

INTER-OFFICE MEMO **TENNECO CHEMICALS, INC.**

TO G.I. Rozand
FROM W.C. Champion
SUBJECT Revised Grading Procedures

AT Piscataway
AT Burlington

DATE February 20, 1974

COPY TO P. Gawason
H.R. Horton
F.W. Kanzler
R.A. Lojewski
File

Grading procedures for both resin and compound have been reviewed with the objective of reducing the amount of "Special Product" (i.e., ungraded) handling. The attached table provides current practice and recommended changes for achieving this end.

For resins, the changes will include grading of all LOP and SPA materials. This will require (especially for LOP where in-specification product is Grade I and out-of-specification product is not graded) a more rapid response in changing manufacturing specifications as required.

In compound, much of the "Special Production" is simply new color matches. Since standards are established for each new color prior to production, these products can be graded. For certain compounds, a "IS" grade similar to that employed in plastisol would be useful in showing that a run will meet customer requirements even though not meeting out internal manufacturing standards.

If you concur in these recommendations, I will take the action required to put them into effect.

W.C. Champion
(14)
W.C. Champion

Attachment.

WCC/jst

COLORITE 012516

RESIN GRADING PROCEDURES

<u>Type of Production</u>	<u>Procedure</u>	<u>Recommendation</u>
Normal Suspension Production	Graded I or E in accordance with established manufacturing specifications.	No change
Normal Plastisol Production	Graded I, IS or E in accordance with established manufacturing specifications.	No change
Limited Operating Procedure (LOP) Minor process, formula change or substitution of equivalent raw material. Not intended to change product properties.	Graded I if meets manufacturing specifications. Not graded ("Special Production") if out-of-specification.	Grade all LOP material in accordance with manufacturing specifications. Revise specifications as required.
Standard Product Adjustment (SPA) Minor changes in process, formula or raw materials which are intended to change product properties.	Not graded ("Special Production")	Grade all SPA material in accordance with the specifications established in the SPA.
New Product Introduction (NPI) Production of a product substantially different from any in our current product line.	Not graded ("Special Production")	No change

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COMPOUND GRADE GRADING PROCEDURES

<u>Type of Production</u>	<u>Procedure</u>	<u>Recommendation</u>
Normal Production	1. Graded I or E based on established manufacturing specifications. 2. Marketing will regrade all "E" material as I, II or III. 3. Quality Control monthly reporting is based on initial grading, i.e., "Right-First-Time".	No change, or regrade to "IS" designation where a specific customer has less stringent requirements (Note: This would <u>not</u> apply to such requirements as contamination or oversize.)
Limited Operating Procedure (LOP)	Not graded by Quality Control ("Special Production"). Release by R&D.	Grade I or E by Quality Control according to established manufacturing specifications. Release by R&D.
Standard Product Adjustment (SPA)	Not graded by Quality Control ("Special Production"). Release by R&D/Marketing.	Grade I or E according to specifications established in the SPA. Release by R&D/Marketing.
New Product Introduction (NPI)	Not graded by Quality Control ("Special Production")	No change
Custom Compound Production (CCP) Production of a customer's proprietary formula.	1. Initial run "Special Production" 2. Subsequent runs graded according to established specifications.	No change
New Colors of Standard Compounds	Not graded by Quality Control ("Special Production")	Grade as standard compound.

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