

TABLE VIII

Operation	High pressure steam (176-220 psi), lbs/barrel of Alkylate.	Low pressure steam (37 psi) lbs/barrel of Alkylate.	Power high voltage KWH/barrel of Alkylate	Low voltage KWH/barrel of Alkylate	Circulating water gals./barrel of Alkylate	Make up water gals./barrel of Alkylate.	Fuel Gas BTU/barrel of Alkylate	Labour		Process Workers
								Foremen	Lab. Technician	
Dehydrogenation	-	320	-	11.1	646	-	937,000			
Compression of dehydrogenated gas and absorption unit	35	-	23.2	1.4	2,530	-	-	4		35
Alkylation, including Refrigeration.	1,225**	-	-	8.2	3,840	-	-	3		20
Butane-isobutane separation, Depropenizer	-	1,100	-	2.7	3,840	27	-			
Debutanizing of Alkylate, distillation of alkylate	302	382	18.5*	2.7	3,840	27 147*	-	4	1	28
TOTAL	1,562	1,802	41.7	26.1	14,696	201	937,000	11 42 14	1 machinists	83

** for butane refrigeration
* for water circulation