



**PARK 500**  
**INTER-OFFICE CORRESPONDENCE**  
Chester, Virginia

To: Craig Stariha

Date: May 15, 1993

From: Denise Donaher

*DD*

Subject: Pad Elimination Project Team Progress Report

**I. Project Objectives**

The general objective is to determine the causes of RL pads and eliminate them in product received by the primaries. The team will be involving the Primaries as customers of this effort and will be asking for their input in setting the objective (see attached memo to be issued). Also, the team is in the process of resolving measurement issues before a quantifiable objective can be set.

**II. Milestones Achieved**

- (1) The team completed the cause and effect diagram.
- (2) We prioritized the causes for the short term separately, based on the feasibility of implementing solutions. For the short term, the top level cause of RL pads was determined to be product distribution. After reviewing the work that the SIT team (C&I #9) is currently doing with the Sharkey Bar as a measure of product distribution in the hogshead, the team had no other solutions to add. Packing temperature was also determined to be a first level cause of pads for the short term. The team investigated the feasibility of further cooling the product with existing equipment, and quickly found out that we are limited by chilled water capacity. Based on the other work ongoing, the team is focusing its efforts to the longer term.
- (3) For the long term, the team identified the following factors as the likely top and first level causes of RL pads to be investigated: packing temperature, product distribution, storage time, storage conditions, and base web density. Other second level causes that the team is considering for inclusion in the experimental test plan are: finished sheet OV, finished sheet solubles, base web solubles, and packing weight.
- (4) The team has decided to pursue using R&D Semiworks primary as a measure or audit of the pad content in hogsheads of RL. The measurement will be used as the response variable in our experimental test plan.

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### III. Current Activity

- (1) The attached memo to the primary managers will be sent out tomorrow. We will try to schedule the objective setting meetings with the primaries during the first week in June.
- (2) Team members are meeting with R&D Semiworks personnel on May 18 to further discuss the details of our testing and their requirements. Initially the team plans to test 18 hogsheads. 9 hogsheads are needed to determine the variation of the method and another 9 for a baseline of normal process variation. The hogsheads were selected from the warehouse and will be returned to the broke system at Park 500 after testing at R&D. If no difficulties are encountered in arrangements with R&D, the initial testing will begin the week of 5/24.
- (3) Preliminary ideas for an experimental test plan are being discussed.

### IV. Progress & Issues

After obtaining input from our customers, the measures of effectiveness and objective will be finalized by the middle of June, which will complete the first phase in the Project Team System (Blocks 1-4). The appropriate documentation will be submitted at that time.

Depending on the success of having a viable measurement of pad content, the details of an experimental test plan should be also be completed in June with testing possibly able to begin by the end of the month (Blocks 5 & 6).

xc:

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