

W. D. Wesely

Flemington

March 13, 1969

H. B. Carr

Burlington

J. C. Fisher

E. L. Kanyok

Homopolymer Resin Specifications

D. C. Hawk

R. A. Vallette

Flemington Production has made some counter requests to the Homopolymer Specifications that were tentatively agreed to in the meeting of 2/28/69 with Quality Control, Customer Service Laboratory, and Process Engineering.

The specifications are attached for your review. Where M. E. Wagshul has requested an alternate specification, you will note that I have made comments as to my viewpoint. The first page lists specifications that are ready to-go while the succeeding pages list the few cases that remain to be ground out.

H. B. Carr

HBC/rjl

Attachment (6)

Sales No.	10R	150	175	225/16R	250-12	225-1	255
Series No.	42/43	10/11	12/13	22/23	38/39	36/37	34/35
Formula No.	173	552	549	120	122	127	148
Relative Viscosity	1.68-1.76	1.58-1.64	1.68-1.76	2.76-2.33	2.40-2.48	2.26-2.33	2.47-2.63
Dry Blend Time	3.0-6.0(a)	--	3.0-6.0(a)	6.0-8.0	6.0-8.0	4.2-6.0	6.0-8.2
Gels (max.)	30/moyle	20(b)	--	13	12	12	13
Bulk Density	36-40	37-41	36-40	30-34	30-33	29-33	29-33
Cont. (max)	20	20	20	20	20	20	20
Heat Stab. min.	70	70	70	90	90	90	90
Vols. % max.	0.9	1.0(d)	0.9	0.4	0.4	0.5	0.4
Volume Resist. min.	--	--	--	10	1.0(W.E)	10	10
+60	0-tr	0-tr	0-tr	0-tr	0-3	0-tr	0-3
+80	--	--	--	--	--	--	5-35
+100	0-30	0-10	0-30	40-70	40-70	40-70	--
-200	0-20	0-15	0-20	0-5	0-5	0-5	0-5

a-d Notes per original specs proposal

e. Brabender-Extruder Gel Test

	200-2 18/19 439	} incorporation of 200-1 and 200-2		200/12R 44/45 171	} incorporation of 200/12R and 200-3
Relative Viscosity	2.00-2.08			2.00-2.08	
Dry Blend Time	5.0-7.0			7.0-11.0	
Gels (max.)	13			10	
Bulk Density	31-35			34-37	
Cont. (max)	20			20	
Heat Stab. " n.	90	This incorporation has been made sticky by the recent EPA 124-1		100	This incorporation would provide a higher heat stability
Vols. % max.	0.7	which extends the Dry Blend of 200-2 to 9.5.		0.5	resin. Increase in cost would be offset by using Lup 11 as catalyst. If this were OKed.
Volume Resist. min.	--			--	this resin could be NPI'd initially.
+60	0-tr			0-tr	
+80	--			--	
+100	10-40			10-40	
-200	0-5			0-5	

specification was recommended by M.E. Wagshall (in pencil) 3/25/69

Production Request (in red)
3/5/69

	200-1 16/17 436		200-2 18/19 439	
Relative Viscosity	2.00-2.08		2.00-2.08	(M.E. Wagshall)
Dry Blend Time	5.0-6.5		(5.1-7.5)	Per SPA 724-1 issued 2/27/69. Also, MEN claims it costs .05-.10 more to hold at 7.0 than 7.5.
Gels (max.)	13		13	
Bulk Density	31-35		30-34 (32-36)	(M.E. Wagshall) As of 3/8/69 average of 20 lots was 34.6. It is recommended that this
Cont. (max)	20		20	revision be adopted in view of the higher O.B. spec
Heat stab. in.	85		85	
Vols. % max.	0.7		0.7	
Volume Resist. min.	--		--	
+60	0-tr		0-tr	
+80	--		--	
+100	20-50		3-33	
-200	0-5 (0-7)	(M.E. Wagshall) As of 3/8/69 average of 20 lots was 2.2 & therefore present 0-5 should be kept.	0-5 (0-7)	(M.E. Wagshall) As of 3/8/69 average of 20 lots was 1.25 & therefore present 0-5 should be kept.

Screen

Specifications Recommended By Q.C., C.S.L., PE (in pencil)
2/24/69

Production Request line
3/5/69

	200/12R 14/15 433	200-3 44/45 171
Relative Viscosity	2.00-2.08	2.00-2.08
Dry Blend Time	7.0-11.0	7.0-11.0
Gels (max.)	13	10
Bulk Density	34-37	34-37
Cont. (max)	20	20
Heat Stab. min.	85	100
Vols. % max.	0.7	0.5
Volume Resist. min.	--	--
+60	0-tr	0-tr
+80	--	--
+100	10-40	10-40
-200	0-5 (0-7)	0-5 (0-7)

Screen

(M.E. Wagschul)
As of 3/13/69 average of 19 lots was 1.5+ therefore, present spec. should be kept.

(M.E. Wagschul)
As of 3/13/69 average of 20 lots was 1.9 + therefore, present spec. should be kept.

Specifications Recommended By G.C., Ltd., PE (in part of 1/10)
Production Request (in red)

7/13/69

250
26/27
125

250-1
28/29
141

Relative
Viscosity

2.31-2.39

2.31-2.39

Dry Blend
Time

5.6-7.0

4.5-5.7

Gels
(max.)

12

12

Bulk
Density

29-34

29-33

(M.E. Wagshal)

(28-33)

AP Hallmayer
27.5 - 32

As of 3/8/69 Flemington

Cont.
(max)

20

20

had averaged 28.9 for 20
lots. It is recommended
that M.E.W.'s request
be approved.

Heat stab.
min.

90

90

Vols. 90
max.

0.4

0.4

Volume
Resist.
min.

10

10

+60

0-3

0-3

+80

10-40

(M.E. Wagshal)

(5-35)

As of 3/8/69

--

+100

--

Flemington had
averaged for
20 previous lots
19.0 +80 which
would indicate
that this spec.
can be met.
Further, it offers

50-80

-200

0-5

0-5

assurance of
meeting the
Flat Field 62+100 requirement.

screen

Spec. *Grainmills* *Proven* *adul* *11*, *20*, *312*, *12* *(comp)*

Production Report (in red)

3/8/69

	250-3 32/33 162		250-4 40/41 150
Relative Viscosity	2.47-2.55		2.47-2.55
Dry Blend Time	5.5-7.0		5.5-7.0
Gels (max.)	13		13
Bulk Density	28-32		28-32
Cont. (max)	20		20
Heat Stab. min.	100		100
Vols. % max.	0.4		0.4
Volume Resist. min.	10		10
+60	0-3		0-12
+80	(1) 12-40	(M.E. Wagon) (5-35) As of 3/8/69 average of 20 lots was 12.0 which does not allow Production any room at all.	(2) 0-12
+100	--		--
-200	0-3		0-5

screen

(1) Per D.C. Hawk 3/10/69 this could be lowered to 10 or even 8 with an overlay
(2) Per D.C. Hawk 3/10/69 this could be lowered to 0-10.

P. R. Scarito

Burlington

March 13, 1969

H. B. Carr

Burlington

J. C. Fisher

E. L. Kanyok

Realignment of Quality Control Laboratory
Working Hours

In order to better conform to the workload in the Quality Control Laboratory, the following change in the shift schedule will be made as provided in our contract effective March 17, 1969 subject to the following:

1. Eight technicians will be on the regular rotating shift basis.
2. The normal hours for the ninth technician will be from 0800 to 1630 Monday through Friday.
3. This technician may be assigned to cover rotating shift absences and vacations. In this case, his shift will not be covered.

H. B. Carr

HBC/rjl