

VINYL - P. E. Markey/M. L. Nathan

Safety

The vinyl and yard departments operated without injury during the month of May.

Shift safety meeting topics included the "Convincer" slide and tape program and part I of the "Safety Seconds" video program series entitled "Safety A State of Mind".

<u>Production</u>	<u>May</u>	<u>Y.T.D.</u>
1. Production, MM Lbs.	35.8	150.6
2. Daily Production Rate, M Lbs./C.D.	1156.4	995.7
3. Total Charges	866	3596
4. Charges, Reactor Batches/C.D.	27.9	23.8
5. Reactor Stream Factor	90	78.6
6. Dryer Rate, Average Lbs./Hr.	7480	6694
7. Dryer Stream Factor	71.5	68.7
8. Accounting Days	31	151

Production

Vinyl department production for May was a record 35.8 MM pounds which was 104% of the budgeted production volume and also exceeded the Business Area targeted production level of 35.0 MM pounds. The new record of 35.8 MM pounds outpaced the previous monthly production record of 34.6 MM pounds established in May 1982. Correspondingly, plant energy consumption was the best ever at 2530 BTU/lb. vs the previous record of 2638 BTU/lb. posted in February of this year.

Reactors

1. Condenser cleanings on D-500, D-600 and 742 reactors resulted in a stream factor penalty of 2.1%.
2. Replacement of D-400 agitator seal twice and D-600 agitator seal once resulted in a reactor stream factor penalty of 1.1%.
3. Jacket welding repairs on 743 and 745 reactors resulted in a stream factor penalty of 0.4%.
4. Agitator blade changes associated with the D-700 test program resulted in a stream factor penalty of 1.1%.
5. Numerous valve changeouts and valve maintenance resulted in a reactor stream factor penalty of 0.7%.

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Reactors - continued

6. Downtime due to recovery system scheduling conflict resulted in a stream factor penalty of 2.3%.
7. Downtime due to pluggage of 741 and 742 rinse lines resulted in a reactor stream factor penalty of 0.2%.
8. One coarse batch was experienced during May resulting in a stream factor penalty of 0.1%. The actual cause of the coarse batch was not determined.
9. An aborted charge on D-500 reactor due to an instrument malfunction resulted in a stream factor penalty of 0.1%.

Dryers

1. Production was essentially reactor limited during May. Dryers were shutdown for energy conservation purposes as needed. The associated stream factor penalty was 22.0%.
2. Routine dryer cleaning resulted in a stream factor penalty of 0.8%.
3. Dryer centrifuge pluggage resulted in a stream factor penalty of 0.6%.
4. Downtime due to bottlenecks in the sifter and pneumatic transfer systems resulted in a stream factor penalty of 0.4%.
5. Routine sock changes on dryer dust collectors resulted in a stream factor penalty of 0.2%.
6. Maintenance on dryer centrifuges, sifters, and activators resulted in a stream factor penalty of 1.0%.

Product Quality Summary

<u>Resin Type</u>	<u>Prime</u>	<u>"BC"</u>	<u>"H"</u>	<u>% of Total Production</u>	<u>Budget Prime Product Mix %</u>
5265	1,629,473	-	-	4.5	12.5
5305	3,105,825	107,150	-	9.0	11.25
5385	23,222,056	6,750	-	64.8	57.5
5425	6,127,409	-	-	17.1	13.75
5465	1,091,480	-	-	3.0	5.0
Sifter Overflow	-	-	140,140	0.4	-
Pond Resin	-	-	416,760	1.2	-
Total	35,176,243	113,900	556,900	100	100

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Product Quality Summary - continued

Quality performance for May was 98.1% customer grade with 0.3% "BC" production and 1.6% "H" grade production. A total of 417 M lbs. of pond resin was reclaimed during the month.

A total of three railcars were shipped as off-grade during the month which represented 2.4% of the 125 total resin hopper cars shipped.

<u>Ship Date</u>	<u>Car No.</u>	<u>Customer</u>	<u>Product</u>	<u>Reason</u>
5/6/83	CONX 45724	Continental Plastics	Resifted Sifter Overflow	Quality
5/10/83	CONX 45913	Charter Industries	Pond Resin	Quality
5/11/83	CONX 45740	Wexford	Resifted Sifter Overflow	Quality

The vinyl area received twenty-seven short lead time emergency type orders comprising 11.7% of the 231 Aberdeen resin shipments in May.

Monthly Variable Cost Performance

Variable costs for the month were favorable \$182.1 M with \$68.7 M due to price and \$113.4 M due to efficiency. Resin variable cost for the month was 23.729¢/lb. vs. the budgeted 24.245¢/lb.

The \$68.7 M favorable price variance was primarily attributed to lower than budgeted pricing of VCM freight charges, \$56.5 M; Lucidol 223 initiator, \$48.4 M; natural gas, \$53.4 M, and electricity, \$31.1 M.

The \$113.4 M favorable efficiency variance can be attributed to favorable variances of \$20.3 M in VCM efficiency, \$80.8 M in the utilities area and \$26.9 M due to deviation from the budgeted product slate.

VCM efficiency for the month was 1.00991 lbs. VCM/lb. PVC vs. the budgeted 1.01277 lbs. VCM/lb. PVC. Y.T.D. VCM efficiency is 1.00865.

Y.T.D. variable cost efficiency variances in the Vinyl department totaled \$482.4 M favorable.

Energy Performance/Progress

1. Plant energy consumption for the month was a record low 2530 BTU/lb. The previous low was 2638 BTU/lb. in February of this year.
2. A total of ten (10) steam leaks and four (4) air leaks were repaired in the plant.

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General

1. Packaging for the month totaled 579,140 pounds.
2. Resin raw material inventory in the 744 account totaled \$174 M at month end posting the lowest this year.
3. D-700 agitation test program was conducted by R & D personnel throughout the month. Five blade configurations were tested during the month with 100 batches being produced.
4. R & D personnel conducted a test run during the month with a new chain transfer agent, 2-mercaptoethanol. Two test batches were produced and were packaged with sample quantities forwarded to Ponca City for further quality testing.
5. R & D personnel conducted a test run during the month with a new killing agent, Inganox 423. A total of six experimental batches were produced.
6. One coarse batch was experienced during May in 742 reactor.