

VINYL - D. W. Hollis/M. L. Nathan

Safety

The Vinyl and Yard Departments operated without an injury in September.

Shift safety meeting topic for the month was Job Safety Analysis. Operating procedures, including safety aspects of several jobs in the Vinyl area, were discussed.

<u>Production</u>	<u>September</u>	<u>Fiscal 1985</u>
1. Production, MM Lbs.	31.1	411.7
2. Daily Production Rate, M Lbs./C.D.	1034.6	1128.0
3. Total Charges	785.0	10087.0
4. Charges, Reactor Batches/C.D.	26.2	27.7
5. Reactor Stream Factor	83.9	89.2
6. Dryer Rate, Average Lbs./Hr.	9642.0	10010.0
7. Dryer Stream Factor	55.9	60.1
8. Accounting Days	30	365

Vinyl Department production for September was 31.1MM pounds.

Reactors

The reactor stream factor for September was 83.9%. Downtime in the reactor area occurred as follows:

- 1) Operational Downtime: Accounted for 15.2% of the total downtime and was due to reactor recovery scheduling conflicts, no place to dump reactor slurry, and downtime due to severe weather conditions.
- 2) Maintenance Service Downtime: Accounted for 2.6% of the total downtime and was due to cleaning reactor AMS injection ports and slow vent lines.
- 3) Maintenance Repair/Revision Downtime: Accounted for 22.6% of the total downtime and was due to eight reactor valve changeouts, agitator seal replacements on 700 and 741, condenser cleanings on 742 and 745, and rupture disc replacement on 741.
- 4) New Module Turnaround: Accounted for 59.6% of the total downtime and was needed to complete preventive maintenance and maintenance repair work of a shutdown nature.

Dryers

The dryer stream factor for September was 55.9%. Downtime in the dryer area occurred as follows:

- 1) Reactor Limited Production: Accounted for 91.1% of the total downtime. Dryers were shut down when possible for energy conservation. Rotary dryers were shut down in conjunction with the new module outage.

VINYL - ContinuedDryers - continued

- 2) Operational Downtime: Accounted for 5.1% of the total downtime and was due to centrifuge plugging, burner flameouts, dryer cleaning, transfer activator problems, and downtime due to power outages. One bundle of hot water panels was removed from the fluid bed dryer due to leaks.
- 3) Maintenance Repair/Revision Downtime: Accounted for 3.8% of the total downtime and was due to activator, centrifuge and screener repairs.

Product Quality Summary

<u>Resin Type</u>	<u>Prime</u>	<u>"BC"</u>	<u>"H"</u>	<u>% of Total Production</u>
5265	1,863,893	-	-	6.0
5305	3,823,514	107,140	-	12.7
5385	15,716,789	1,082,460	-	54.1
5425	6,917,065	-	-	22.3
5465	824,790	-	-	2.7
Debox	-	451,760	-	1.5
Sifter Overflow	-	-	82,548	0.2
Pond Resin	167,920	-	-	0.5
Total	29,313,971	1,641,360	82,548	100.0

Quality performance for September was 99.7% customer grade with 0.3% "H" grade production.

A total of fifteen railcars were shipped as "B" grade during the month which represented 11.0% of the 136 total resin hopper cars shipped.

<u>Load Date</u>	<u>Ship Date</u>	<u>Car No.</u>	<u>Customer</u>	<u>Product</u>	<u>Reason</u>
8/22/85	9/03/85	PTLX 41598	Wexford	Debox	Quality
8/25/85	9/12/85	PTLX 41619	Vulcan	5385	Contamination ⁽¹⁾
8/26/85	9/12/85	VIPX 45709	Vulcan	5385	Contamination ⁽²⁾
8/15/85	9/13/85	PTLX 41596	Extrusion Technology	Debox	Quality
8/06/85	9/13/85	PLWX 44294	Extrusion Technology	5385	Contamination ⁽²⁾
8/31/85	9/17/85	PLWX 44291	Silverline	5385	Contamination ⁽²⁾
8/29/85	9/18/85	ERLX 6239	Grifco	5385	Contamination ⁽¹⁾
8/01/85	9/19/85	VIPX 45795	Vulcan	5385	Contamination ⁽²⁾

VINYL - ContinuedProduct Quality Summary - continued

<u>Load Date</u>	<u>Ship Date</u>	<u>Car No.</u>	<u>Customer</u>	<u>Product</u>	<u>Reason</u>
9/02/85	9/20/85	PLCX 43019	Extrusion Technology	Debox	Quality
8/28/85	9/20/85	PLCX 42994	Extrusion Technology	5385	Contamination ⁽¹⁾
9/10/85	9/23/85	VIPX 45748	Wexford	5385	Contamination ⁽²⁾
9/05/85	9/23/85	PTLX 41841	Wexford	Debox	Quality
8/07/85	9/30/85	VIPX 45260	Silverline	5385	Contamination ⁽¹⁾
9/18/85	9/30/85	ACFX 53415	Continental	Debox	Quality
7/28/85	9/30/85	PLCX 43701	Grifco	5385	Contamination ⁽²⁾

(1) Contamination due to operating problem with fluid bed dryer.

(2) This material was used for dryer cleanout.

The vinyl area received thirteen short lead time emergency type orders comprising 5.5% of the 236 Aberdeen resin shipments in September.

Monthly Variable Cost Performance

Variable costs for the month were favorable at \$1970.9M resulting from an overall favorable price variance of \$2139.9M and a net unfavorable efficiency variance of \$169.0M. Resin variable cost for the month was 18.203 ¢/lb. vs. the budgeted 24.605 ¢/lb.

The \$2139.9M favorable price variance was primarily attributed to lower than budgeted pricing for VCM, \$2065.9M; VCM freight, \$27.5M; process additives, \$16.4M; and utilities, \$30.0M.

The \$169.0M unfavorable efficiency variance can be attributed primarily to unfavorable VCM efficiency, \$177.7M. Favorable efficiency variances included natural gas, \$28.6M.

VCM efficiency for the month was 1.03195 lbs. VCM/lb. PVC versus the budgeted 1.00500 lbs. VCM/lb. PVC. Fiscal year 1985 efficiency was 1.00311. The poor efficiency experienced for September is under investigation.

Fiscal year 1985 variable cost efficiency variances in the Vinyl Department totaled \$746.3M favorable.

Energy Performance/Progress

1. Plant energy consumption for September totaled 2432 BTU/lb.
2. A total of nineteen steam leaks and one steam trap were repaired during the month.

Vinyl - ContinuedGeneral

1. Packaging for the month totaled 421,898 pounds.
2. Resin raw material in the 744 account totaled \$245.8M at month end.
3. A vibration study was performed on the fluid bed dryer on 10/2 to determine the cause of the cracks in the water panels. The cracks are being caused by a low frequency/high magnitude vibration. A design will be proposed by the vendor to modify the panel support structure in order to reduce the vibration.