

PCL Production Costs

It is intended to carry out a world wide reappraisal of the various processes for waste utilization along the lines of the report produced after the 1962 Conference.

In order to establish the latest conversion costs for PCL at different plant capacities on a comparative basis it would be appreciated if the following questionnaire were completed :-

ANNUAL PRODUCTION OF PCL.	3,800,000	lb.
PLANT OPERATION	24	hours/day.
	5	days/week.
	48	weeks/year.
CAPITAL COST OF EQUIPMENT	\$1,441,976	
COST OF INSTALLATION	240,128	
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TOTAL	\$1,682,104	
BUILDING AREA AND COST	66,797 sq. ft.	Value \$442,801
Plant	30,805 sq. ft.	\$252,400
Warehouse	27,202 sq. ft.	\$136,491
MAJOR ITEMS OF EQUIPMENT		

Six Manton Gaulin S.M.D., one Rotary drier, two grinders, five Reitz disintegrators, three PCL driers, one Bird(dewatering) two Morehouse mills.

LENGTH OF BANDS, MAXIMUM CAPACITY AND EFFICIENCY.

310 feet 300 lbs/hr. 93% inclusive of starts,
per band per band stops and maintenance

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UNIT COST OF PCL

MATERIALS	COST/lb.	COST/lb. PCL
Tobacco lamina (1) 40% at .0224	51% at (2) .0651	.0292
stem	.0378	.0189
Winnowings (1)	.0224	.0026
	(1) incl. collection, storage & overhead (2) incl. purchase cost, storage & overhead	
ADDITIVES	COST/lb.	LEVEL OF ADDITION
Celando	.2700	7 1/2% on total solids at 3 to 1 ratio
		.0162
UTILITIES	REQUIREMENT/lb.	COST/UNIT
Electricity	1.035 Kw.H.	3.0087
Steam	18.3 lbs.	*See below
Water	4.110 gallons	\$0.48 per 1000 gallons
Bldg. & Process heat.	Oil .0311 gallons + Gas 18.53 cu. ft.	
	*Cost of steam included in above utilities, materials & labour costs	
		.0020
		.0115
LABOUR	NO.	** RATE/HOUR
Unskilled	3	\$2.70
Skilled	13	\$3.15
Supervision	6 plus 2 office	
		** incl. vacation, benefits and related costs
		.0040
		.0194
		.0179
MAINTENANCE	COST/YEAR	
Materials	\$90,800 (incl. one S.S. hand per annum)	.0238
Labour	\$26,250 (3 maintenance technicians plus any outside temporary labour)	.0070
GENERAL FACTORY EXPENSES		
DEPRECIATION	RATE	
Plant	7% of replacement value	.0277
Buildings	4% of replacement value	.0070
OTHER EXPENSES		
General expenses, etc. incl. taxes	\$114,400	.0301
Allocated charges from H.C. Depts.	101,078	.0266
Engineering & Research		
	TOTAL COST/lb.	.2519

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