FILE NAME: Firestone (FIRE)

DATE: 1982

DOC#: FIRE007

DOCUMENT DESCRIPTION: History and description of Firestone Decatur Plant [Ex. 41]

APPENDIX B

Section 3-POSTAGE METER RECORD BOOK

Those departments that have their own postage meters are required by Federal law to keep a Meter Record Book (Form 3602-A), showing register readings of metered mail on each day of operation of the meter. Meter Record Books must be retained for at least one year from the date of final entry. (*See* 39 C.F.R. § 501 *et. seq.*).

Updated 9/2005

Pltf Exh

041

10/31/82

DECATUR, ILLINOIS

TIRES, TUBES AND CAMELBACK

History

The Decatur Plant is located on North 22nd Street in Decatur. It was originally constructed in 1943 as the Victory Ordnance Plant. Major products were T87 Power Trains for Caterpillar D-7 Tractors. The Firestone Tire & Rubber Company purchased this facility in 1962 from the government. The first tire was cured February 14, 1963. The 1966 Expansion increased the capacity of the plant to 26,000 tires per day. The 1969 Expansion Program provided facilities for the production of 10,560 radial tires, with total capacity remaining at 26,000 tires per day. In 1970, production equipment was purchased and installed to provide the facilities for producing 200 steel belted bias tires and 1,200 steel belted radial tires, with the total capacity remaining at 26,000 tires per day. The 1972 Expansion provided production capacity to produce 20,000 steel belted radial tires per day while reducing the total tire capacity to 22,350 per day. A refinement to the 1972 Expansion Program provided for an additional 1,500 radial steel tires per day, bringing the total to 21,500, while the total tire capacity increased to 24,000 tires per day. Modifications to our truck tire building capacity increased our plant rated daily capacity to 24,600 tires per day. The H.D. Expansion Program, completed in fiscal 1978, increased plant rated daily capacity to 25,100 tires per day. Phase I of a Light Truck Radial (LTR) conversion was approved and begun in 1979. Under this program, the plant rated capacity included 2,500 light truck radials, 20,000 passenger radials, and 3,900 bias truck tires/day. In 1980, a second LTR conversion program was approved (Phase II, Rev.1). This is a long range program, ultimately giving Decatur the ability to produce up to 6,500 LTR tires/day. Since both LTR's and passenger radials can be built on the same machines, Decatur is flexible in its ticket mix. It can vary from 6,500 LTR's and 14,000 passenger radials/day to -0- LTR's and 21,500 passenger radials/day. Decatur is in the process of a bias truck tire conversion program which will consolidate sizes and types of tires in certain plants, increasing Decatur's bias truck production to 4,200 tires/day by January, 1983.

Acreage	153.2 Acres	
Floor Space		
Production Area	1,331,404	
Finished Goods Storage	443,980	
Raw Materials Storage	124,240	
Office Area	62,150	
Total Area	1,961,774	Sq. Ft.
Leased Storage Areas	185,000	
Grand Total	2,146,774	Sq. Ft.

Power Facilities

1. Boiler Capacity (3 units)		
1 Unit - 100,000 lbs/hr. Gas-Oil	500	P.S.I.
1 Unit - 100,000 lbs/hr. Gas-Oil	300	P.S.I.
1 Unit - 100,000 lbs/hr. Gas-Oil	400	P.S.I.
2. 100# Compressed Air (5 units)	14,500	CFM
3. Instrument Air Compressor	400	CFM
4. Deep Well Capacity - None		
5. Incoming Transformer Capacity	37,500	KVA
6. Refrigeration - (3 units)	3,600	Tons
7. Refrigerated Compressed Air Dryer (1 unit)	70	Tons

Average Power Consumption - Average Month YTD through September 1982

1.	M KWH Consumed per M Lbs of Production	.6778
2.	Power Cost per M Lbs of Production	$43.29
3.	M Lbs of Steam per M Lbs of Production	4.5924
4.	Cubic feet of air per M Lbs of Production	30.1629
5.	Gallons of water per M Lbs of Production	1.2094

Capacity - Daily	Previous	1983 Approved Plant Capacity
A-3	180 Units	300 Units
A-4	620	800
A-5	1,600	3,100
A-6	1,000	-
Front Tractor	200	-
A5/A6 Radial		3,650
Passenger - Radial	21,500	19,000
Total	25,100 Units	26,850 Units
Total Tire Weight	682,676 Units	846,215
Camelback Weight	20,000	20,000
Miscellaneous	11,748	11,748
Total Weight	714,424	877,963

Enrollment - Average 1982/83

Salary	488
Clock	1,631
Total	2,119

MAJOR EQUIPMENT ITEMS

Dept. 112 - Compounding & Mixing

2 - 60" Mills
1 - #11 Banbury (Final Mix 30/50 R.P.M.)
2 - #11 Banbury Mixer (2 Final Mix 30 R.P.M.)
1 - #11 Banbury Final Mix 40 R.P.M.
3 - #27 Banbury Mixer 50 R.P.M. (Master Batch/Remill)
2 - Bale Cutter, Spadone
3 - 20" Pelletizer
3 - 84" Mills
4 - 48" Batch-off Machines (Belts, soap tanks, wig wags, shifters)
3 - 48" Mills

Dept. 115 - Refiner Mills

3 - 20" x 32" x 36" Refiner
2 - 26" x 26" x 36" Cracker

Dept. 121 - Steel Cord Calendering

1 - 4 Roll Inclined Z Calender - 70 Y.P.M.
2 - Creel Rooms (2,592 total spool letoffs)
4 - 84" Mills
1 - Dual Fabric Letoff Train w/Hydraulic Compensator
2 - Automatic Slab Loaders

Dept. 122 - Dipping & Calendering

1 - 4-Roll Calender - 70 Y.P.M.
1 - Dip Unit, Rayon - 75 Y.P.M. (designed for revising to handle nylon)
10 - 84" Mills
1 - 3-Roll G.P. Calender
1 - 3-Roll Innerliner Calender
1 - 2-Roll Contour Calender
2 - 12,000 Gal. Latex Storage Tanks
1 - 2,000# Weigh Tank
1 - 1,500 Gal. Mix Tank
4 - Automatic Slab Loaders

Dept. 123 - Stock Cutting

2 - Banner Bias Cutters NRM 66-90-360
2 - Banner Bias Cutters NRM 66-45-360
2 - H.D. Bias Cutters
1 - Spadone #100 Bias Cutter
8 - Free Loop Guiding & Spindle Windups
1 - Fabric Dual Surface Windups
1 - H.D. Gum Insert Calender with Single 84" Mill
1 - Rotary Bias Cutter
1 - Auto-Fabric Ply Transfer Unit
1 - Tread Ply Assembly Unit with Automatic Letoff
2 - 48" Liner Reroll Table
1 - Chafer Assembly Unit
2 - Cameron Slitter
2 - Tread Ply Gum Wedge Application Table
1 - H.D. Gum Insert Calender with 6" C.F. Extruder
1 - Dual Letoff, Dual Windup Tread Ply Gum Wedge Application Table

Dept. 124 - Bead Making

4 - Bead Wire Winders
1 - 14 Unit Letoff
2 - 12 Unit Letoffs
4 - 2 1/2" NRM Extruder
4 - Side Lapped Bead Splice Press
1 - Wire Sizer
17 - #612A Utility Bead Reinforcing Machine
2 - H.D. General Purpose Bead Reinforcing Machine
1 - Mark II Semi-Automatic Bead Machine
2 - Spiral Wrap Bead Machine
2 - Extruded Bead Filler Bead Assembly Machine (1-single & 1-dual)
1 - Continuous Strip Cutter
4 - Extruder Temp. Control Unit
1 - 10 Unit Letoff

Dept. 126 - Tubing - Tread & Sidewall

1 - A.S.M. Tread Slitter
1 - 8"x10" Tread & Sidewall Tubing Unit
1 - 10"x10" Tread & Sidewall Tubing Unit
3 - 60" Warm-up Mills
3 - 36" Cushion Calender
2 - 36" High Speed Tread Cutter
1 - 8" Rubber Extruder with Reducer
19 - 84" Mills, 3 of which are equipped with WSW Blending Belts
1 - 6x6 Preassembled WSW Unit
1 - 12"x12" Cushion Calender
1 - Offline Slitter
4 - Slab Loaders
1 - 10" Extruder System

Dept. 131 - Heavy Duty Tire Building

2 - #80 T.A.M.'s with #180 Server
3 - #80 T.A.M.'s with 8 Ply Side Loader Server
2 - #80 T.A.M.'s with #180 Server
10 - #59 T.A.M.'s with #146 Server
4 - #46 T.A.M.'s with #146 Server
1 - Lot Conveyors
5 - #46 T.A.M.'s with #146 Server (9-Ply)

Dept. 133 - Passenger Final Inspection

4 - Trimmers, Dual Pin Vent
13 - Inside Inspection Machines
1 - Dual Station Cold Brander
32 - Meath Spotters
2 - Winner Curing Stands
1 - Vita-Cap Heater
2 - Universal Vulcanizer Model 360
3 - Single Station Cold Branders
1 - WSW Lathe
8 - Wolverine Benches
2 - Tire Spreaders
1 - Single Trimmer
1 - Passenger Tire Changer
1 - Lot Conveyors
5 - Tire Inflation Stands
2 - Bead Repair Presses

Dept. 139 - H.D. Final Inspection

1 - Single Trimmer
2 - Dual Trimmers
2 - Micro Poise Balancers
1 - Lot Conveyors
2 - Meath Spotters (Steam
3 - Tire Spreaders
1 - H D. Spot-Au-Matic
2 - 1191 Concentricity Machines
1 - H.D. Tire Lift/Spreader
1 - Single Station Cold Brander

Dept. 149 - Pass. Tire Final Insp. Grading, Correction & W.S.W. Grinding

16 - Manual Tire Balancing Units
18 - Tire Uniformity Optimers
4 - Spadone W.S.W. Grinders
15 - Firwood W.S.W. Grinders
2 - Jay-Em 4600 CARE Machines
1 - Automatic Belt Sanders
4 - 2910 Automatic Tire Balancers
1 - Passenger Spot-Au-Matic
1 - Lot Conveyors
2 - T.S.I.S. Manual Inspection Stands

Dept. 150 - H.D. Tire Final Inspection Grading & Correction

3 - 2910 Automatic Tire Balancer
2 - Light Truck Tire T.U.O. & Conveyor System

Dept. 153 - Flap Curing

6 - Flap Presses
39 - Flap Molds
4 - Patch Presses

Dept. 158 - Waste Control

1 - Filler Wax Unit (Waxer & Lathe)
2 - 63" Liner Reroll Table
1 - 48" Liner Reroll Table
3 - 20" Liner Reroll Tables
4 - Chafer Reroll Tables
1 - Poly Baler
1 - Steel Stab. Ply Trimming Table
1 - Steel Stab. Ply Reroll Table
2 - Fabric Trim Tables
6 - Liner Sewing Machines

Dept. 161 - Green Tire Storage

19 - Radial Tire Splice Presses
5 - Plummer Doping Units, Radial Green Tire, Automatic
1 - Lot Green Tire Conveyors
1 - H.D. Tire Doper
1 - H.D. Tire Splice Presses

Dept. 166 - Passenger Curing
187 - 40.5 Curing Presses, NRM
178 - P.C.I. Units, NRM
9 - P.C.I. Units, Firwood
2 - Mold Cleaners (Dry Blaster)

Dept. 169 - H.D. Curing

32 - #46 Curing Presses, NRM
24 - #55 B.O.M. Curing Presses, McNeil
32 - 46" P.C.I. Units
25 - 55" P.C.I. Units (1 idle unit, used for re-P.C.I.)
1 - Mold Cleaning Unit (Wet Blaster)
1 - Vulcanizer

Dept. 171 - Radial Stabilizer Ply Stock Cutting

3 - Spadone Wire Fabric Bias Cutters
3 - Spadone Dual Fabric Letoffs
9 - Horizontal Splicing Tables

Dept. 174 - Radial Tire Building

115 - 85B T.A.M.'s (1 additional machine planned)
13 - 85D T.A.M.'s
1 - Lot Basket Conveyors
110 - 280D Servers
18 - 280C Servers

Dept. 551 - Bladder Building, Curing & Inspection

5 - 36" x 30" Model 900 McNeil Bladder Curing Presses
17 - Bladder Molds (4 inactive)
9 - Extra Bladder Cores
1 - 4½" CFE for Bladder Slugs

Dept. 561 - Cement Mixing

6 - 12,000 Gal. Bulk Storage Tanks
1 - 500 Gal. Struthers-Wells Mix Tank
1 - 500 Gal. Chemineer Mix Tank
1 - 250 Gal. Struthers-Wells Mix Tank
1 - 25 Gal. Day Mixer
1 - Philadelphia Mix Tank
1 - Solvent Distiller

Dept. 765 - Quality Assurance

3 - 8-Position Tire Test Machine
1 - 4-Position Bureau of Standards Machine
1 - Bead Cutting Machine
1 - Tread Stripper
1 - Band Saw
1 - Profilometer
1 - Manual Balancer
1 - Centering Gauge Machines
2 - H.D. Tire Test Machines
1 - H.D. Tire Mounter
2 - Passenger Tire Mounters
1 - IHI Model K248 Holograph Unit
1 - Picker Manual X-Ray Unit
1 - Picker AID X-Ray Unit
1 - Monsanto 1027 X-Ray Unit

Dept. 791 - Warehouse & Shipping

2 - Passenger Tire Unitizing Machines - Signode
1 - H.D. Tire Compression Unit - Brainard
3 - Tube & Flap Insert Units

FORK LIFT TRUCKS - AS OF NOVEMBER 1, 1982

QUAN.	MAKE	MODEL	POWER	CAP.	OPERATOR	DEPT.
2	Clark	Fork	L. P. Gas	5,000	Rides	831
1	Clark	Fork	L. P. Gas	5,000	Rides	701
3	Clark	Fork	L. P. Gas	5,000	Rides	791
3	Clark	Fork	L. P. Gas	5,000	Rides	729
1	Clark	Fork	L. P. Gas	5,000	Rides	Janitors
10						
1	Kalamazoo	Platform	L. P. Gas	1,000	Rides	701
1	Kalamazoo	Platform	L. P. Gas	1,000	Rides	749
2						
1	Hyster	Fork	L. P. Gas	1,000	Rides	166

ELECTRIC FORK LIFT TRUCKS

1	Clark	Fork	Electric	5,000	Rides	701
4	Clark	Fork	Electric	5,000	Rides	791
4	Clark	Fork	Electric	5,000	Rides	166
1	Baker	Fork	Electric	5,000	Rides	112
3	Baker	Fork	Electric	5,000	Rides	128
4	Baker	Fork	Electric	5,000	Rides	149
7	Baker	Fork	Electric	5,000	Rides	161
5	Baker	Fork	Electric	5,000	Rides	791
2	Baker	Fork	Electric	5,000	Rides	701
31						
2	Baker	Fork	Electric	6,000	Rides	112
2	Baker	Fork	Electric	6,000	Rides	122
2	Baker	Fork	Electric	6,000	Rides	123
4	Baker	Fork	Electric	6,000	Rides	126
10						
1	Baker	Fork	Electric	7,000	Rides	166
1	Baker	Fork	Electric	7,000	Rides	831
6	Baker	Fork	Electric	7,000	Rides	112
1	Baker	Fork	Electric	7,000	Rides	122
4	Baker	Fork	Electric	7,000	Rides	126
1	Baker	Fork	Electric	7,000	Rides	123
14						
1	Moto-Truc	Platform	Electric	4,000	Rides	124
1	Moto-Truc	Platform	Electric	4,000	Rides	128
2						
10	Moto-Truc	Platform	Electric	6,000	Rides	128
2	Kalamazoo	Platform	Electric	2,000	Rides	831
6	Raymond	Platform	Electric	6,000	Rides	128

ELECTRIC FORK LIFT TRUCKS (continued)

QUAN.	MAKE	MODEL	POWER	CAP.	OPERATOR	DEPT.
9	Baker	Fork	Electric	4,000	Rides	791
1	Baker	Fork	Electric	4,000	Rides	831
10						
4	Towmotor	Fork	Electric	5,000	Rides	128
7	Towmotor	Fork	Electric	5,000	Rides	133
1	Towmotor	Fork	Electric	5,000	Rides	158
5	Towmotor	Fork	Electric	5,000	Rides	166
4	Towmotor	Fork	Electric	5,000	Rides	701
8	Towmotor	Fork	Electric	5,000	Rides	791
29						
1	Towmotor	Fork	Electric	7,000	Rides	122
1	Towmotor	Fork	Electric	7,000	Rides	112
2						
1	Towmotor	Fork	Electric	3,000	Rides	133
1	Towmotor	Fork	Electric	3,000	Rides	791
1	Towmotor	Fork	Electric	3,000	Rides	124
3						

954-005

Firestone
INTEROFFICE

TO MR. W. A. FERRING
CORPORATE ENGINEERING

FROM DECATUR PLANT

DATE AUGUST 12, 1982

REFERENCE

SUBJECT GENERAL PLANT DATA REPORT

RECEIVED
AUG 16 1982
W. A. FERRING

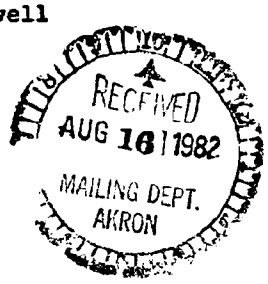
Attached is the General Plant Data Report for the Decatur Plant.

R. L. Buchanan
R. L. BUCHANAN
PLANT ENGINEER

RLB:ac

Att.

cc: H. E. Powell





S1873A

BATO/Jackson 064441

-2753 REV. 3-79

ATTACHMENT I

PLANT DECATUR

ACREAGE 156

YEAR 1982

FLOOR AREAS

	SQ. METERS	SQ. FEET
I. OWNED BUILDINGS		
A. RAW MATERIAL STORAGE		144,240
B. PRODUCTION AREA		1,355,,612
C. PRODUCTION AREA IN THE OPEN		
D. FINISHED GOODS STORAGE		399,772
E. OFFICE AREA		24,790
F. VACANT OFFICE SPACE		37,360
TOTAL		1,961,774
II. LEASED BUILDINGS		
A. RAW MATERIAL STORAGE		
B. PRODUCTION AREA		
C. PRODUCTION AREA IN THE OPEN		
D. FINISHED GOODS STORAGE		185,000
E. OFFICE AREA		
TOTAL		185,000

REFERENCE DRAWINGS :

PLOT PLAN 70T-02-22

PROPERTY DWG. 70DA-1924

LAB:bj
10/6/82

BATO/Jackson 064442

Firestone
INTEROFFICE

DATE OCTOBER 15, 1981

TO MR. W. A. FERRING
SUPERVISOR OF ESTIMATING
AKRON

FROM DECATUR PLANT

REFERENCE

RECEIVED
OCT 19 1981
W. A. FERRING

SUBJECT GENERAL PLANT DATA REPORT

Attached is the General Plant Data Report for the Decatur Plant.

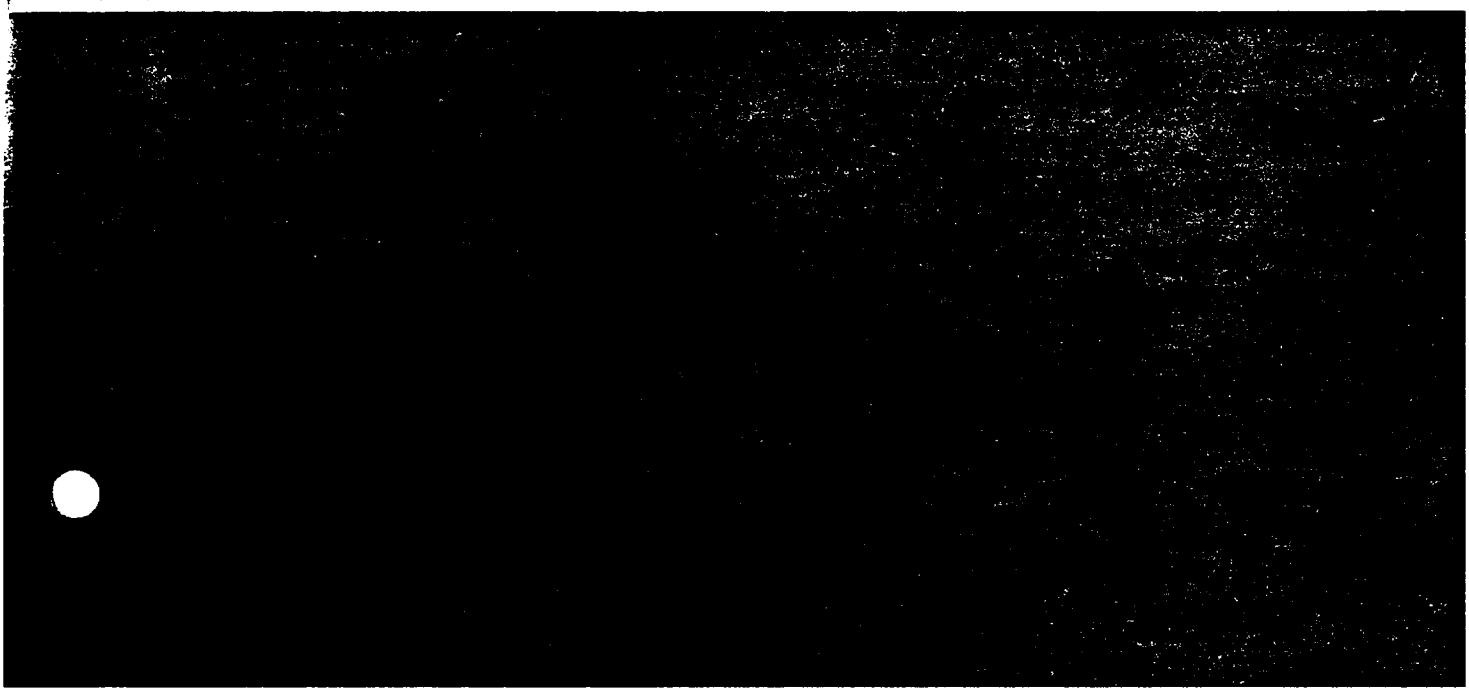
R. L. Buchanan
R. L. BUCHANAN
PLANT ENGINEER

RLB:ac

Att.

cc: H. E. Powell

S1273C



BATO/Jackson 064443

Firestone
INTEROFFICE

TO MR. H. D. BOSSMAN
AKRON

FROM R. L. BUCHANAN

DATE OCTOBER 7, 1982

REFERENCE

SUBJECT FLOOR AREA SUMMARY REPORT

RECEIVED
OCT 11 1982
H. D. BOSSMAN

Attached is the Floor Area Summary Report for the Decatur Plant for 1982.

R L Buchanan
R. L. BUCHANAN
PLANT ENGINEER

RLB:bj

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