



ESCAMBIA PLANT
INTEROFFICE MEMORANDUM

To: R. E. Davis

Date: February 8, 1973

From: E. A. Primeau

Copies:

Re: PVC Monthly Report
January, 1973

SUMMARY

Prime resin production for January was 5,440 M pounds versus a budget of 5,300 M pounds and a January 20th forecast of 5,400 M pounds. Off-grade, tails and sweeps amounted to 60 M pounds which represent 1.1% of total production versus a budget of 4.5%.

A total of 623 charges were made--an average of 20 per day.

R. F. E. data for the installation of a 3,700 gallon reactor as No. 12 reactor was prepared and submitted to the Valley Forge Accounting Department on January 26, 1973.

An R. F. E. was prepared to purchase the valves and actuators necessary to automate the charge system on No. 11, 5,000 gallon, glass-lined reactor.

The variance generated by PVC for January was (\$266). The variance resulted from:

1)	PVC Bulk	(\$2,565)
2)	PVC Bagging	\$2,299

The forecast variance on January 20th was \$2,100 favorable. The item affecting the variance were:

	<u>Forecast</u>	<u>Actual</u>
Raw Materials	(\$2,000)	\$1,316
Process Costs	(\$1,400)	(\$6,093)
Volume	\$1,000	\$1,121
Machine Hours	\$3,000	\$3,300
	<u>\$ 600</u>	<u>(\$ 266)</u>

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ANALYSIS OF VARIANCE

Raw materials were favorable due to a favorable variance in vinyl chloride of \$2.5 M, in process chemicals of \$2.2 M, and in royalties of \$1.5 M. This was partially offset by an unfavorable variance in by-product credit of (\$4.9) due to low production of off-grade.

Volume variance was \$1.1 M favorable due to above budget production of resin. Machine hour variance was \$3.3 M favorable due to January being a 31-day month. Projected production for month of February is 4,900,000 pounds with a favorable variance of \$2,400.

DISCUSSION

During January, the PVC plant produced six resin types. One type 1230 P accounted for 49.9% of the total prime resin production.

The Alpine Mill was utilized to regrind 2,000 pounds of 3185 resin produced at Calvert City. Almost no size reduction was obtained from the first mill pass and only 4185-2S was produced in the second pass through the mill. A separate memo was written to V. J. Grande, detailing the work done.

CHEMICAL CLEANING

The new recovery jets arrived in mid-January and were installed. The modification and installation of the larger evaporators was completed and put into operations on January 20th. Currently, the unit is being tested. Thus far, the feed to the Artisan unit has been increased from 600 pounds per hour to 780 pounds per hour. However, the Moyno pump has been plugging an average of two to three times per day.

On January 31st, a section of the inner shell of the Rototherm unit collapsed. Maintenance is attempting to repair the shell but a new shell will have to be purchased and installed as sections of the shell wall measure 3/16" as opposed to the original thickness of 7/16". A drawing of the unit has been sent out for quotes. Artisan wants \$11,000 for the shell and have a delivery of 26 to 30 weeks.

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R. E. Davis
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PVC EXPANSION

Data required for an R. F. E. to install a 3,700 gallon stainless steel reactor was sent to the Valley Forge Accounting Office on January 26, 1973. Additional cases are currently being studied for the installation of a 10 M gallon or 20 M gallon stainless steel reactor.

PVC BAGGING

A total of 2,185 M pounds of PVC was bagged at a cost of \$11,511 in January. Variance is as follows:

	<u>Actual</u>	<u>Forecast</u>
Volume	\$ 549	\$ 500
Spending	<u>\$1,750</u>	<u>\$1,000</u>
Total	\$2,299	\$1,500

PVC LOADING & SHIPPING

A total of 5,589 M pounds of resin was shipped from Pace. Starting resin inventory was 599 M pounds and closing inventory was 518 M pounds.



E. A. Primeau

EAP:lm
Attach.

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STATISTICS

	<u>January</u>		<u>Year-to-Date</u>	
	<u>Actual</u>	<u>Budget</u>	<u>Actual</u>	<u>Budget</u>
Prime Production				
Homopolymer	5,440	5,300	21,487	21,029
Subtotal	5,440	5,300	21,487	21,029
Off-Grade				
Homopolymer	0	-	0	-
Tails	50	-	225	-
Sweeps	10	-	36	-
Subtotal	60	231	261	943
Total Production	5,500	5,531	21,748	21,972
O. G., % Total Prod.	1.1	4.5	1.2	4.5
Bulk Prod., % Prime	60.0	-	59.2	--
VCM Efficiency %	93.6	94.5	93.0	94.5
Reactor Avail. %	95.1	92.5	94.3	92.5
Production, #/Gal. Yr.	1,343	1,307	1,337	1,307

Off-Grade Analysis

None

Production Sequence - January

<u>North Line</u>		<u>South Line</u>	
<u>Type</u>	<u>Batches</u>	<u>Type</u>	<u>Batches</u>
2160	7	1225	13
2185	5	1230	129
2200	29	1225	34
2160	9	1230	162
2250	11	1225	5
1225	19		343
2200	31		
2160	22		
2250	19		
2200	60		
1225	32		
2250	31		
2200	5		
	280		

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Statistics - continued
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Production Summary - M Pounds

<u>Type</u>	<u>January</u>	<u>Year-to-Date</u>
1160	--	17
1200	--	15
1225	917	3,826
1230	2,714	10,225
1250	--	--
2160	314	853
2185	31	132
2200	990	4,300
2225	--	546
2250	474	1,644
	<u>5,440</u>	<u>21,558</u>

Downtime Analysis - Hours

	<u>January</u>	<u>%</u>	<u>Year-to-Date</u>	<u>%</u>
Cleaning Reactors	532	6.5	2,172	6.7
Schedule Charges	22	0.3	344	1.1
Behind on Recovery	152	1.8	432	1.3
Hold to Drop	69	0.8	519	1.6
Plugged Drop Valves	44	0.5	100	0.3
Change Type	10	0.1	87	0.3
Slow Drying	20	0.2	274	0.8
Hydraulic Motor Maint.	34	0.4	121	0.4
Misc.	<u>54</u>	<u>0.7</u>	<u>177</u>	<u>0.5</u>
	937	11.3	4,226	13.0

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Personnel

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