

down both sides of two walls on the front exterior of the building will be a feature for decorative as well as for practical purposes in cooling water which goes through the latex ovens. This use of cascading water will also take the place of the need for a water tower. For further decorative effect, a fountain will shoot water upwards from the cascading water and this whole view will be exposed to employees in their dining room, where a tremendous window permits an unobstructed view of the water and fountain.

Cost of equipment and machinery will run about \$3 million, excluding the cost of the building itself. About 12,500 sq. ft. is being devoted to a sample room, which is being built on a high mezzanine directly over the shipping area.

Adjoining the sample room will be a computer room and also throughout this mezzanine area a number of executive offices, conference rooms, a showroom, and so on, all air-conditioned. Hot meals will be available to employees in an upstairs lunch-room through a battery of vending machines.

A combined conference and educational room will make use of projection machines, screens and other equipment designed to make the room useful for sales seminars and so on. Also high, upon the mezzanine, an observation platform is being constructed for visitors as well as civic and social groups on planned tours, with telescopes on the observation deck so that visitors may use them to get close-ups of some of the various manufacturing operations going on throughout the plant.

Movement of certain types of equipment will be made via use of in-floor conveyors, employing cables very similar to those used by the San Francisco cable cars. A 160-ft. single pass drying oven, with a total running length of over 300 ft. for the drying process, will be used not so much to provide heat as to give the fabric ample drying time.

No part of the plant will use less than 75 ft. candlelight power and no natural light will be employed because the plant will operate around the clock and, according to Mr. Moss: "We want goods looking the same at 2 p.m. as 2 a.m."

Along the executive suite offices "in use" lights will be used on all doors to indicate that an important conference is in session or, in other words, "Do Not Disturb." Other areas on the mezzanine will be devoted to an important contract office, a spacious showroom for sales training groups and designers' offices.

Initial production is expected to get under way by March 15. Everything in the plant will be color-keyed, even including long carts for the movement of carpet rolls. Each cart will handle from six to 15 rolls at a time, depending on weight. Rolls will be made from 600 to 1,500 ft. long, which will be folded into the carts for movement into other areas. The shipping area will accommodate 12 trucks and there are two railroad sidings alongside the plant.

The tufting room will be fully enclosed and temperature and humidity controlled at all times for pre-conditioning of the yarn. Some tufting machines will be employed initially. The sealed tufting room is being created to maintain steady consistency of humidity and yarn on creels will be kept in the room two days to pick up the temperature and humidity levels of the room before being put to use. The objective here is to get better pattern definition and less streaking. Trucks will move into and out of the tufting area through rubber doors which contain some kind of transparent plastic. Trucks will simply push right through the doors. Yarn on creels will be some 10 ft. from the floor and about two stories high in the air. "This whole system of temperature and humidity control in a carefully sealed room is a very unusual technique in the carpet industry," says Mr. Moss. All tufters will be 15 ft. wide.

About 300 to 350 people will be employed and many of them will be transferred from Walters' old plant.

All lighting throughout the entire plant is color corrected. A substantial amount of greige goods will be kept in the storage area and tufted goods will be stored in cantilever racks four high and will be conveyed to and from the racks by overhead bridge cranes, very much like those used in a steel plant. This crane will carry containers holding anywhere from six to 15 rolls of goods. About 3,500 rolls in greige goods will be kept in the storage area.

Even the color of the walls throughout the plant has been carefully selected for morale and decorative purposes, but more so to offer as little conflict as possible with the continuous exposure of colors in the processes of production of carpet by workers. The color: grey.

Fourteen dye becks will be totally enclosed to insure even water temperature for the purpose of minimizing side match problems. The first four becks will be