

SAFETY - C. M. Markerson/J. V. Uptain

	<u>Dec.</u>	<u>Fiscal</u> <u>Y.T.D. 1995</u>	<u>Y.T.D. 1994</u>
First Aid	1	7	6
OSHA Recordable	<u>0</u>	<u>1</u>	<u>3</u>
Total Injuries	1	8	9
Number of Restricted Workday Cases	0	0	1
Number of Lost Workday Cases	0	0	0

Injuries by Department

Vinyl Operations	0	1	0
Compound Operations	1	3	4
Maintenance	0	3	2
Laboratory	0	0	1
Receiving/Warehouse	0	0	2
Office	<u>0</u>	<u>1</u>	<u>0</u>
Totals	1	8	9

Injuries by Type

Cuts and Abrasions	1	5	5
Eye Injuries	0	0	0
Burns	0	2	1
Bruises	0	0	2
Strains/Sprains	0	0	1
Stings	0	1	0
Other	<u>0</u>	<u>0</u>	<u>0</u>
Totals	1	8	9

Non-Occupational Injuries

Lost Workday Cases	0	0	4
Days Lost	0	0	101

Contractor Injuries

First Aid Cases	0	0	1
Medical Treatment Cases	0	0	0
Lost Workday Cases	0	0	0

Safety Record

Last lost time injury - 01/22/94
 Days since - 343
 Employee hours since - 425,851

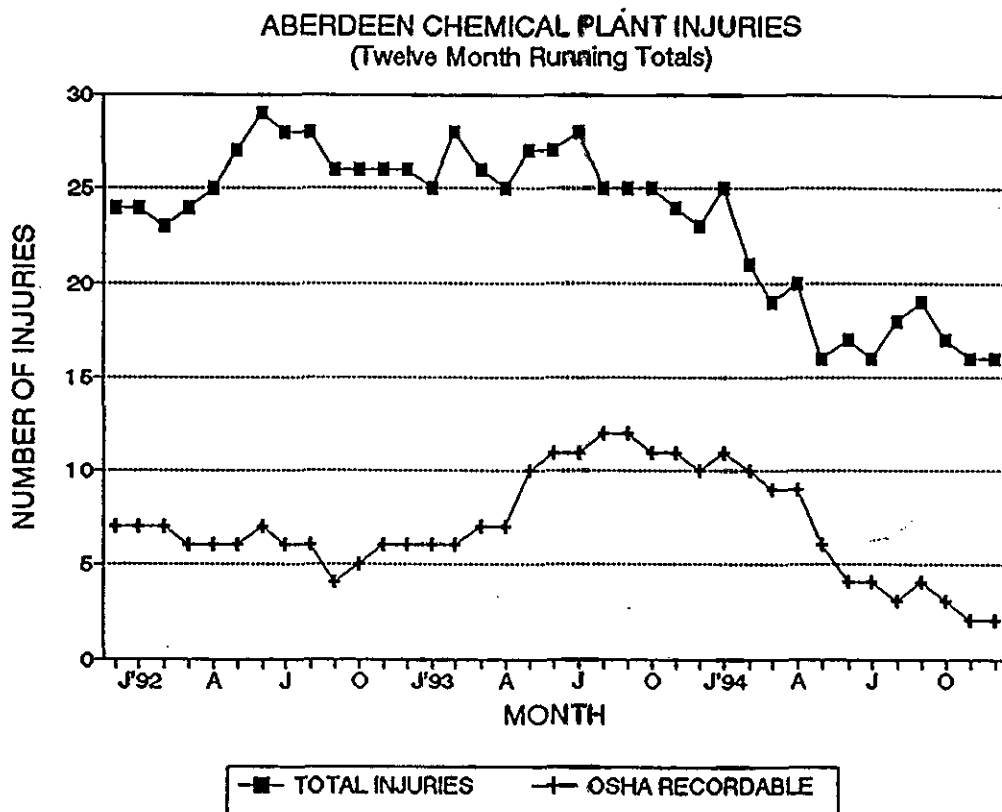
On December 31, 1994, the employees of the Aberdeen Plant completed 343 days with no lost time injury.

Routine dosimetry results for the month were:

<u>Chemical</u>	<u>< PEL</u>		<u>> PEL</u>	
	<u>Number</u>	<u>Percent</u>	<u>Number</u>	<u>Percent</u>
VCM	61	100.0	0	0
Lead	2	100.0	0	0
Total Particulates	1	100.0	0	0

SAFETY - ContinuedMonthly Injury Summary

<u>Injury Class</u>	<u>Department</u>	<u>Description</u>
FA	Compound	Cut finger.



COST VARIANCES - J. D. Olson**Variable Costs**

<u>Product</u>	<u>Dec., 94 Variance, \$M</u>		
	<u>Efficiency</u>	<u>Price</u>	<u>Total</u>
PVC	210.8	<2593.3>	<2382.5>
Flexible Compound	195.5	< 451.3>	< 255.8>
Plasticizer	< 29.7>	< 54.3	< 84.0>
Total	376.6	<3098.9>	<2722.3>

PVC Resin

The favorable efficiency variance for PVC was due to a favorable VCM efficiency on a total production basis. High off-grade production resulted from an accounting adjustment made for seven railcars of resin produced in November. These seven railcars were down-graded from 5385 to off-grade due to contamination with a Barium stabilizer which was accidentally added to the resin.

Flexible Compound and Plasticizer

The Compound negative price variance is due in part to higher than budgeted resin transfer prices and antimony oxide prices, and is offset by favorable aluminum trihydrate prices. The negative Plasticizer price variance is due to phthalic anhydride and alcohol pricing.

Major Price Variances

	<u>Variance - \$M</u>
- VCM	<2807.3>
- Resin to Compound	< 304.8>
- Antimony Oxide	< 108.4>
- Aluminum Trihydrate Filler	68.8
- Phthalic Anhydride	< 43.5>
- Alcohol	< 60.5>

VINYL - J. D. Olson, W. S. Carroll**Safety**

The Vinyl Department had no injuries in December.

The monthly safety meetings were held on shift.

General

December production was 49.8MM pounds of which 47.1MM pounds was prime grade resin. This is a new all-time monthly production record surpassing the previous record of 48.9MM set in October, 1994. Percent asset utilization was 92.5%.

VINYL - Continued**General - continued**

Production of 2QFY95 was 145.7MM which is a new quarterly production record surpassing the previous mark of 144.2MM set 1QFY95.

Annual production for CY94 was 540.2MM.

	<u>Dec.</u>	<u>YTD</u>
- Production, MM Lbs.	49.8	289.5
- Reactor Stream Factor, %	95.2	95.3
- Resin Quality, % Prime	94.6	97.0
- VCM Efficiency, Lbs./Lb.	1.0377	1.0369
- Daily Rate, M Lbs./C.D.	1605	1573
- Capacity Utilization Factor, %	111.6	109.4
- Total Reactor Charges	1131.0	6515.0
- Charges/C.D.	36.5	35.4
- Rotary Dryer Stream Factor (#4-#8), %	93.4	95.9
- Fluid Bed Dryer Stream Factor, %	95.3	97.4

Reactor Downtime**Hours**

- Operational downtime (recovery scheduling conflicts - 203 hours, hydroblast two reactors- 43 hours).	259.0
- Mechanical downtime (replace D-700 seal - 18 hours, repair Old Module process water line - 17 hours, repair New Module hot water charge tank - 16 hours).	95.0

Dryer Downtime**Hours**

- Operational downtime (cleaning, product changes, and centrifuge plugs).	78
- Mechanical downtime	65
- Reactor limited production	139

COMPOUND - S. C. Hillman**Safety**

The Compound Department had no OSHA recordable injury during the month.

General

Compound prime production in December totaled 7.5MM pounds. This is the highest monthly production in Compound since April, 1989.

Plasticizer production totaled 1.7MM pounds in December.

COMPOUND - Continued

<u>Compound Production</u>	<u>Operating Days</u>	<u>Production M (Lbs).</u>		
		<u>Month</u>	<u>Avg./Day</u>	<u>Fiscal Y.T.D.</u>
Line I	31	2006	65	11717
Line III	31	4260	137	24279
Line V	31	1279	41	7138
Total		7545	243	43134
% Prime		98.0		97.0
Capacity Utilization Factor		98.1		95.4

DowntimeHoursLine I

- Product Changes	86
- Miscellaneous Maintenance	37
- Quality	10

Line III

- Product Changes	57
- Miscellaneous Maintenance	30
- Quality	9

Line V

- Product Changes	33
- Miscellaneous Maintenance	39
- Quality	29

	<u>Operating Days</u>	<u>Production (M Lbs.)</u>		
		<u>Month</u>	<u>Avg./Day</u>	<u>Fiscal Y.T.D.</u>
Plasticizer	31	1721	56	10928
% Prime		84.7		85.5
Capacity Utilization Factor		85.2		91.1

ENGINEERING - J. E. Nickerson, T. R. Mackay, R. H. SneedOSHA Process SafetyProcedures

Propane System procedures were completed and approved.

HAZOPS

The New Module HAZOP line-by-line analysis is complete. Completion of the New Module and SA Module HAZOPS is scheduled.

ENGINEERING - Continued

Reactor Sight Glass Installation

The design for the reactor sight glass has been changed from reactor 600 to reactor 741. This required a smaller flange than that required for reactor 600. As a result, a smaller view window had to be used. The design and calculations have been approved by GED and the window assembly is being fabricated.

New Module Recovery Observation

Most of the equipment has arrived and arrangements have been made for the fabrication and installation of the piping. The wiring of cable for the camera is installed. Piping will be ready for installation at the end of this month.

Calcium Stearate Addition Upgrade

Dry calcium stearate is being used in the fluid bed dryer with 5385. Dry calcium stearate is also used in the rotary dryers as long as the bulk density remains above specification limits. If the bulk density falls below specification, then wet calcium stearate is used. Ways to allow continual use of dry stearate in the rotary dryers are being explored.

VCM Vapor Lines Winterization

Most of the heat tracing has been installed along with insulation. Power has not been connected due to delay in getting circuit breakers. All of the circuits except the one for the loading rack should be operational shortly after the arrival of the remaining equipment.

P-1 Reactor Header Modifications and Control Valve Replacement

The vacuum breaker for coil draining has been installed and tested on reactor 1. Modifications to the first reactor should be complete for a startup sometime in February. The control valve replacement has already been completed for the first reactor. This project will reduce batch cycle times by as much as three hours by improving the heatup and cool down times.

V-10 Slurry Transfer System Upgrade

This project, funded by Conoco, will replace the slurry transfer pumps currently being used in the Pond 2 resin drying system. Other piping modifications will be completed to reduce downtime associated with plugged pipes and pump maintenance. The design and estimate were presented to Conoco and approval for the project has been obtained.

ENGINEERING - Continued**New Module Charge Water System Upgrade**

This project will install a new hot water charge pump and associated piping in the New Module. This will provide faster charges and allow simultaneous charge and rinse. Construction is mostly complete. Final tie-ins and programming will be completed during the DCS shutdown in late January.

Economy Surplus Power Conversion

Estimation of various plant loads is complete. A plant electrical curtailment plan is being drafted for potential temporary reductions in power. Contract negotiations with the Aberdeen Water and Light and TVA are in progress.

Suspending Agent Charge Modifications

A test run proposal to charge suspending agent into the water charge header has been approved. Mechanical design is in progress. Testing of the modifications is scheduled to begin in March, 1995.

Recovery Compressor Addition for Old Module

This project adds another compressor to the Old Module to decrease recovery times. Calculations show a production increase of 2.3MM lbs./year with the decreased recovery times. The project has been reviewed and turned in for AFE approval.

Activator Replacement and Resin Transfer Improvements

This project replaces the activator on dryer #8 with a new dense phase transfer system. This system will require less air and will be able to transfer up to 25,000 lbs./hr. The feeder has been ordered.

Reactor 600 Larger Batch Trial

The larger batch trials have been switched to the New Module. The nuclear level gauge will be installed on reactor 741. The AFE has been approved.

ENVIRONMENTAL - K. G. Akins**Water**

The monthly average limit for chemical oxygen demand (COD) was exceeded for the month of December. Concentrations of COD in the discharge were within normal ranges, however, higher than average flows caused the mass limit to be exceeded.

ENVIRONMENTAL - Continued**Water - continued**

BOD₅ values for the same period were well within permitted values. The NPDES permit was modified in 1993 to increase the permit limits for BOD₅, but due to an oversight, the COD limits were not accordingly adjusted.

The Aberdeen Plant submitted a proposed Toxicity Reduction Evacuation Plan to the DEQ on 1/10/95 to address whole effluent toxicity testing failures.

Air

On December 14 - 15, for the period of 22:00 to 1:00 hours, the incinerator stack gas chromatograph indicated the exhaust gas averaged 10.6 ppm VCM. Operating data indicated low flow rates, normal VCM content in feed, and firebox temperatures > 2000 degrees F.

Based on the above operating data, it is highly unlikely that actual VCM concentrations in the stack were as measured. However, the incident will be reported on the quarterly NESHAPS report with an explanation.

Wastes

A bulk shipment of waste oil was shipped to Chemical Fisher Industrial Service in Gadsden, Alabama.

KEY ENVIRONMENTAL COMPLIANCE DATA

	<u>MONTH</u>	<u>FYTD</u>
Stormwater Outfall Excursions	0	0
Wastewater Outfall Excursions	1	2
Reportable NESHAP Excursions	1	1
Reportable non-NESHAP Air Excursions	0	0
CERCLA/SARA Reportable Incidents	0	0
Other Reportable Incidents	0	0
Citations and NOV's Received	0	0