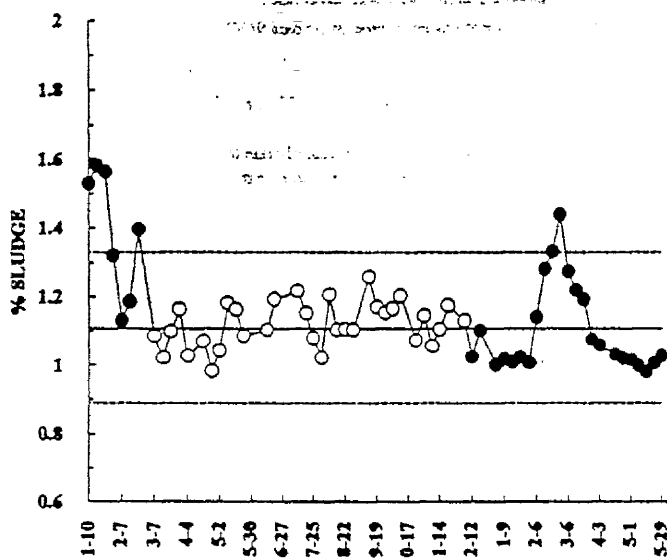


D. PROCESS VARIABILITY EVAP FD TK SLUDGE AVG.

LINE 1; RECORDER: C. CLAIBORNE

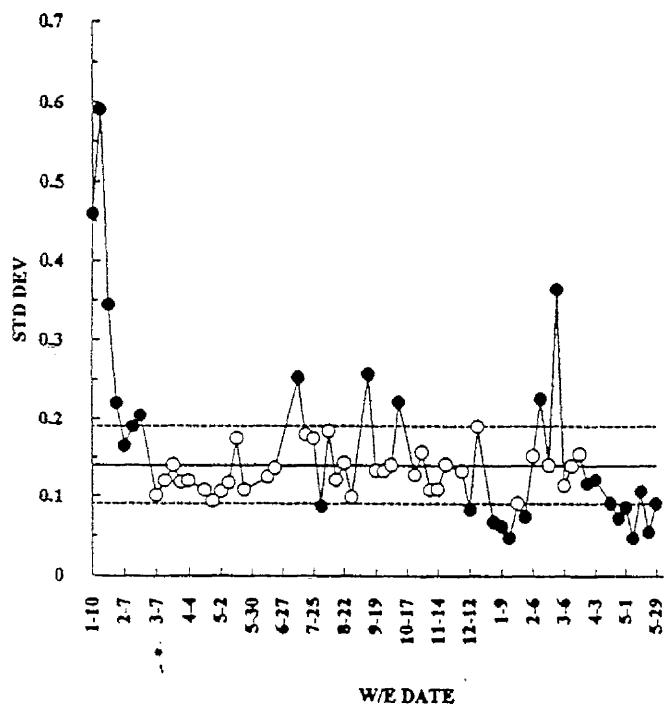
ANALYST: D. LOCKHART

UCL 1.33 CL 1.11 LCL 0.89  
EFFECTIVE 11/1/92



WEEKLY EVAP FD TK SLUDGE VARIABILITY LINE 1  
S CHART FOR W/E DATES 1/10/93 - 5/29/94

UCL .19 CL .14 LCL .09  
EFFECTIVE 11/1/92



W/E DATE

2.008

**Impact and Explanations**

3/6/94 No reason identified to explain OOC conditions.

3/13/94 High EFT solubles.

3/20/94 SEL solubles have been high on L2.

3/27/94 High SEL solubles.

5/8 - 5/15/94 Possibly due to a reduction of sludge in the raw materials.

5/22/94 Less var. in broke recycle. Less fiber in liquor syst. Reject boxes dumped twice during shift.

5/29/94 Recycle in broke is not fluctuating.

Not getting slot of fiber in the liquor syst.

Reject boxes are dumped twice a shift. Sludge dumpsters are not filling up quite as fast.

1/30/94 Decrease in var. due to less sand in raw materials.

2/13/94 No reason identified to explain increase in raw materials.

2/27/94 No reason identified to explain increase in var.

4/24/94 Decrease in var. due to changing of bird tips.

5/1/94 No reason identified to explain reduction in var.

5/8/94 Decrease in var. since replacing the tips on the bird cleaners.

5/15/94 Possibly due to a reduction of sludge in the raw materials.

5/22/94 Less var. in broke recycle.

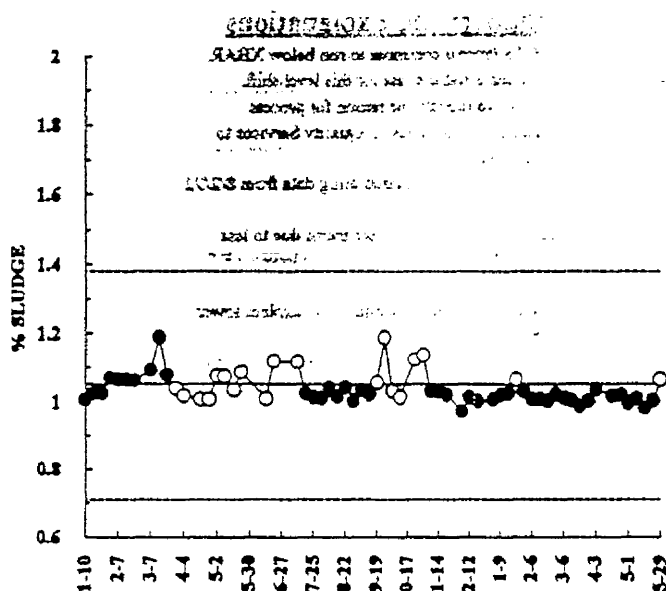
5/29/94 Recycle not fluctuating. Reject boxes are dumped twice a shift.

Confidential  
Philip Morris v. ABC

2025319705

D. PROCESS VARIABILITY EVAP FD TK SLUDGE AVG  
 LINE 2, RECORDER: C. CLAIRBORNE  
 ANALYST: D. LOCKHART

UCL 1.38 CL 1.05 LCL 0.71  
 EFFECTIVE 10/20/91



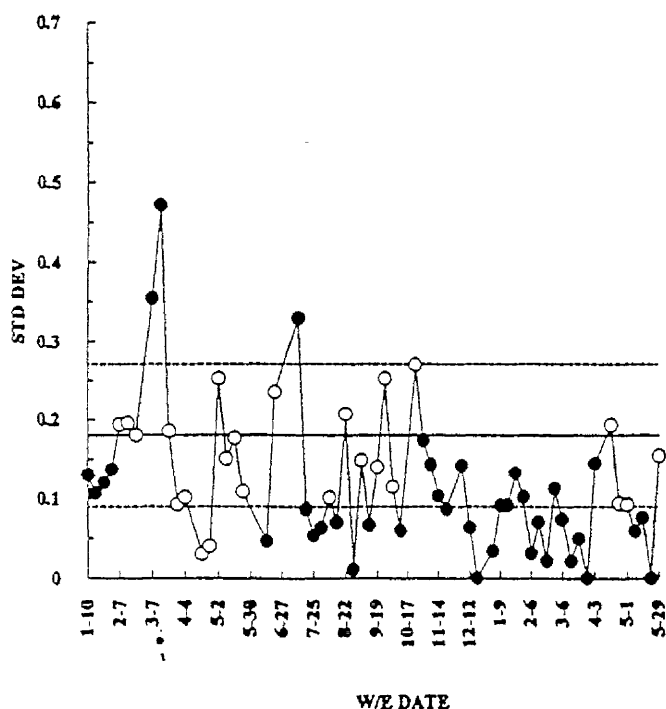
**Impact and Explanation**

3/13/94 OOC low possibly due to lower & more consistent EFT sol. due to more consistent broke feedback.  
 3/20/94 Low SEL sol.  
 3/27 - 4/3/94 OOC low due to more consistent SEL sol. possibly due to more consistent broke feedback.  
 4/17 - 5/1/94 More consistent SEL sol. possibly due to more consistent broke feedback.  
 5/8 - 5/15/94 Possibly due to a reduction of sludge in the raw materials.  
 5/22/94 Less var. in broke recycle. Less fiber in liquor syst. Reject boxes dumped twice during shift.  
 5/29/94 Reject boxes are being dumped regularly. Not alot of fiber is getting in liquor syst.

Confidential  
 Philip Morris v. ABC

WEEKLY EVAP FD TK SLUDGE VARIABILITY LINE 2  
 S CHART FOR W/E DATES 1/10/93 - 5/29/94

UCL 0.27 CL 0.18 LCL 0.09  
 EFFECTIVE 6/28/92



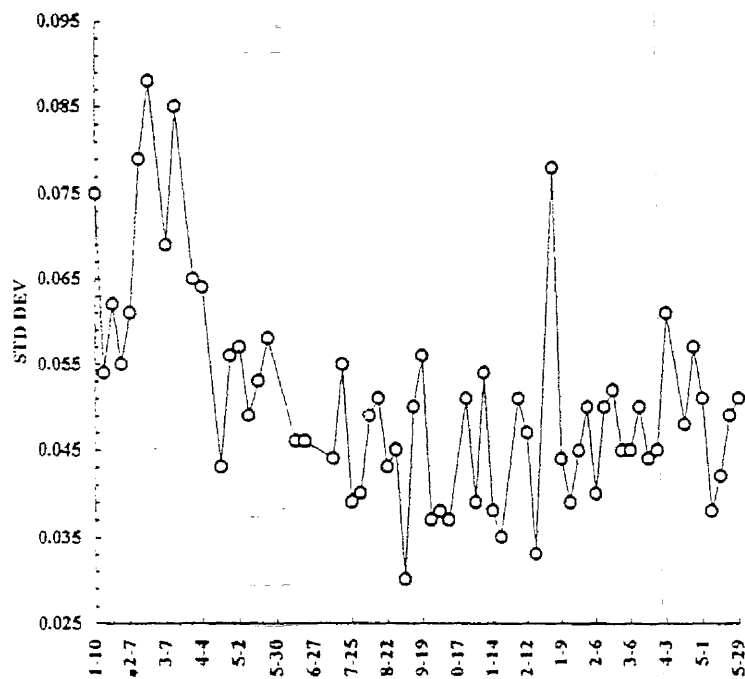
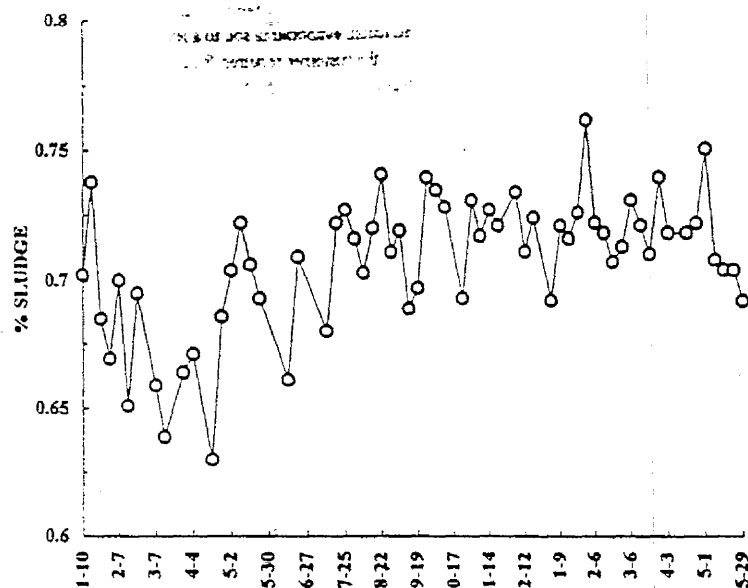
2/6/94 Decrease in var. possibly due to raw materials.  
 2/13/94 Decrease in sand possibly due to raw materials.  
 2/20/94 Decrease in sludge possibly due to raw materials.  
 2/27/94 No reason identified to explain reduction in var.  
 3/6/94 Decrease in var. possibly due to raw materials.  
 3/13/94 Decrease in var. due to more consistent broke feedback.  
 3/20/94 Low SEL sol.  
 3/27 - 4/3/94 Decrease in var. possibly due to more consistent SEL sol.  
 5/8 - 5/15/94 Decrease in var. due to more consistent SEL sol. due to more consistent broke feedback.  
 5/22/94 Less var. in broke recycle.

2.049

2025319706

D. PROCESS VARIABILITY EVAP FEED TANK SLUDGE AVG  
 RUN CHART, RECORDER: D. MERTZ  
 ANALYST: C. BURKE

7/25/74 1000.1



3.013

Impact and Explanations

5/94 Limits to be established

7/25 Value = .039

5/94 Limits to be established

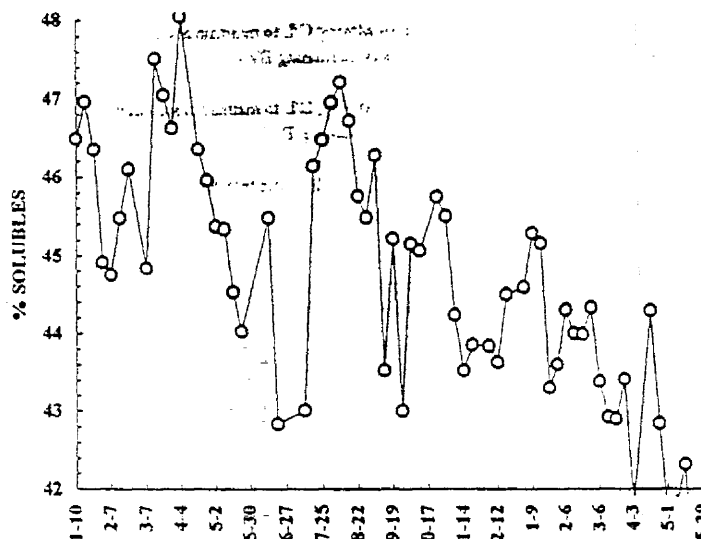
Confidential  
 Philip Morris v. ABC

2025319707

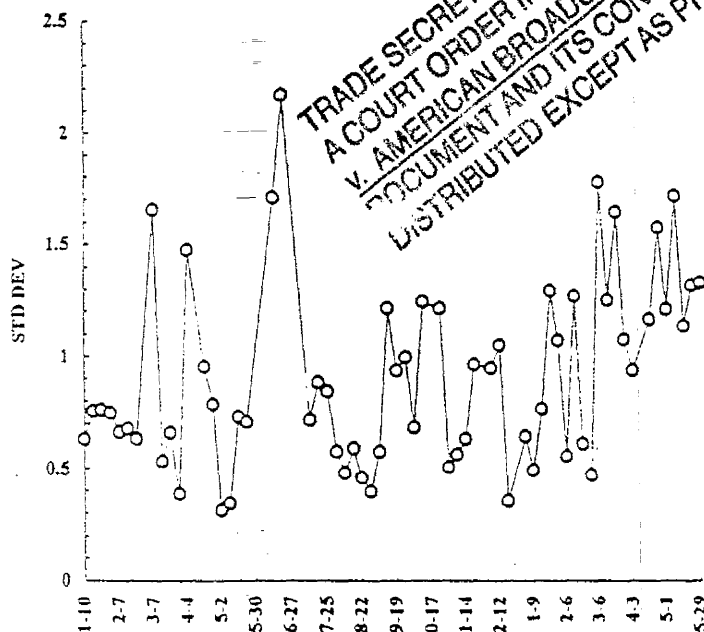
D. PROCESS VARIABILITY SIZE PREP SOLUBLES AVG  
 RUN CHART, RECORDER: D. MERTZ  
 ANALYST: C. BURKE

Impact and Explanations

6/20 Value = 42.836



WEEKLY SIZE PREP SOLUBLES VARIABILITY  
 RUN CHART



8/30 Value = 2.154

9/13 Value = 2.278

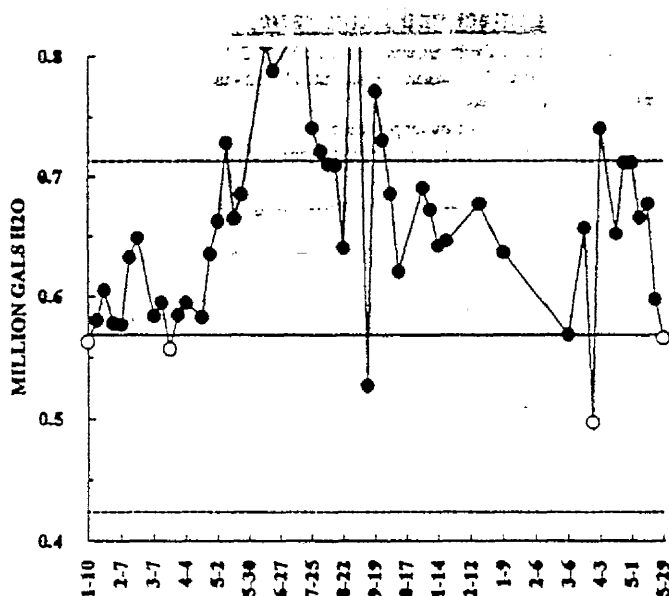
6/20 Value = 2.171

3.021

2025319708

F. PROCESSING DATA GALS PROCESS H<sub>2</sub>O AVG FROM  
WWT TO LINE 3, RECORDER: S. TARRY  
ANALYST: C. BURKE

UCL .7132190 CL .562300 LCL .4232410  
EFFECTIVE 6/9/91

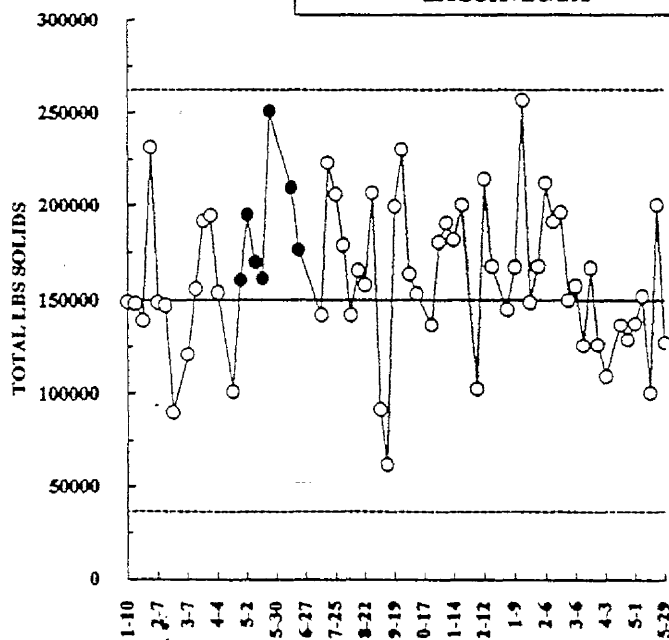


**Impact and Explanation:**

1/2/94 Not enough data taken to do TQM's.  
1/9/94 No expl. from the shift coordinators.  
1/16 - 2/27/94 Incorrect data - could not do TQM's.  
3/6/94 No explanation.  
3/13/94 Not enough correct data.  
3/20/94 Atmospheric tank in M.R. valved to sewer high silica. Mach. down for 3 hrs. lost power on 7-3 shift.  
4/3/94 Definite level shift, prob. solving initiated.  
5/22/94 Flow appears to correlate with vap of prob. having to use fresh H<sub>2</sub>O make-up on vap periodically.

WEEKLY TOTAL LBS SOLIDS FROM LINE 3 TO WWT  
X CHART, RECORDER: S. TARRY  
ANALYST: C. BURKE

UCL 262247 CL 149601 LCL 36954  
EFFECTIVE 3/1/92



10/11 NOTE: Waste Treatment experienced some calibration prob. with the L3 flow meter. Some of the flow data was a little high which would cause solids lbs. to be higher.  
11/1 The total lbs. is incorrect due to incorrect flows. Power outage on 10/29/92. On 10/31/92 Blending down to repair #11 w.b. & run five load checks on several other w.b.'s.  
11/8 L3 dumping B-100 stems shurry during this week causing solids to be up.  
11/15 Pounds are down but still OOC due to past numbers being high. They were high due to B-100 product being dumped on L3.  
11/22 No explanation.  
6/20 No explanation.

3.032

1 yr = 7,418,000 50  
7.5 million lbs

2025319709