

FOSECO, INC.

INTER-COMPANY AND INTER-DEPARTMENTAL CORRESPONDENCE

TO: T. R. Bernardi

FROM: J. T. Vrh

DATE: March 4, 1974

SUBJECT: Scrap/Production
February, 1974

I. Department 108 (One-piece)

Pieces Produced	14,393
Pieces Scrapped	439
Scrap Rate	3.1%
Scrap Rate, January	2.6%

The increased scrap rate in February can be attributed to the following areas:

1. Burning and sagging of 538 tops due to inconsistencies in surfactant properties (RM X1281) used. The amounts of X1281 needed in the slurry from day to day varied from 1 to 3 pounds depending on the drum of surfactant being used. Excessive oil not only caused forming difficulties but enhanced the possibilities of tops burning.
2. Attempts to produce Wisconsin Steel tops (390E) in asbestos free slurry again resulted in 30% scrap. Sagging and thickness variation being the main problem.
3. A lack of concern on the part of machine operators to properly control production (thickness) was also observed. This situation was quickly brought into control.

It was necessary to remove the No. 1 538 tool from production for rescreening as the flange area of the tool became so badly plugged that sub-quality product resulted. The tool was sent to Cleveland for rescreening. This situation, however, I believe created a situation that has occurred in the past when it has become necessary to use the No. 2 538 tool. This being a small top as this tool is smaller than the No. 1 tool.

The top, therefore, fits extremely loose in the casting and, thus, I believe, has added to the complaints from Republic Steel of increased seal leaks.



R. Callahan has been advised of this situation and I have requested that he alter the No. 2 tool to the same dimensions of the No. 1 tool. He has taken the measurements of the No. 1 tool while he was having it rescreened.

Sixty 538 tops having the redesigned double wiper strips were sent into Republic Steel for evaluation. Initial indications are of a positive nature.

II. Department 114

A) Rings

Pieces Produced	9168
Pieces Scrapped	419
Scrap Rate	4.6%
Scrap Rate, January	3.2%

The primary jump in scrap rate during the production of Seal-On rings resulted during the last two days of the month. Here, as in one-piece tops, the surfactant problem became very prominent. Fifty percent of the scrap can be traced to the under use of surfactant either through varying properties of the material or through conservation measures attempted to conserve the inventory of this raw material.

These areas, however, caused the slurry to become lumpy, and thereby, caused weak tops due to malforming.

B) Multiple Profax

Pieces Produced	61,640
Pieces Scrapped	6,441
Scrap Rate	10.4%
Scrap Rate, January	4.5%

The tremendous jump in scrap rate in this area can be traced to slurry problems and from burning. During this month it was necessary to run Proflex materials for a period of three consecutive days. When returning to Profax, improper forming immediately occurred.

First off, heavy sticking of product to the tool screen, the material at this point being extremely dry probably due to heavy amounts of surfactant being concentrated in the reclaimed water.

To offset this problem, the water reclaimed tank was drained and fresh water added. This action, however, now caused the slurry produced not to dewater properly.

Through additions of ammonium hydroxide and anti-foam, the problem worked itself out as the water regained its proper working properties. This forming difficulty, however, resulted in 1968 pieces of scrap.

Throughout Proflex runs, burning of product resulted, for no apparent reason. This problem, which resulted in 25% of the reported scrap, is being closely watched.

One area of scrap that can be traced to carelessness is that of operators discarding good product when the dry vacuum box fails to pick up product for one reason or another. Rather than placing the good product onto the finished good conveyor, good and bad product was being discarded. This action is being stopped.

Finally, the need to remove at last count, 20 dryers from the system which are causing warped and cracked boards is underway.

An attempt was made to produce 326 rings on Super G again. The rings produced were definitely weaker than No. 7 produced rings plus, if the tool screen is at all plugged, holes are left in the finished product.

III. Department 110

<u>Product</u>	<u>Batches Produced</u>
Koron 200W	43
Koron 160W	19
Koron 180W	3
Koron 205W	3
Terrapaint 55M	6
Ceramol 55/90	3
Ceramol 660/90	3

All product produced in Department 110 were within specification. It should be noted that viscosity and baume' difficulties mentioned in January report concerning Ceramol 660/90 were overcome by changing the sequence of raw material additions.

This change was simply to add RM 543 into the batch during the second step of manufacturing, thereby allowing this material more time to go into solution. RM 543 was originally added during step three.

D. Schultz was advised of this change.

dfw

cc: W. C. Fletcher