Middleton

Operation Report
Dept. 246 - Aroclor
March - 1965

PRODUCTION SUMMARY (Current Month)

Scheduled - 2,480,000#
Actual - 2,489,050#
% of Schedule - 100%

PRODUCTION SUMMARY (year to date)

Aroclor	Current Month	Year to Date
1242	1,065,365#	2,828,872#
1248	475,013#	1,936,428#
1254	469,588#	1,527,952#
1260	454,844#	1,210,166#
1262	24,240#	35,820#
Total -	2,489,050#	7,539,238#

Average Monthly Production - 2,513,079#

Availabilities
Repair - 89.78% Process - 94.62% Other - 96.51%
Total - 80.91%

The reasons for the outages for this month are summarized below.

Repair	34 Hrs. (4.57%)	Rate of No. 1 still reduced because of broken condenser (This was repaired on 3/22/65)
	10 Hrs. (1.34%)	Fuse burned out on filter pump.
	17 Hrs. (2.28%)	Change #2 still pump.
	15 Hrs. (2.02%)	(3 Hr.) Plastic cover was left on a replacement valve on #4 chlorinator. (2 Hr.) Leaking tee in off-gas line on #4 chlorinator. (3 Hr.) Leaking flange on #2 still coil (1 Hr.) Replace wiring on biphenyl transfer pump motor (6 Hr.) Repair leak in 200# steam line.
Process	9 Hrs. (1.21%)	Rate of No. 1 still reduced by plugged condenser on water side.
	6 Hrs. (0.81%)	Operating error. Wrong chlorinator pumped into blow tank.
	11 Hrs. (1.48%)	Circulating line plugged on #1 still.
	7 Hrs. (94%)	(3 Hrs.) Operating error delayed charging No. 4 chlorinator. (4 Hrs.) Changed plugged furnace coil on No. 2 still furnace.

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Dept. 246 (cont.)

Other	18 Hrs. (2.42%)	Changing products
	8 Hrs. (1.07%)	(1 hr.) - Project group installing line between stills.
		(5 hrs.)- Plant tests on quality
		(2 hrs.)- No biphenyl due to late switching.

YIELDS

	Standard	Actual	YTD
% Theory on Biphenyl -	95.50%	96.78%	98.79%

Significant Items This Month

This month's production was second only to January's record production.

Quality

Two lots of electrical grade 1242 Aroclor were produced this month with thermal-chemical stabilities of 0.34 ppm and 0.55 ppm. The distillate from the stills at the end of each 1242 run was kept separate. The material with the 0.55 ppm stability was made during a plant test in which the two stills were run in series. The material was fed to the first still where a 10% cut was made and then the other 90% was sent to the second still which was operated in the usual manner. The test was run to determine if low boilers could be removed in the first still and improve the thermal-chemical stability. Although some low boilers were removed in this manner the stability for this run was actually worse than for the regular run. This could have been due to factors at other steps which affect quality. The cause for the 0.55 ppm is being investigated by the Process Research Group and Technical Services.

The 1242 thermal-chemical stabilities are summarized below for the first quarter of 1965.

Date	Lot No.	Thermal-Chemical Stability
1-9-65	KE-401	0.62 ppm
1-21-65	KE-405	0.48 ppm
1-27-65	KE-406	0.52 ppm
2-5-65	KE-407	0.46 ppm
2-7-65	KE-409	0.52 ppm
2-25-65	KE-412	0.44 ppm
2-27-65	KE-413	0.28 ppm
3-15-65	KE-416	0.34 ppm
4-2-65	KE-420	0.55 ppm
4-17-65	KE-422	0.40 ppm

Beginning with Lot KE-412 all 1242 was produced by separating the distillate near the end of the run for non-electrical material, and the sensing points for the vacuum controllers on the still systems were changed from the receivers to the stills.

4/24/64 KE 424 0.62 ppm

DSW 296463

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Dept. 246 (cont.)

The back pressure on the HCl off-gas line was erratic near the end of the month making it necessary to sewer HCl gas for about eight hours. The fluctuation in back pressure is not indicative of a plugged line, but indicates that the automatic valve which distributes gas between Depts. 217 and F-218 may be causing the back pressure.

The nuclear density gauge on No. 4 chlorinator was standardized and gauge readings compared with hydrometer readings. There is a large difference between the two readings which prevents the use of the density gauge as an indication of when a batch is finished.

Stock Position

Product	Aroclor 1st of Mo.	Aroclor Last of Mo.
Whse. Stock -	1,575,018#	1,566,205#
Dept. Stock -	842,191	607,307
	2,417,209#	2,173,512#

D. E. Harris

ghw

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