

DEPARTMENT OF ENVIRONMENTAL QUALITY  
AIR QUALITY DIVISION  
ACTIVITY REPORT: Scheduled Inspection

N174926447

FACILITY: PLASTATECH ENGINEERING LTD		SRN / ID: N1749
LOCATION: 725 MORLEY DR, SAGINAW		DISTRICT: Saginaw Bay
CITY: SAGINAW		COUNTY: SAGINAW
CONTACT: Keith Goodale , Safety & Environmental Manager		ACTIVITY DATE: 07/22/2014
STAFF: Kathy Brewer	COMPLIANCE STATUS: Compliance	SOURCE CLASS: SM OPT OUT
SUBJECT: Inspection to determine compliance with PTI 336-97B and air regs.		
RESOLVED COMPLAINTS:		

I (KLB) conducted an announced inspection to determine compliance with PTI 336-97B and air regulations. I met with Mr. Keith Goodale, Safety & Environmental Manager, and Crint LaBrosse, Plant Manager. The inspection included a tour of the production facility, air pollution control equipment, and, a review of electronic and hardcopy records for both instantaneous and historical operations of processes and emission control devices. No violations of PTI 336-97B or air quality regulations were found during the inspection.

Plastatech Engineering manufactures vinyl and PVC film material. These films are produced in a calendaring process and undergo additional steps to produce the finished products, primarily commercial roofing membranes. On May 14, 2004, the facility was issued PTI 336-97B which is a facility wide opt-out permit. This permit covers the calendar line, two laminator lines, and the former finishing line and coating line. All emission units except for the calendar line are controlled by Smog-Hog ESPs for VOC/condensable PM emissions. The sites data tracking system, "AS 400", is used to generate information for compliance with records keeping and determining emissions.

#### EU-CalendarLn: In Compliance

Per PTI 336-97B application, the process consists of three 90,000 pound storage tanks (two for plasticizer and one for ESO), three 1500 pound totes, three 170,000 pound PVC resin silos, four 2200 pound super sacks, a five story mixing tower, a planetary extruder, a strainer extruder, a 14ft conveyor, calender rolls, and cooling rolls. The calendar line is an extrusion process that produces the initial product used for all finished goods at the facility. Raw materials consisting of PVC resin, plasticizers, heat stabilizers, biocides and colors are combined by gravity loading into a weigh hopper and loaded into the planetary extruder followed by a screw extruder. The extruders are heated by a hot oil bath jacket on the extruders. This process generates a semi-viscous thermoplastic that is pressed into a thin film using a series of high temperature, high pressure rollers. This film is then cooled by an additional series of rollers, trimmed to width and wound into rolls. These rolls then go to other operations or are shipped off-site.

Emissions generated in the calendar process are captured by hoods and vented outside through one stack.

The permit requires Plastatech to maintain a current listing of the chemical composition of each material. The site uses raw material MSDS VOC and HAP concentrations to generate product specific emissions based on run time for each product ID.

Floor operators track run times, raw material fed to the mix tank, extruder feeds to rollers. Emission calculations are based on material produced (number of yards) and item produced specifications (raw materials and finished product characteristics – e.g. thickness).

#### FG-LaminatorLns: In Compliance

9/23/2014



Plastatech operates two laminator lines at the facility. The lamination process involves bonding two layers of the vinyl film over a reinforcing mesh (scrim) using a plasticizer as an adhesive and heat to activate. Each Laminator line utilizes a separate Smog Hog ESP to control emissions from the process. The emissions are generated from the curing of the adhesive and captured by hoods over the heated portion of the process.

The Smog-Hogs utilize a closed loop chilled water system for temperature control in the units. The PTI requires continuous monitoring of the temperature of the SmogHog exhaust and limits the temperature to less than 130°F. Each process has an individual data logger for the continuous monitoring of the exhaust temperatures. The ESPs are interlocked with the processes such that production cannot begin, or continue, without the ESPs operating at the correct chiller temperature and exhaust gas temperature. Processes will automatically shut down if the ESPs begin operating out of range. The current operating range is set for <80 F on the chiller and 128 F for each laminate line.

At 11:02 AM the Chiller temperature readout was 62 F, Line 1 readout was 97.6 F, and Line 2 readout was 89.3 F.

This FG is limited to no more than 7000 hrs per 12 mo rolling time period and 3.8 TPY VOCs. VOC emissions are based on the yardage of each item. I viewed the floor production hourly operating logs and material usage logs, the daily summary sheets, and the monthly summary sheets. For the period ending in June 2014, records show the laminate lines ran 6320 hours and the 12 month rolling VOC laminate emissions were 2.7 TPY.

Copies of the Laminator Line 1 production run times and production records for July 16, 2014 are attached. The running monthly summary and totalizing operating hours & VOC emission estimates are also attached.

#### FG-CoatFinishLns: In Compliance

Plastatech previously conducted a plastisol coating operation to produce expanded vinyl products. This process was removed in 2006. The finish line equipment was still on site but not operational. The control equipment that previously serviced the coating line and the finish line is still in place.

#### FG-FACILITY: In Compliance

FG-Facility establishes minor HAP limits for the facility. This FG consists of all equipment at the stationary source including equipment covered by other permits, grandfathered equipment and exempt equipment. This FG establishes the opt-out limits for HAPs to ensure this as a minor source.

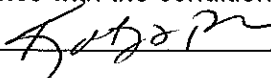
Review of onsite electronic records show the current HAP emissions for the facility are significantly below the established minor source limits.

#### Miscellaneous Exempt Equipment: In compliance

The majority of the manufacturing operations at the facility are covered by PTI 336-97B. Plastatech also manufactures the scrim that is used in the lamination process at the facility. There are several large looms that weave the mesh fabric and produce large rolls of scrim. There are no air emissions generated by this process.

Based on the results of the facility inspection and records review, Plastatech was in compliance with the conditions of PTI 336-97B.


NAME



DATE

9/23/14

SUPERVISOR



9/23/2014



7/22/14

### Plastatech Engineering Ltd. Laminator Usage Records

mo.yr	Lam1 hrs	Lam2 hrs	LBs of Adhesive	Material Produced	VOC/Tons	Total year to date Lam totals
Jan-09	Lam 1	326.99	45778.50	330586.14	0.037	0.037
Jan-09	Lam 2	433.42	60683.12	438187.62	0.093	0.130
Feb-09	Lam 1	228.68	32015.66	231198.82	0.000	0.130
Feb-09	Lam 2	303.14	42439.37	306472.86	0.860	0.990
Mar-09	Lam 1	105.65	14791.70	106817.20	0.017	1.007
Mar-09	Lam 2	140.05	19607.60	141594.89	0.002	1.009
Apr-09	Lam 1	146.42	20498.17	148026.09	0.014	1.023
Apr-09	Lam 2	194.09	27172.00	196220.63	0.079	1.102
May-09	Lam 1	220.77	30907.90	223199.20	0.039	1.141
May-09	Lam 2	292.65	40970.94	295868.71	0.040	1.181
Jun-09	Lam 1	290.67	40694.33	293871.21	0.048	1.229
Jun-09	Lam 2	385.31	53943.65	389550.21	0.095	1.324
Jul-09	Lam 1	328.16	45942.83	331772.89	0.072	1.396
Jul-09	Lam 2	435.01	60900.97	439791.98	0.063	1.459
Aug-09	Lam 1	293.80	41132.12	297032.69	0.056	1.515
Aug-09	Lam 2	389.46	54523.98	393741.01	0.074	1.589
Sep-09	Lam 1	168.22	23551.46	170075.16	0.045	1.634
Sep-09	Lam 2	223.00	31219.37	225448.47	0.083	1.717
Oct-09	Lam 1	317.44	44442.00	320934.73	0.047	1.764
Oct-09	Lam 2	420.80	58911.49	425425.11	0.041	1.805
Nov-09	Lam 1	271.40	37995.64	274382.82	0.017	1.822
Nov-09	Lam 2	359.76	50366.32	363716.76	0.032	1.854
Dec-09	Lam 1	60.33	8446.16	60993.36	0.011	1.865
Dec-09	Lam 2	79.97	11196.08	80851.67	0.062	1.927
Jan-10	Lam 1	118.18	16545.38	119481.29	0.028	1.955
Jan-10	Lam 2	156.66	21932.25	158382.17	0.061	2.016
Feb-10	Lam 1	136.68	19135.62	138186.54	0.054	2.070
Feb-10	Lam 2	181.18	25365.83	183177.50	0.073	2.143
Mar-10	Lam 1	176.14	24659.70	178078.26	0.071	2.214
Mar-10	Lam 2	233.49	32688.44	236057.23	0.074	2.288
Apr-10	Lam 1	199.89	27984.79	202090.17	0.060	2.348
Apr-10	Lam 2	264.97	37096.12	267886.97	0.061	2.409
May-10	Lam 1	242.42	33939.15	245089.16	0.058	2.467
May-10	Lam 2	321.35	44989.11	324885.63	0.061	2.528
Jun-10	Lam 1	293.13	41037.55	296349.76	0.071	2.599
Jun-10	Lam 2	388.56	54398.62	392835.73	0.074	2.673
Jul-10	Lam 1	243.92	34148.63	246601.93	0.060	2.733
Jul-10	Lam 2	323.33	45266.80	326890.93	0.061	2.794
Aug-10	Lam 1	253.13	35437.68	255910.65	0.058	2.852

VOC's  
are  
Cumulative  
- Meas  
- Rollup



Aug-10 Lam 2	335.54	46975.52	339230.39	0.061	2.913
Sep-10 Lam 1	208.82	29235.15	211119.58	0.056	2.969
Sep-10 Lam 2	276.81	38753.58	279856.18	0.048	3.017
Oct-10 Lam 1	286.12	40056.50	289265.18	0.064	3.081
Oct-10 Lam 2	379.27	53098.16	383444.54	0.064	3.145
Nov-10 Lam 1	65.72	9201.02	66444.47	0.051	3.196
Nov-10 Lam 2	87.12	12196.69	88077.56	0.040	3.236
Dec-10 Lam 1	197.50	27650.56	199676.55	0.067	3.303
Dec-10 Lam 2	261.81	36653.07	264687.52	0.000	3.303
Jan-11 Lam 1	112.10	15694.60	113337.40	0.056	3.359
Jan-11 Lam 2	148.60	20804.46	150237.95	0.048	3.407
Feb-11 Lam 1	87.50	12250.14	88463.49	0.000	3.407
Feb-11 Lam 2	115.99	16238.55	117265.55	0.042	3.449
Mar-11 Lam 1	165.03	23104.08	166844.47	0.057	3.506
Mar-11 Lam 2	218.76	30626.34	221165.92	0.054	3.560
Apr-11 Lam 1	209.18	29284.88	211478.66	0.045	3.605
Apr-11 Lam 2	277.28	38819.49	280332.18	0.046	3.651
May-11 Lam 1	67.61	9465.68	68355.77	0.047	3.698
May-11 Lam 2	89.63	12547.54	90611.13	0.060	3.758
Jun-11 Lam 1	209.20	29288.33	211503.60	0.055	3.813
Jun-11 Lam 2	277.31	38824.07	280365.23	0.060	3.873
Jul-11 Lam 1	200.67	28094.19	202880.17	0.059	3.932
Jul-11 Lam 2	266.01	37241.13	268934.18	0.037	3.969
Aug-11 Lam 1	44.50	6230.43	44992.60	0.031	4.000
Aug-11 Lam 2	58.99	8258.94	59641.35	0.000	4.000
Sep-11 Lam 1	219.89	30784.55	222308.44	0.045	4.045
Sep-11 Lam 2	291.48	40807.43	294687.93	0.053	4.098
Oct-11 Lam 1	209.09	29271.96	211385.35	0.043	4.141
Oct-11 Lam 2	277.16	38802.36	280208.49	0.053	4.194
Nov-11 Lam 1	179.27	25097.77	181241.73	0.049	4.243
Nov-11 Lam 2	237.64	33269.13	240250.67	0.062	4.305
Dec-11 Lam 1	120.44	16861.37	121763.15	0.054	4.359
Dec-11 Lam 2	159.65	22351.11	161406.97	0.060	4.419
Jan-12 Lam 1	108.86	15240.68	110059.48	0.053	4.472
Jan-12 Lam 2	144.31	20202.76	145892.79	0.027	4.499
Feb-12 Lam 1	108.41	15177.50	109603.23	0.026	4.525
Feb-12 Lam 2	143.71	20119.01	145288.00	0.047	4.572
Mar-12 Lam 1	142.97	20015.65	144541.61	0.041	4.613
Lam 2	189.52	26532.38	191601.67	0.047	4.660
Apr-12 Lam 1	185.48	25967.67	187523.70	0.063	4.723
Lam 2	245.87	34422.27	248577.93	0.056	4.779
May-12 Lam 1	187.97	26315.35	190034.39	0.074	4.853
Lam 2	249.17	34883.13	251906.06	0.045	4.898
Jun-12 Lam 1	227.14	31799.43	229637.33	0.083	4.981
Lam 2	301.09	42152.74	304402.98	0.047	5.028
Jul-12 Lam 1	198.13	27738.16	200309.14	0.041	5.069
Lam 2	262.64	36769.19	265526.08	0.017	5.086





KAB

VOC tons

Aug-12 Lam 1	330.77	46308.43	334413.04	0.032	5.118
Lam 2	438.47	61385.60	443291.70	0.011	5.129
Sep-12 Lam 1	233.74	32723.49	236310.32	0.062	5.191
Lam 2	309.84	43377.64	313248.56	0.028	5.219
Oct-12 Lam 1	320.93	44930.25	324460.58	0.061	5.280
Lam 2	425.42	59558.70	430098.91	0.054	5.334
Nov-12 Lam 1	203.97	28555.68	206212.81	0.073	5.407
Lam 2	270.38	37852.88	273351.86	0.071	5.478
Dec-12 Lam 1	157.24	22013.55	158969.30	0.074	5.552
Lam 2	208.43	29180.08	210721.83	0.060	5.612
Jan-13 Lam 1	169.97	23795.31	171836.16	0.061	5.673
Lam 2	225.30	31542.63	227782.82	0.058	5.731
Feb-13 Lam 1	160.61	22486.05	162381.44	0.061	5.792
Lam 2	212.91	29807.10	215249.81	0.071	5.863
Mar-13 Lam 1	159.44	22322.28	161198.72	0.074	5.937
Lam 2	211.36	29589.99	213682.03	0.060	5.997
Apr-13 Lam 1	221.40	30995.65	223832.85	0.071	6.068
Lam 2	293.48	41087.25	296708.66	0.074	6.142
May-13 Lam 1	234.51	32831.21	237088.20	0.060	6.202
Lam 2	310.86	43520.43	314279.71	0.061	6.263
Jun-13 Lam 1	203.97	28555.68	206212.81	0.058	6.321
Lam 2	270.38	37852.88	273351.86	0.061	6.382
Jul-13 Lam 1	157.24	22013.55	158969.30	0.071	6.453
Lam 2	208.43	29180.08	210721.83	0.074	6.527
Aug-13 Lam 1	169.97	23795.31	171836.16	0.060	6.587
Lam 2	225.30	31542.63	227782.82	0.061	6.648
Sep-13 Lam 1	160.61	22486.05	162381.44	0.058	6.706
Lam 2	211.36	29589.99	213682.03	0.061	6.767
Oct-13 Lam 1	212.91	29807.10	215249.81	0.056	6.823
Lam 2	425.42	59558.70	430098.91	0.048	6.871
Nov-13 Lam 1	203.97	28555.68	206212.81	0.064	6.935
Lam 2	270.38	37852.88	273351.86	0.064	6.999
Dec-13 Lam 1	203.97	28555.68	206212.81	0.051	7.050
Lam 2	158.88	23895.31	171842.16	0.067	7.117
Jan-14 Lam 1	114	22274	115254.00	0.067	7.184
Lam 2	256	29526	258816.00	0.000	7.184
Feb-14 Lam 1	128.5	27481.3	129913.50	0.056	7.240
Lam 2	328	36428.7	331608.00	0.048	7.287
Mar-14 Lam 1	336.25	23703.75	339948.75	0.014	7.301
Lam 2	57.5	31421.25	58132.50	0.079	7.380
Apr-14 Lam 1	369.75	35563.15	373817.25	0.039	7.419
Lam 2	221	47141.85	223431.00	0.040	7.459
May-14 Lam 1	330.5	42802.2	334135.50	0.048	7.507
Lam 2	380.5	56737.8	384685.50	0.095	7.602
Jun-14 Lam 1	346.75	43027.95	350564.25	0.072	7.674
Lam 2	368	57037.05	372048.00	0.040	7.714
Jul-14 Lam 1			0.00		

12.703

END 2013

15.388

2.685

Lam1 2938.39  
 Lam2 3381.15  
 6319.54 KAB

10/10/10

10/10/10

10

10/10/10

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10

10/10/10

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10/10/10

10

10

Lam 2	0.00
Aug-14 Lam 1	0.00
Lam 2	0.00
Sep-14 Lam 1	0.00
Lam 2	0.00
Oct-14 Lam 1	0.00
Lam 2	0.00
Nov-14 Lam 1	0.00
Lam 2	0.00
Dec-14 Lam 1	0.00
Lam 2	



Plastatech		Jun 2013 -	Jun-14 hours
Lam 1	Lam 2		
203.97	270.38		
157.24	208.43		
169.97	225.3		
160.61	211.36		
212.91	425.42		
203.97	270.38		
203.97	158.88		
114	256		
128.5	328		
336.25	57.5		
369.75	221		
330.5	380.5		
346.75	368		
			total
2938.39	3381.15		6319.54

Soener: KYB BASED ON SKUMMY INFO PROVIDED  
7/22/14



7/22/14

LAMINATOR #1 DAILY SUMMARY

SHOP ORDER NUMBER

M725270

DATE 7/16/2014  
 SHIFT 3rd  
 Item # 50295  
 Rolls 116  
 OEE % 96.27%  
 RUN TIME 12  
 DOWN TIME 0

GROSS YARDS 14880  
 NET YARDS 14556  
 SAVED YARDS 176  
 SCRAPPED YARDS 148  
 SET ASIDE YARDS 0  
 SCRAP % 2.18%

SIGNATURE: T L Agnew

Employee #	Indirect hours		Direct Hours		Total Hours
	A=adhesive P=Plant mtg DM=Depart. mtg	Setup	Run		
11032			11.5		11.5
9496			11.5		11.5
11002			11.5		11.5
11135			11.5		11.5
11138			11.5		11.5
11226			11.5		11.5
					0
					0
					0
					0
<b>TOTALS</b>		<b>0</b>	<b>69</b>		<b>69</b>

Start up Information

Summary of saved yards

Accountable Yards  
 Top film 0  
 Bottom Film 0  
 Scrim 0  
 Line Speed 21  
 Scrim 11030

Non-Accountable  
 Top Film 0  
 Bottom Film 0  
 Scrim 0  
 Adhesive SO # M724490  
 Film 10209 | 10315

Flatstock 176  
 Splitdown 0





Shift: Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
X	297462	4:43	141	141					—		Table
A 97					Booth	11138					
X	297464	4:50	98	97	TS	1			Ø		Table
A 98					Booth	11138					
X	297466	4:56	145	145					Ø		Table
A 99					Booth	11138					
X	297468	0502	110	109	BS	1			Ø		Table
A 100					Booth	9496					
X	297469	0508	147	147					Ø		Table
A 101					Booth	9496					
X	297471	0514	144	144					Ø		Table
A 102					Booth	9496					
X	297473	0521	140	140					Ø		Table
A 103					Booth	9496					
X	297475	0526	143	141	BS	2			Ø		Table
A 104					Booth	11002					
						4		0			
Totals			1068	1064			4		Ø		

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift: Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
X											Table /
A105	297477	0534	145	145							Booth 9496
					SS	3			3		Table 1082
A106	297478	0541	140	137						284DBF	Booth 9496
X					TS	3			0		Table /
A107	297480	0545	71	68							Booth 9496
X					BS	1			0		Table /
A108	297481	0548	75	74							Booth 9496
X											Table /
A109	297483	0555	144	144							Booth 9496
+											Table /
A110	297485	602	141	141							Booth 1138
+											Table /
A111	297487	607	140	140							Booth 1138
+											Table /
A112	297489	612	71	68	BS	3			1		Booth 1138
						10			0		
Totals			927	917			10		4		

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift:

Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if Clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
X	297490	018	141	141	<del>—————</del>				<del>1</del>		Table <input checked="" type="checkbox"/>
A113					Booth <u>1138</u>						
X	297492	623	73	72	SP	1			1		Table <input type="checkbox"/>
A114							Booth <u>1138</u>				
X	297494	0628	134	134	CM	-			<del>1</del>		Table <input checked="" type="checkbox"/>
A115							Booth <u>1138</u>				
X	297496	0635	145	145	BS	-			<del>1</del>		Table <input checked="" type="checkbox"/>
A116							Booth <u>1138</u>				
A											Table <input type="checkbox"/>
											Booth <input type="checkbox"/>
A											Table <input type="checkbox"/>
											Booth <input type="checkbox"/>
A											Table <input type="checkbox"/>
											Booth <input type="checkbox"/>
A											Table <input type="checkbox"/>
											Booth <input type="checkbox"/>
Totals			493	492		1		0	1		

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift: Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if Clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
											Table
											Booth
A 121											Table
											Booth
A 122											Table
											Booth
A 123											Table
											Booth
A 124											Table
											Booth
A 125											Table
											Booth
A 126											Table
											Booth
A 127											Table
											Booth
A 128											Table
											Booth
Totals											

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_





Plastatech Laminator #1  
Bottom Station Splice & Registration Check Sheet

Film Item #	10289
Laminate Item #	50255

Shift	3rd	Supervisor	B.R.
Date	7/16/14	Lead Operator	TA

Time	0414	0438	0501	0525	0547	0611							
Lot #	4517	4518	4518	4518	4518	4518							
Roll#	32	4	3	14	13	12							

Process Step    Process Variable

Pre-Splice

- 1    Alignment Bolts Against Film
- 2    Air-Bar Has Air
- 3    Current Roll Brake OFF
- 4    New Roll Brake ON
- 5    Backing Removed From Tape


Splice

- 6    Nip Roll Closed
- 7    Set Brake Tension


Post-Splice

- 8    Open Nip Roll
- 9    Verify Alignment & Adjust To Equal Distance Between Rulers


Operator #

11135	11135	11135	112710	11135	11135								
-------	-------	-------	--------	-------	-------	--	--	--	--	--	--	--	--







Plastatech Laminator #1  
 Top Station Splice & Registration Check Sheet

Film Item #
Laminate Item #

Shift	Supervisor											
Date	Lead Operator											
Time												
Lot #												
Roll #												

Process Step    Process Variable

Pre-Splice

- 1    Alignment Bolts Against Film
- 2    Air-Bar Has Air
- 3    Current Roll Brake OFF
- 4    New Roll Brake ON
- 5    Widen Out (4) Notches
- 6    Backing Removed From Tape


Splice

- 7    Nip Roll Closed
- 8    Set Brake Tension


Post-Splice

- 9    Open Nip Roll
- 10    Verify Alignment & Adjust To  
Equal Distance Between Rulers
- 11    Narrow If Necessary


Operator #

Shift: Nights Days  
(circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 2-10-14

PEL Number 50295

"X" if Clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
X					BS	1					Table
A 1	297267	1838	150	149							Booth 92181
X					CM						Table
A 2	297265	1835	137	137							Booth 92181
					SS	-				282	Table 10331
A 3	297266	1810	145	139	TL	6		6	RPE		Booth 92181
X											Table
A 4	297268	1848	140	140							Booth 11248
					BS	3					Table 11002
A 5	297270	1855	145	142							Booth 11248
X					PR	-					Table
A 6	297271	1901	95	95							Booth 9496
					SP	1	TS	3			Table 11002
A 7	297276	1910	205	142	SP	-	ST	58	60		Booth 9496
					SP	1					Table
A 8	297278	1918	155	141	SP	1	CM	8			Table 11002
					BS	2			12		Booth 9496
					SP	3					
					CM	-					
Totals			1172	1085		87			78		

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift: Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number \_\_\_\_\_

PEL Number \_\_\_\_\_

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
X A 9	297280	1925	140	140							Table Booth 9496
X A 10	297282	1932	140	140							Table Booth 9496
X A 11	297286	1938	108	108	cm						Table Booth 9496
A 12	297288	1945	143	138	BS TL TL SS	2 2 1		3		282 BBD14	Table Booth 11002 9496
X A 13	297290	1952	144	144							Table Booth 9496
X A 14	297292	1957	93	93	st			0			Table Booth 9496
A 15	297296	2004	144	135	TS TR	1 8		8			Table Booth 11002 11138
A 16	297297	2010	143	139	BS BR	2 2		2			Table Booth 11138
Totals			1055	1037		18		13			

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift:

Night Days  
(Circle one)

## LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614PEL Number 50295

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
					SP	-					Table 11002
A 17	297300	2027	144	143	SP	1			1		Booth 1138
X									-		Table -
A 18	297302	2024	141	141							Booth 1138
X					BS	2					Table -
A 19	297301	2031	109	107					0		Booth 1138
X									-		Table -
A 20	297306	2037	140	140							Booth 1138
X					SS	1			5	285AB4	Table -
A 21	297308	2043	90	84	T4	5					Booth 1138
X											Table -
A 22	297311	2050	140	140							Booth 1138
X					BS	-			0		Table -
A 23	297312	2057	125	125							Booth 1138
X					TS	3					Table -
A 24	297314	2102	108	105					0		Booth 11032
			997	985		12			6		
Totals											

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift: Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
X A 25	297316	2109	143	143							Table Booth 9496
A 26	297320	2116	146	146	CM SP	-					Table Booth 9496
A 27	297322	2123	146	145	DS SP	1 -			∅		Table Booth 9496
A 28	297325	2131	145	145	SP	-			∅		Table Booth 9496
A 29	297326	2138	142	139	CM CM BU CM CM	3 - - -			3		Table Booth 9496
X A 30	297328	2141	60	60	SP	-			∅		Table Booth 9496
A 31	297332	2148	149	148	CM CM BS	- - 1			∅		Table Booth 9496
A 32	297334	2156	151	151	SP	-			∅		Table Booth 9496
Totals			1082	1077			5		3		

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift: Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
X A 33	297336	2203	118	99	SS WR TS	- 19 -			0	285AB T14	11138
X A 34	297338	2209	140	140							11138
					BS	3					11002
A 35	297339	2215	143	140					0		11138
X A 36	297342	2222	140	140							11138
X A 37	297345	2229	140	140	CM	-			-		11138
X A 38	297347	2236	103	99	BS	4			-		11138
X A 39	297351	2242	140	140					-		11138
X A 40	297353	2258	140	140					<del>0</del>		11138
			1064	1038		20			0		
Totals											

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift:

Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
+	297355	2255	94	90	cm	4			4		Table
A41											Booth
	297357	2302	140	137	cm	-			0		Table
A42											Booth
X	297359	2309	139	139	B4	-			0		Table
A43											Booth
X	297360	2315	110	110	B4	-			0		Table
A44											Booth
	297362	2322	145	145	St	-				285DBT14	Table
A45											Booth
X	297364	2328	77	77	BS	-			0		Table
A46											Booth
	297366	2333	146	144	SP	1			2		Table
A47											Booth
X	297368	2341	145	145							Table
A48											Booth
Totals			998	987		11			6		

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_



Shift: Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if Clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
					TS	2				Table	11032
A89	297448	3:53	145	143	BS	-				Booth	9496
X										Table	
A90	297450	3:59	145	145						Booth	11138
X										Table	
A91	297451	4:06	141	141						Booth	11138
					BS	-				Table	
A92	297454	4:14	149	149	SP	-				Booth	11138
X										Table	
A93	297455	0420	140	140						Booth	11138
X					SS	-				Table	2840/SE 14
A94	297457	0426	119	119						Booth	11138
X										Table	
A95	297459	0432	140	140						Booth	11138
					BS	1				Table	
A96	297460	0437	98	97						Booth	11138
						3		0			
Totals			1077	1074			3		0		

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift:

Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
X	A81	297433	0307	108	108	BS	-				Table Booth 9496
X	A82	297435	3:11	74	74	SS	-			2830BF 14	Table Booth 9496
X	A83	297437	0317	118	118	BU	-		0		Table Booth 9496
	A84	297439	0324	137	135	SP	2		2		Table Booth 11007 9496
	A85	297441	0330	147	146	BS SP	1 -		0		Table Booth 11002 9496
X	A86	297442	0336	97	95	SP	2		2		Table Booth 9496
X	A87	297444	0341	141	141						Table Booth 9496
X	A88	297444	0346	107	105	SP	2		2		Table Booth 9496
							7		0		
Totals				929	922			7	6		

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift:

Nights Days  
(Circle one)

## LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614PEL Number 50295

"X" if Clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
					BS	1					Table 11052
A 73	297418	2:21	102	101					BS		Booth 11138
X											Table —
A 74	297421	2:26	135	135							Booth 11138
					SP	—					Table 11032
A 75	297422	2:33	143	143							Booth 11138
X											Table —
A 76	297425	2:39	140	140							Booth 11138
X					BS	—					Table /
A 77	297427	0244	70	70							Booth 11138
X											Table /
A 78	297428	0250	130	130							Booth 11138
X					FS	1					Table /
A 79	297430	2:57	116	115							Booth 11138
	297432				KM	?					Table 11002
A 80	<del>297432</del>	0302	142	135					7		Booth 9496
			978	969		9			7		
Totals											

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift: Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 7-16-14

PEL Number 50295

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
X A65	297403	0128	92	85	SP	7			7		Table Booth 9496
X A66	297404	0132	83	81	BS	2			0		Table Booth 9496
X A67	297406	0139	143	143	-----						Table Booth 9496
X A68	297408	145	140	140	-----						Table Booth 9496
X A69	297411	0154	142	137	SP	4			5		Table Booth 9496
X A70	297413	0159	152	131	TS	4	FYP	3	16	285 DBE	Table Booth 11002 11138
X A71	297415	2:05	141	141	-----						Table Booth 11138
X A72	297416	2:33	140	140	-----						Table Booth 11138
Totals			1033	998		35			28		

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift: Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
											Table 11002
A57	297387	0035	140	140	St	—					Booth 11138
					BS	2					Table 11002
A58	297390	0043	162	100	SS	—				285DB4	Booth 11138
					RS	60					Table —
X								8			Booth 11138
A59	297392	0052	80	72	SP	8					Table 11002
					SP	1					Booth 11138
A60	297394	0055	140	139				1			Table —
X					TS	5					Booth 9496
A61	297395	0100	86	81							Table 11002
					BS	1					Booth 9496
A62	297397	0109	160	145	Km	9		14			Table —
					BU	5					Booth 9496
X											Table —
A63	297399	0116	140	140							Booth 9496
											Table —
A64	297401	0123	142	142							Booth 9496
											Table —
Totals			1050	959		91		24			

Total NET Clean Yards \_\_\_\_\_

Total NET Cut Yards \_\_\_\_\_

Shift: Nights Days  
(Circle one)

LAMINATOR TAKE-OFF AND DISPOSITION SHEET

Lam #1

Lot Number 71614

PEL Number 50295

"X" if clean/Roll #	Tag	Take off time	Gross Yards	Net Yards	Defect Code - Yards				Saved Yards	Scrim Roll # or Glue Tote Lot #	Emp #
					Code	Yds	Code	Yds			
X											Table
A 49	297370	2348	107	107							Booth 11032
X					BS	1					Table
A 50	297372	2352	97	96							Booth 11032
X											Table
A 51	297373	2355	82	82							Booth 11032
X					TS	2					Table
A 52	297375	0009	100	98							Booth 11030
X											Table
A 53	297379	0008	142	142							Booth 11032
X											Table
A 54	297382	0014	143	143							Booth 11032
X											Table
A 55	297383	0021	146	144	BS	2					Booth 11138
X											Table
A 56	297386	0028	140	140							Booth 11138
											Table
			957	952		5					Booth
Totals											

Total NET Clean Yards \_\_\_\_\_

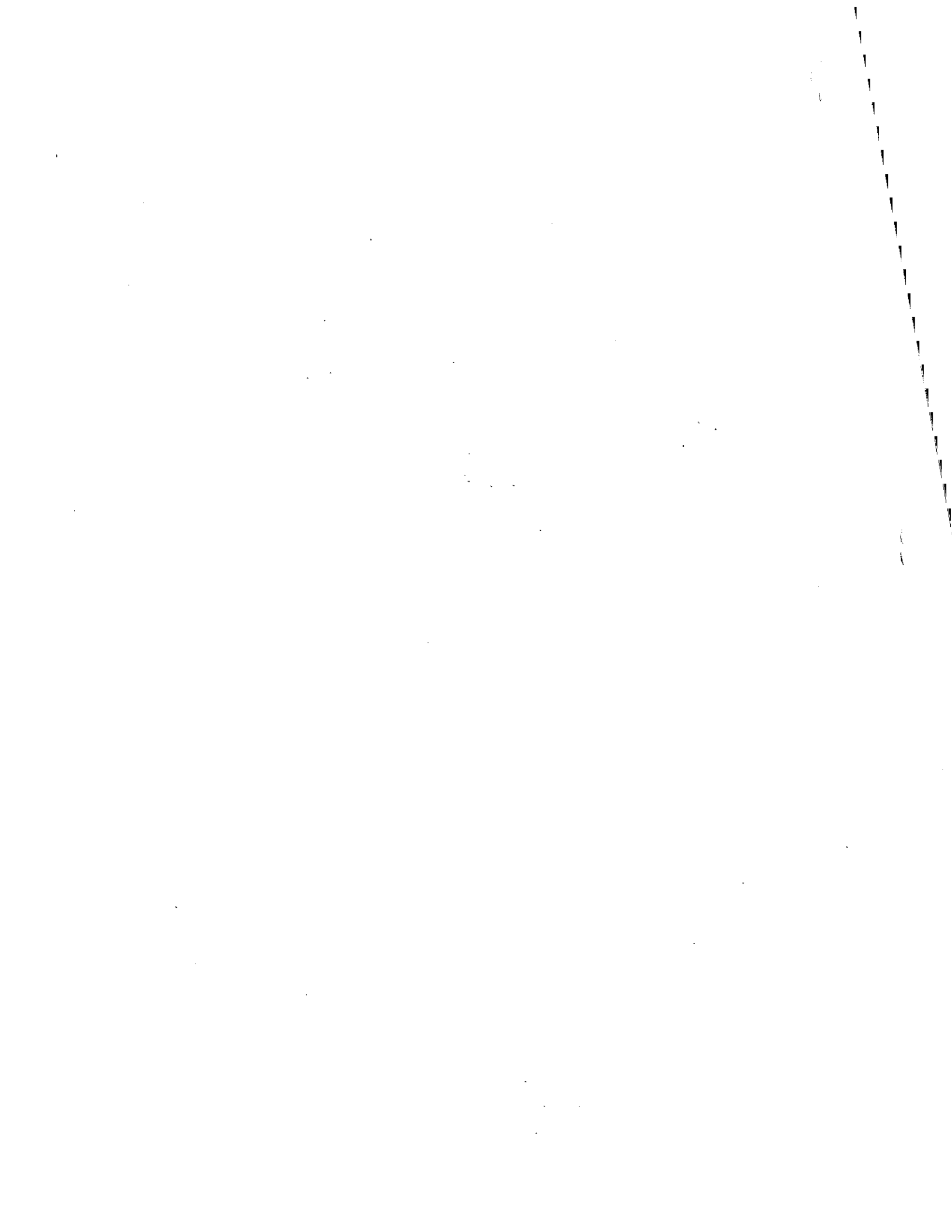
Total NET Cut Yards \_\_\_\_\_

M 725210

LOT NUMBER: 7/16/14	MATERIAL TYPE: 50295	LAM	#1
---------------------	----------------------	-----	----

TIME:	COMMENTS:
1900	Running 50 mil white
2100	Running okay had some string issues where string was stuck on the drum.
2300	Running okay 2.5 %
0100	Had 60 yds Scrim Runner on Scrim Splice caused us to jump to 3.1 %
0300	Running okay 2.9 %
0500	Running Good 2.5 %
0630	Switch to 1st Shift Paperwork

Employees	CHECKLIST			MACHINE SETTINGS	
BOTTOM: 11135	Shift	3rd	IRS. #1:	90 - 100 - 100	PRE PSI 65
TOP: 11226	BLADE CONDITION:	<input checked="" type="checkbox"/>	#2:	90 - 100 - 100	PRE 302°
BOOTH: 9496	FORKLIFT CAL-	<input checked="" type="checkbox"/>	#3:	100 - 100 - 100	CALENDAR: 0 %
TAKEOFF: 11138	FORKLIFT CHECK-	<input checked="" type="checkbox"/>	SPEED:	20	C.Cans 15 %
TABLE: 11002	HOIST CAL-	<input checked="" type="checkbox"/>	BPR PSI:	100	LAM: 331°
FLOATER: 11032	WINDER OP. #S-	<input checked="" type="checkbox"/>	TPR PSI:	100	HYDR: 50/50





SRN: N1749  
 Found: 8  
 (1 Revised)

Address: 725 E MORELY DRIVE  
 City: SAGINAW  
 County: SAGINAW

ZIP Code: 48601

Note: This address reflects permit No. 336-97B. The equipment addresses for other applications / permits may differ if they are for portable sources or if the company is located at a large complex.

Status: 1 Active Permit

Company	Permit No.	Rev.	Received	Denied	Approved	Voided	Remarks
PLASTATECH ENGINEERING, LTD	336-97B	0	3/31/2004		5/14/2004		MODIFICATION TO EXISTING PERMIT

Status: 1 Voided Application

Company	Permit No.	Rev.	Received	Denied	Approved	Voided	Remarks
PLASTATECH ENGINEERING, LTD	819-87	0	11/10/1987			5/2/1990	

Status: 6 Voided Permits

Company	Permit No.	Rev.	Received	Denied	Approved	Voided	Remarks
PLASTATECH ENGINEERING, LTD	336-97A	0	4/24/2002		12/17/2003	5/14/2004	MODIFICATION TO EXISTING PERMIT
S & S CUSTOM PLASTICS	1121-92	1	6/28/1993		11/18/1993	2/7/2006	EXTRUDER; PERMIT ALREADY INSTALLED SOURCE
S & S CUSTOM PLASTICS	1121-92	0	12/11/1992		3/26/1993	2/7/2006	EXTRUDER; PERMIT ALREADY INSTALLED SOURCE
S & S CUSTOM PLASTICS	169-91	0	2/7/1991		11/1/1991	11/22/1993	INJECTION MOLD MACH
PLASTATECH ENGINEERING, LTD	552-90	0	5/29/1990		9/21/1990	8/28/1998	COATING BOOTH
B & H PLASTICS, INC	577-89	0	6/28/1989		5/2/1990	8/28/1998	PLASTISOL COATING
B & H PLASTICS, INC	819-87A	0	12/26/1989		5/2/1990	8/28/1998	PVC APPLICATION

Note: This is a supplemental revision. Please remember to look at the details in the original record, i.e. Revision 0 (zero).



725 E Morley Dr  
Saginaw, MI 48601

Directions Save



Explore this area

Search nearby · fast food restaurants · roast beef



Map data ©2014 Google 1000 ft

