interoffice Memorandum

To: Mr. H. F. Roderick

Date: December 5, 1966

From: T. L. Carey

Subject: Monthly Report - November, 1966

Primary T.L.C.

The Amines operations were a very bright spot in November. It was a record production month and yields were essentially at budget.

Total variance was a negative \$43,920. Of this, approximately \$30,000 is due to budgeting errors or omissions (depreciation, steam allocation, lab charges and inventory adjustment). Maintenance accounted for approximately \$15,000 variance and was due to replacing the ammonia preheater tube bundle with a stainless steel bundle, re-tubing the superheater with stainless tubes and disassembly and cleaning of the forward flow heat exchanger. All in the No. 2 plant.

Yields were:

Methyl Amines	+ \$ 9,758
Ethyl Amines	- 19,566
(\$15,000 due to high cost raw materials)	
Isopropyl Amines	- 4,510

Volume was 4,979,000 lbs. - more than 1,000,000 lbs. better than the best previous record.

These results are highly gratifying.

PRODUCTION UNITS - McMILLAN

The following is a tabulation of the plant results of those plants under the supervision of Mr. McMillan and his Area Superintendents:

J. MARTS

	<u>Variance from Budget</u>	
	<u>November</u>	<u>Year To Date</u>
Steam	- 1,740	\$ - 39,348
Water	+ 2,740	+ 28,011
Ammonia	+ 6,927	+ 148,457
Nitric Acid	-13,654	- 5,079
Methanol	-16,875	+ 61,866
Total		\$ + 193,907

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December 5, 1966

J. RUSSELL

	<u>Variance from Budget</u>	
	<u>November</u>	<u>Year To Date</u>
Ammonium Nitrate	- 442	\$ + 4,880
Urea	+ 709	- 14,241
U-34 Solutions	- 960	- 6,734
Bay-Sol	- 1,972	+ 15,064
Prills	+38,949	+ 180,932
Total		+ 179,901

M. SMITH

PVC	+22,097	\$ + 124,892
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S. BARFIELD *

Phos. Acid	- 8,971	\$ - 109,616 (Idle plants)
Nitro-Phos.	-41,939	- 250,029 (Inv. adj. and 1 Mo. Idle plant)
Ammonium Phos.	-	+ 23,505
Total		- 336,140

TOTAL ALL UNITS

\$ + 162,460 better than
budget.

* These units have been placed under the supervision of J. Russell and are now operating essentially at budget except for inventory adjustment. Inventory adjustment carryover from last year plus one month idle NP plant amounts to \$175,000. Phos. Acid \$109,000. Even including all of these costs, cost per ton is \$2.50 less than last year.

METHACRYLATE

In accord with Mr. Roderick's decision this plant is in the process of being shut down and placed on standby. Detailed plans are being formulated to carry out these instructions. The plant will use up the raw materials on hand and process them through to finished product. It is anticipated that forces will be reduced by approximately 30 people. There will be a gradual reduction through to mid-January.

The two Dow people have returned to their home operations.

November HIBA production was another new record.

T. L. Casey
T. L. Casey

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