

FOSECO, INC.

INTER-COMPANY AND INTER-DEPARTMENTAL CORRESPONDENCE

TO: T. R. Bernardi

FROM: J. T. Vrh

DATE: May 3, 1974

SUBJECT: Production/Scrap
April, 1974

I. Department 108 - One Piece Tops

Pieces produced	17,594
Pieces scrapped	360
Percent scrap	2.0%
Percent scrap March	1.9%

The scrap rate of 2.0% in April, a figure comparable with March rate of 1.9%.

Asbestos free material was again tested in the production of 538M and 390E one piece tops. These tests, however, produced unsuitable product. A memo on the subject was written to cover the problems earlier in the month of April.

The problems concerning the use of double wiper strips on 538 one piece tops for Republic Steel continues.

In an attempt to solve this, the problem of making the double wiper strip fit the top in its green state at the machine, Chicago personnel reduced the size of the flange in the tool and receiver by 1/16 inch along each edge and 1/8 inch in the corner radius. This action eliminated the problem of wiper strips not fitting the top produced. However, the Wiper strips in general are too large when fitted into the ingot molds.

Wisconsin Steel is now receiving the 390F one piece top which is 1¼ inches taller than the once used 390E. Damaged shipping racks are causing packaging problems as there is minimal clearance between the tops and the rods in the center stacking position.

Slumping, breakage, and burnt tops were the primary causes of scrap.

II. Department 114

A. Proflex Rings

Pieces produced	10,670
Pieces scrapped	286
Percent scrap	2.7%
Percent scrap March	4.5%

The April scrap rate of 2.7% was lower than the March scrap rate of 4.5%.

Undercuring and warpage continue to be the major problems. The 941B tool has been returned to Cleveland for redesign from a two piece to a four piece ring.

B. Multi-piece

Pieces produced	45,370
Pieces scrapped	3,806
Percent scrap	8.4%
Percent scrap March	5.0%

The scrap rate in April of 8.4% was higher than the March figure of 5.0%. There are three primary causes of scrap produced on Super G.

1. Malforming, caused by plugged tool screening. This situation has increased since beginning usage of raw materials RM X3578 and RM X3211. It now appears that rescreening is necessary every two weeks. An improved water spray system has been installed to attempt better washing of the screen.

2. Thin product. In an attempt to reduce the problem of the slurry valve diaphram breaking a charge was made to the pump system. Now the pump has a clutch. This, however, has led to a new problem. Periodically, one out of every seven cycles will run thin boards, probably due to the pump activating. Action must be taken on this problem.

3. Cracking from hanging dryer rods continues. Dryer repair needed.

Production on K-4 remains slow at the present. Forming, due to tooling misalignment, still a problem. Adjustments attempted to improve alignment were not successful. I still feel that these tools should be pinned and bushed so that proper alignment can be achieved.

III. Department 110

Product	Batches Produced
Koron 200	41
Koron 160	30
Moldcote EP 1677A	2
Terrapaint 55M/80	11
Dexil 60	5

No problems experienced.

1917

dfw

cc: W. C. Fletcher