




Shasta Mill

Kimberly Clark  Corporation

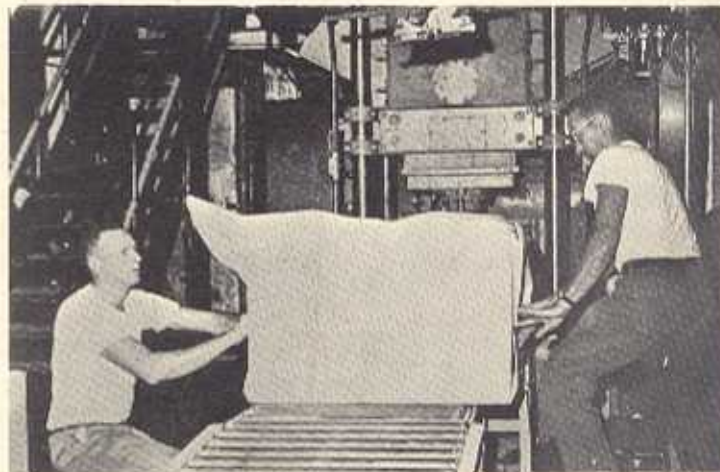
Shasta Division

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Fork lift operator Gerald Bohren drives into a boxcar next to the baling room to place one of nearly 1,000 bales which had been readied for shipment by Wednesday.



Al Coenen, left, and Harold Parker, dryer operators, wrap one of the first bales off the production line.

FLOW OF PULP FROM SHASTA MILL STEADIES AFTER INITIAL SHAKEDOWN PERIOD;
MILL MANAGER REPORTS NO OPERATIONAL PROBLEMS DURING STARTUP PHASE.

"The pulp mill is now in operation, and we're producing up to 100 tons daily," Tony Yankowski, Mill Manager, said today. "We will have brief shutdowns in the weeks ahead as the final shakedown of equipment takes place, but basically, we are 'on stream' in production of unbleached paper grade kraft pulp."

More than 230 tons, approximately 1,000 bales, were standing by in boxcars Wednesday awaiting quality tests by prospective consumers. This pulp will be moved out, and replaced by subsequent production, after the final shipping orders are received.

Reading from the daily reports, he summarized the startup period:

On September 16th, the mixing of solutions began, and the following day chemicals were introduced into the digester. The first of several delays came on the eighteenth when dried pulp plugged the digester blowline, and the following day a broken hydraulic line in the digester chip lifter required repair. On the 20th, finished pulp arrived at the drier and press. During this initial shakedown period, each element in the system was checked and adjusted. Various types of pulp were run through to allow placing of all the various systems on the line, and to achieve

the necessary chemical balance in the recovery boiler and other elements.

September 21st through October 5th was primarily a shutdown period to make minor design changes proven necessary in the drier, baler, and other units.

On October 5th, all the equipment was back in operation and production began with only intermittent shutdowns for minor mechanical difficulties.

The baler and drier equipment at Shasta are both items which have never before been used in pulp production, and the problems which developed were not unusual for new equipment.

"We didn't have any operational problems," he said. "They were all mechanical and we had skilled employes and manufacturers' representatives here around the clock to get the bugs out."

"The problems were solved through mutual effort convinces me we are developing the understanding necessary for effective team work. The extra efforts put forth by everyone involved substantially contributed to the progress we have made to date. This one is behind us. Next is the finishing room, bleachery, and groundwood mill."

ADAPTATIONS, MODIFICATIONS, OF PROVEN EQUIPMENT, COMBINED TO PROVIDE SHASTA MILL WITH THE MOST MODERN, EFFICIENT PULP-MAKING SYSTEM YET DEVELOPED FOR THE INDUSTRY

If necessity is the mother of invention, then progress, profit and perseverance are the wet nurses that bring it to maturity.

There are few elements of the Shasta Division pulp/paper plant which could be termed new inventions or exclusive processes. But the entire facility is studded with composites, modifications and improvements of proven equipment to make the Shasta Mill the most modern and progressive in existence.

When K-C representatives began negotiations with state and local officials, the local agencies established standards of air purity and water effluent discharge which K-C must meet to both the public agencies and K-C, the Shasta Division mill will equal or exceed the standards of any other pulp mill operating.

Innovations--in this case the best effluent control system existing--don't come cheaply. Cost of the Anderson effluent and air system has been estimated to exceed \$2 million.

The air purification system incorporates the best elements of the best system in the industry. It has three separate processes:

(1) An oxidation tower in which air is pumped through recovered pulping liquors to change the sulfur compounds into a more stable form which retards their breakdown into highly odorous gases which would pass out into the air.

(2) Odor forming gases which are formed at various points in the process are collected and given different treatments with air, chlorine-containing water, and caustic water before being discharged to the atmosphere. The liquids containing the odor forming chemicals go to the liquid effluent treating plant.

(3) A venturi scrubber in the recovery boiler stack recovers solid salt cake particles which would otherwise go out the stack.

The liquid effluent disposal system, in all of its tanks, has a capacity of 7.3 million gallons of the normal output from the mill for an 18 hour period. Instead of one system (or none, as in the case of some eastern mills), the Shasta Division effluent control has two complete systems one for removal of solids from the water and one for removal of dissolved matter.

Water for the mill is drawn from deep wells, used in the manufacturing process, then pumped into the river after purification to a quality equal to, or better than from any other pulp or paper mill.

The huge lime kiln found at many less modern mills has been replaced at Anderson by a fluo-solids calciner, which is an adaptation of the



Parker Gray, former development engineer with the Research and Development Department, Neenah, was literally up to his elbows in test tubes and other laboratory paraphenalia helping set up the lab.

lime recovery elements of the Lansing, Mich., municipal sewage disposal plant. It is the second one to be used in the industry. The slaker and causticizer have been combined into one unit here, and large gravity settlers and washers have been replaced by compact filters similar to the brown stock washers.

These three major changes have replaced elements which formerly required nearly as much space as a football field. They use about one-quarter that area, and required much less initial expense.

The first flash dryer in bleached kraft pulp production is located at Anderson. Smaller, less difficult to operate, and providing a product which can be repulped much more easily, the flash dryer also incorporated lower cost factors. Based on the principal of an alfalfa dryer developed in the Mortana range lands, it will produce dried pulp in a light, fluffy form resembling cotton, rather than heavy sheets.

Another technical example of K-C's desire to progress is the Impco continuous Digester, again a more compact unit than the batch cookers. It operates with a continuous flow of chemicals, water, and chips, and gives better quality control, less odor problems, and smoother operations.

When a visitor asks "What's new and different about the Shasta Mill?", he must be told that nearly everything here, in a modified form, has been tested and proven practical somewhere else or in some other industry. But by the same token, nearly every major component is the best available, and in combination the Anderson facility is the most modern mill in the nation.



concentration and interest in the problems of managing to an objective are etched in the faces of these pulp mill crew leaders during one of the many training sessions in the pulp mill conference room. At the rear table are Ken Cole, Wayne Thompson, Harry Bennett, Sandy Sand, Earl Swieg, and Ken Behling. Foreground are Herman Cheatle, William Keller, and Carey Duke.

THREE ADDITIONAL UNITS PLANNED FOR STARTUP DURING NOVEMBER

Three major units of the Shasta Division pulp and paper plant are expected to be placed on the line sometime during the month of November--the bleachery, the groundwood mill, and the paper mill finishing room.

Irv Kersten, specialist in paper manufacturing, said that early in November rolls of paper will be shipped from the Kimberly mill to Anderson. Here it will be supercalendared in our 80 inch fractional dekkle supercalendar, rewound, trimmed, cut, sorted, inspected, and packaged for sale to West Coast consumers.



"We are filling two needs," Kersten said. "First, we are allowing our finishing room crews to obtain experience and training before the paper mill starts. Secondly, we are developing a

limited inventory of stock for the sales department on the West Coast."

Bill Barry, from R&D, said the bleachery is expected to begin operations sometime during the first week of November. The six-stage unit, which is now being bypassed in the pulp-making process, will soon be placed on the line with a three man/shift crew.

Engineering trials are expected to begin early in November for the groundwood mill. Bleached groundwood will be sent to the K-D plant at Fullerton in wet-lap until the paper machine here is placed in operation.

RESEARCHERS TO VISIT

Approximately 75 members of the Forest Products Research Society will tour the pulp plant on Friday, October 23rd, according to Mill Manager A. A. Yankowski. Bob Blumenstein, Shasta Division's manager of woods products research, is a member of the board of directors of the society. Dixon Sandberg, resources manager, will appear on a

CALIFORNIA ABSENTEE VOTER PLAN ALLOW EARLY BALLOTING BY MAIL

General Manager A. D. Wilkinson today pointed out to all K-C employees that California's absentee voting procedure will allow them to vote even though they will be unable to get to their polling places on election day. "Any employee who fears that he will be away from his precinct on election day should request an absentee ballot from the county clerk," Wilkinson said.

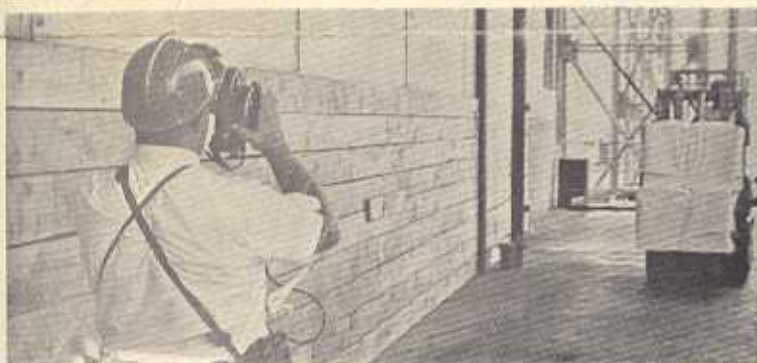
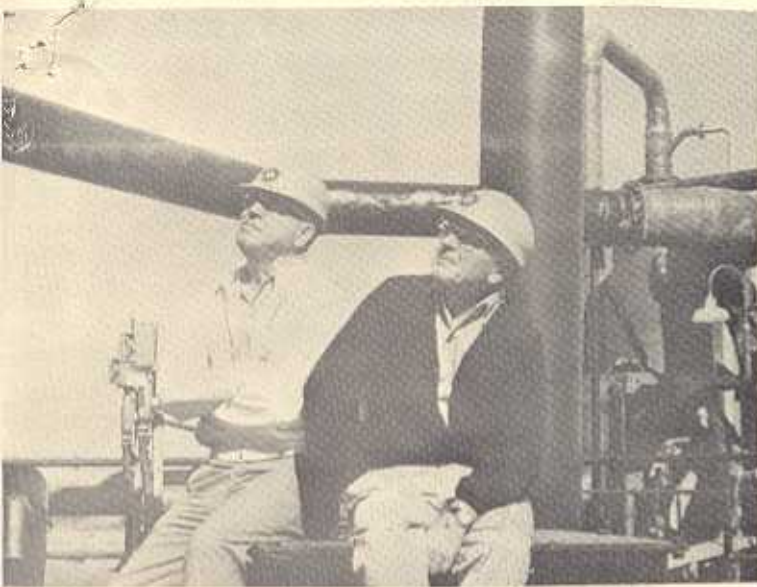
Registered voters can vote an absentee ballot in one of two ways: (1) appear at the County Clerk's office prior to 5:00 PM, October 27th, fill out the necessary forms and vote at that time. (2) Request in writing before October 27th that the County Clerk mail you an absentee ballot. The request must state that you will be absent from your polling place, give your present address (the address under which you are registered to vote), state the address to which you wish the absentee ballot sent, and signed in the same way that you are registered to vote. The voted ballot must be returned to the County Clerk's office prior to 5:00 PM November 2nd.

CHANGES FORCE HUNTING CLOSURE

"Operating conditions have changed on K-C lands near the Sacramento River and we are now forced to close the lands to all hunting," Ray Williams, assistant general manager, said today. The closed area is known as the River Ranch and is located between the Balls Ferry Road and the Sacramento River.

"A limited amount of pheasant and quail hunting was allowed last year" Williams said, "but the risk to employees, equipment, and livestock is too great to allow it to continue." He pointed out that K-C employees are now required to go into the area regularly in their work duties to test valves and spray equipment used by the effluent disposal system of the pulp mill. Several hundred head of livestock are also grazed on the land by local ranchers.

"We had hoped that at least some limited hunting by employees would be possible again this year," he said.



The trainers in the Pulp Mill are now going home. Some are still here to make changes in the procedure writeups. To all of them, I say thanks for all the people on the payroll for a job well done. When we are the "Best in the West" you will know you have played a part in getting us there. We appreciate your help and wish you success on your jobs back home.

It is now up to us to take the knowledge that these trainers have helped us to assimilate and put it to good use.

We must now prepare for the next phase of the total startup even while we are still uniforming the pulp mill operation. In this paper, there are the names of the people who are now on the scene for future startups. I know that they are part of the team and they are anxious to do their part to make this mill the "Best in the West".



TONY
YANKOWSKI

21 NEW EMPLOYEES ARRIVING

Training Coordinator, Tom Dennler, said today 21 new employes have arrived to begin startup operations of the Paper Mill. Sixteen are transferees from other K-C Mills. The new men, their jobs here, and their former Mills are: Niagara Falls Mill-Al Barr, Papermaker; Harvey Bennett, Mach. Tender; Lewis Conklin, Mach. Tender; Carey Duke, OMC Op.; Leon Cushman, OMC 1st Helper; Bill Keller, 175" Cal Op.; Sam Bolea, Stockman; Dave Mitchell, 175" Cal. Op.; Herman Cheattle, 80 Cal. Op.; Niagara Mill-Frank Knabenshue, Back-tender; Leonard Mickelson, Back Tender; Earl Swieg, 175" Cal. Op. Kimberly Mill-Francis Van Sambeek, Back Tender; Clancy Coates, Trimmer Coordinator; Ken Behling, OMC Op. Coosa River-Mill-Stell Young, Print Tester. New Employees-Wayne Thompson, Mach. Tender; Roy Paradis, OMC Op.; Ken Cortright, Fin. Rm. Crew Leader; Eugene Ray, Trimmer Operator; Gary McCollum, Fin. Rm. Mat'l. Handler.

Welcome to California and the Shasta Division!

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HELP NEEDED FOR SHASTA MILL

The SHASTA MILL is intended primarily to keep the Shasta Division employes informed of the activities, new developments, and personnel activities in the pulp and paper operations. To make the SHASTA MILL the paper you want it to be we need your help.

Keep us informed of the activities in your area,--personal items, births, promotions, graduations, and other activities about yourself and other employes. Please turn in your news to Sharon Newman, Dianne Jackson, Lillian McDonald, Barbara Williams, or Milene McConnell, our Shasta Mill representatives.

Over the past several weeks, wood chips, chemicals, and water were forced through more than 350 miles of piping in the startup of the new Shasta Mill.

In the top picture, C.G.R. "Russ" Johnson, and William Kellett, former President of the Kimberly-Clark Corporation, observe work on the digester from the top of the Pulp Mill. In the center picture, Arden Falk, left, Maintenance Crew Leader, from the Lakeview Mill, and Thomas Eatmon, pulping operator, check the valves at the hot stock screen.

In the bottom picture, Blaine Graham, Channel 7 Newsman, carried to the community the news that the first bales of Kimberly-Clark pulp from the Shasta Division had been loaded on boxcars