

COMPOUND - S. B. VickSafety

The Compound, Dry Blend, and Plasticizer Departments operated with one first aid case during October, 1983. The first aid case involved a cut finger while operating a vending machine..

The safety meeting topics for October were part five, "Preflight Your Job", and part six, "Keep It Clean", of the "Safety Seconds" program. All shifts saw part five and two shifts saw part six.

Parts six and seven of the "Safety Seconds" program will provide safety meeting topics for November in addition to respirator training which is planned for November and December.

<u>Compound Production</u>	<u>Month</u>	<u>#'s/Day</u>	<u>Y.T.D.</u>
Line I, M Pounds	1318	63	11648
Line V, M Pounds	0	0	19
Line III, M Pounds	2854	96	28840
Total, M Pounds	4172		40507
Accounting Days	31		304

Line I operated twenty-one days during October at an average rate of 63M pounds per day. Line I operated well for the month. Major downtime items were: product changes 31.0 hours, blender charging delays 16.2 hours, blender conveyor bucket repairs 12.0 hours, and scheduled maintenance shutdown 8.0 hours. Experimental compounds produced on Line I for the month were reformulated versions of 34642 Black, 3934-144A, 3934-144B, and 3934-144C.

Line V did not operate during October.

Line III operated 29.5 days during October at an average rate of 96M pounds per day. Line III production was hindered by product changes 48.7 hours, FCM orifice gate pluggage 24.0 hours, charging delays 7.7 hours, dicer delays and transfer line pluggage 2.0 hours, Line III sump pump repairs 6.7 hours, pellet screener repairs 6.5 hours, and scheduled maintenance shutdown 5.0 hours. Experimental compounds produced on Line III included: (1) 5167-136D, reformulated 38931, (2) 5167-14 and 5167-14B, reformulated 35851, and (3) 4986-74, a new 105⁰ wire formulation for 3M. Quality performance for flexible compounds was 1.8% off-grade which 98.5% was due to mill scrap. "BC" production was 0.24%.

COMPOUND - Continued

The raw material requirement for flexible compounds was 1.00825 pounds of raw material per pound versus a 1.01302 standard. (Y.T.D. is 1.01279).

The variable cost variance for compound was \$191.0M favorable with \$60.7M due to price and \$130.3M due to efficiency. The variance due to product mix was \$134.9M. The only major efficiency variance was DTDP at (\$23.5M). The variance was due to the unbudgeted use of DTDP in 34641 compounds.

Total customer grade compound inventory decreased 1.4MM pounds to 8.2MM pounds during October.

<u>Dry Blend</u>	<u>Month</u>	<u>#'s/Day</u>	<u>Y.T.D.</u>
Production, M Pounds	3783	161	45087
Accounting Days	31		304

Dry blend operated 23.5 days during October at an average rate of 161M pounds per day. Production included 80273G, 90171, 90172, 4606-168A, and 5034-95, reformulated 90172. Dry blend production was hindered by product changes 28.0 hours, quality control delays 24.3 hours, and resin availability 16.5 hours. Production rates were limited during production of 4606-168A due to continued use of intermittent master batch production technique. Quality performance for the month was 99.5% customer grade.

The raw material requirement for dry blend was 1.01056 pounds of raw material per pound of dry blend versus a standard of 1.00490. (Y.T.D. is 1.00284).

The variable cost variance for dry blend was \$123.7M favorable with \$33.6M due to price and \$90.1M due to efficiency. The variance due to mix was \$89.1M. There were no major efficiency variances for the month.

<u>Plasticizer</u>	<u>Month</u>	<u>#'s/Day</u>	<u>Y.T.D.</u>
Production, M Pounds	1078	51	10146
Accounting Days	31		304

Plasticizer operated twenty-one days during October at an average rate of 51M pounds per day. Production included 610P and 108P.

VRP production totaled 60.8M pounds (6.3%). Production was limited by demand.

COMPOUND - ContinuedPlasticizer - continued

The raw material requirement for plasticizer was 1.09238 pounds of raw materials per pound of plasticizer versus a 1.12528 standard. (Y.T.D. is 1.10270).

The variable cost variance for plasticizer was \$193.3M favorable with \$182.2M due to price and \$11.1M due to efficiency. Major price variances were: Alfol 810AI \$26.6M, Alfol 610 \$110.9M, and phthalic anhydride \$41.9M. There were no major efficiency variances for the month. The variance due to product mix was \$13.3M.

Energy

	Usage (BTU/LB)	
	<u>Standard</u>	<u>Actual</u>
Compound	2117.3	1849.3
Dry Blend	860.0	754.3
Plasticizer	1825.1	1384.7