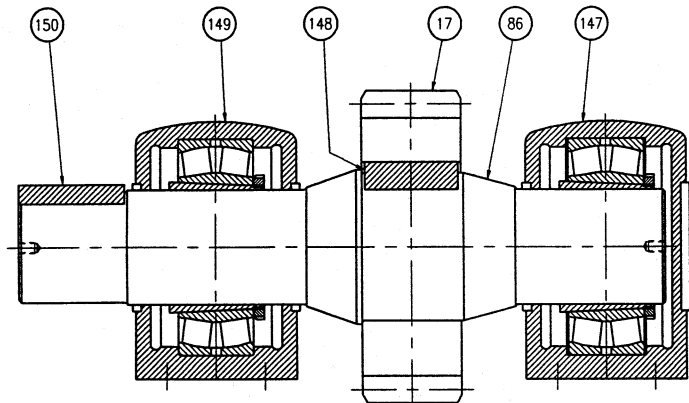


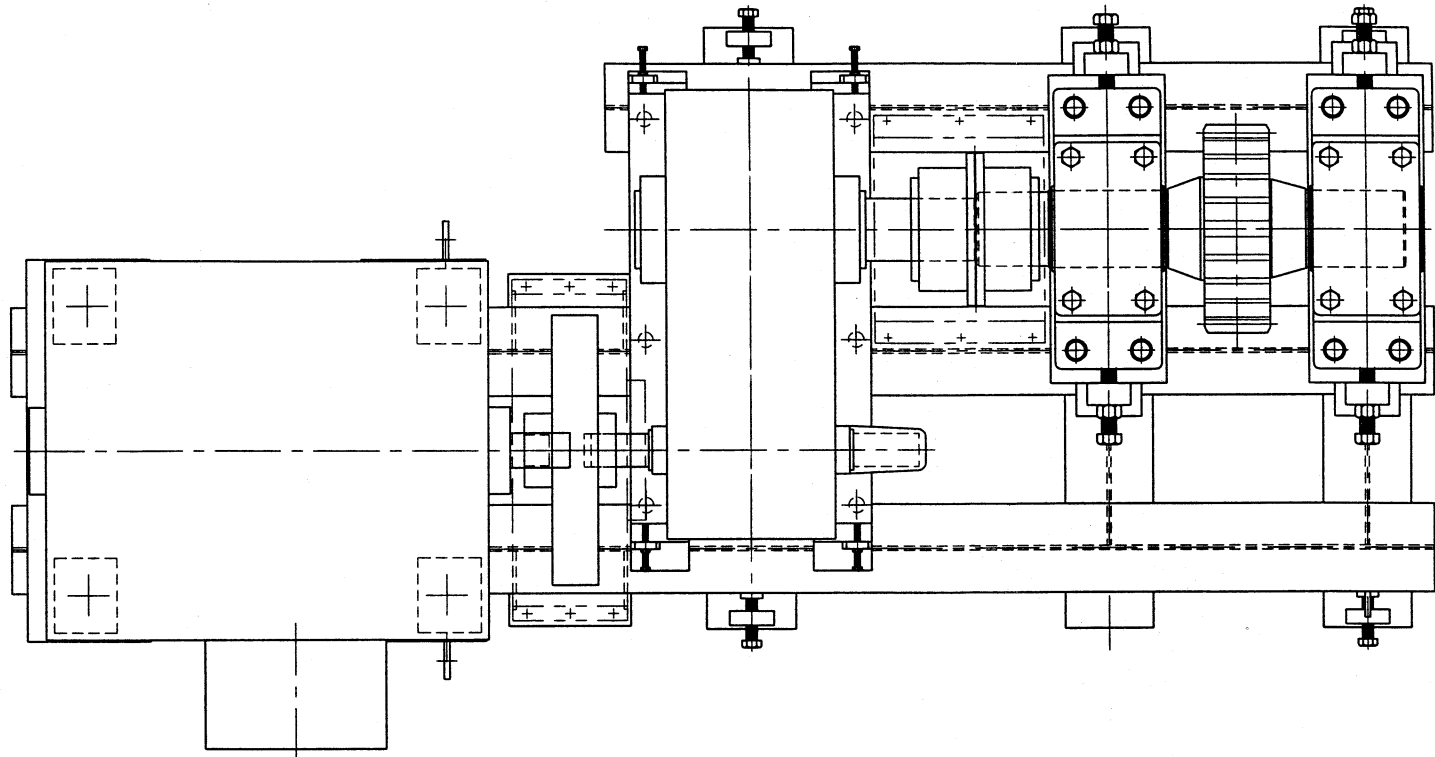
REVISIONS				
NO.	DATE	REMARKS	BY	CHK
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12	HEX BOLT	A193-B7	1/2"-13UNC X 3/4" LG.	244		6	HEX HEAD BOLT	A193-B7	5/8"-11UNCx1 1/2" LG.	172		1	DRIVE GEAR SHAFT			86	
12	HEX HEAD CAPSCREW	DIN 961	M30X2X230 8.8	243	SANTASALO	1	T-HANDLE LATCH W/ OFFSET PAWL		P/N 11595A12	171	McMASTER-CARR	1	STANDOFF			85	
12	HEX NUT	DIN 934	M30X2 8	242	SANTASALO	1	GREASE FITTING		ALEMITE 196/S 1/8"NPT	170	OR EQUAL	1	STANDOFF			84	
24	HEX HEAD CAPSCREW	DIN912	M24X70 8.8	241	SANTASALO	6	HEX HEAD CAPSCREW	A193-B7	1/2-13UNC X 3/4 LG.	169		2	SHIM PLATE			83	
55	WASHER	SMS70, 200HB	BRB 37 68	240	SANTASALO	1	LOCK NUT		AN26	168	SKF OR EQUAL	1	ROD ASSEMBLY			82	
22	WASHER	SMS70, 200 HB	BRB 31 58	239	SANTASALO	1	LOCK WASHER		W26	167	SKF OR EQUAL	1	NOZZLE HOLDER			81	
22	HEX NUT	DIN 985	M30 8	238	SANTASALO	2	TAPER ROLLER BEARING		32226	166	SKF OR EQUAL	4	ANGLE BRACKET			80	
22	HEX HEAD SCREW	DIN931	M30X110 8.8	237	SANTASALO	28	FLAT WASHER	A36	5/8" NOM.	165		1	CROSS SUPPORT			79	
22	WASHER	SMS70, 200 HB	BRB 31 58	236	SANTASALO	32	HEX HEAD BOLT	A193-B7	5/8"-11UNC X 1" LG.	164		1	END INSPECTION COVER			78	
22	HEX NUT	DIN 985	M30 8	235	SANTASALO	4	HEX HEAD CAPSCREW	A193-B7	3/4"-10UNC X 1 1/2" LG.	163		1	DRIP PAN			77	
22	SHOULDER SCREW	DIN 931	M30X110 8.8	234	SANTASALO	2	PROXIMITY SENSOR		P/N Ni 4-G12-AZ33X	162	TURCK	1	SIDE INSPECTION COVER			76	
55	WASHER	SMS70, 200 HB	BRB 37 68	233	SANTASALO	8	WASHER	A36	1/4" NOM.	161		1	SIDE INSPECTION COVER			75	
55	HEX NUT	DIN 985	M36 8	232	SANTASALO	8	HEX HEAD CAPSCREW	A193-B7	1/4"-20UNC X 3/4" LG.	160		1	END COVER			74	
55	SHOULDER SCREW	DIN609	M36X150 38h9 8.8	231	SANTASALO	4	PILLOW BLOCK ASSEMBLY	FREE (ONE END CLOSED)	SDAF23256KCLx10 7/16" W/ ADAPTER	159	TORRINGTON	1	SUPPORT FRAME			73	
5	LOCK WASHER	A36	3/8" STANDARD	230		6	HEX HEAD BOLT	A193-B7	1"-8 THD. X 6" LG.	158	THREAD FULL LENGTH	1	GIRTH GEAR GUARD SECTION III			72	
5	HEX NUT	A194-2H	3/8"-16UNC	229		40	HEX NUT	A194-2H	1"-8 THD.	157		1	GIRTH GEAR GUARD SECTION II			71	
1	LOCK WASHER	A36	NO. 10 STANDARD	228		16	HEX HEAD BOLT	A193-B7	1"-8 THD. X 6-1/2" LG.	156	THREAD FULL LENGTH	1	GIRTH GEAR GUARD SECTION I			70	
1	HEX NUT	A307	NO. 10-24UNC	227		16	HEX NUT	A194-2H	2"-8" THD.	155		1	PULLEY SUPPORT BRACKET			69	
1	HEX HEAD BOLT	A307	NO. 10-24UNC X 2" LG.	226		16	HEX HEAD BOLT	A193-B7	2"-8" THD. X 8" LG.	154	THREAD FULL LENGTH	1	WEIGHT			68	
71	HEX NUT	A194-2H	1/2"-13UNC	225		32	HEX NUT	A194-2H	1-5/8"-8 UNC	153		1	PIVOT PIN			67	
48	HEX HEAD CAPSCREW	A193-B7	1/2"-13UNC X 1 1/2" LG.	224		2	HEX HEAD BOLT	A193-B7	1-5/8"-8 UNC X 8-1/2" LG.	152		1	TENSION PLATE			66	
16	HEX HEAD CAPSCREW	A193-B7	1/4"-20UNC X 5/8" LG.	223		4	PILLOW BLOCK ASSEMBLY	HELD (ONE END CLOSED)	SDAF23256KCLx10 7/16" W/ ADAPTER	151	TORRINGTON	1	WEIGHT HANGER ROD			65	
4	HEX NUT	A194-2H	3/4"-10UNC	222		1	KEY	A108-1045	1 3/4" X 2 1/2" X 9 3/4" LG.	150	ONE END ROUND	2	PULLEY			64	
4	HEX BOLT	A193-B7	3/4"-10UNC X 1 3/4" LG.	221		1	PILLOW BLOCK BEARING	HELD	SDAF23256Kx10 7/16" W/ ADAPTER	149	TORRINGTON	1	SEAL PROTECTOR			63	
8	FLAT WASHER	A36	1/2" NOM.	220		1	KEY	A108-1045	2 1/2" X 3 1/2" X 8 1/2" LG.	148	BOTH ENDS ROUND	1	DRIP PAN SUPPORT ARM			62	
8	HEX HEAD CAPSCREW	A193-B7	1/2"-13UNC X 2 1/2" LG.	219		1	PILLOW BLOCK BEARING	FREE (ONE END CLOSED)	SDAF23256Kx10 7/16" W/ ADAPTER	147	TORRINGTON	1	DISTRIBUTION PIPE			61	
8	HEX HEAD CAPSCREW	A193-B7	1/2"-13UNC X 1 3/4" LG.	218		4	HEX NUT	A194-2H	3/4"-10UNC	146		1	DRIP PAN			60	
16	CENTERLOCK NUT	BRB 37 68	1/4"-20UNC P/N 90040A029	217	McMASTER-CARR	1	KEY	A108-1045	2" X 1 1/2" X 13"	145		1	SUPPORT STRUCTURE			59	
1	COTTER PIN	A36	P/N 98338A22	216	McMASTER-CARR	1	KEY	A108-1045	1" X 1" X 6"	144		1	INLET FUNNEL			58	
4	HORIZONTAL HANDLE HOLD DOWN ACTION TOGGLE CLAMP	P/N 5128A66		125	McMASTER-CARR	1	KEY	A108-1045	1" X 1" X 8"	143		1	MOUNTING BRACKET			57	
10	HAND KNOB	CAST IRON DIN PLATING	P/N HK-410	214	MORTON MACHINE	20	HEX NUT	A194-2H	1 1/4"-8 UNC	142		1	ROD ASSEMBLY			56	
1	WASHER	A36	4" O.D. X 1 9/16" I.D. X 5/16" THK.	213		6	HEX BOLT	A193-B7	1 1/2"-8 UNC X 6 1/2" LG.	141	THREAD FULL LENGTH	4	MOUNTING BRACKET			55	
6	FLAT WASHER	A36	1/2" NOM.	212		6	HEX NUT	A194-2H	1 1/2"-8 UNC	140		4	ROD ASSEMBLY			54	
6	NUT	A194-2H	1/2"-13 UNC	211		4	HEX NUT	A194-2H	1 1/4"-8 UNC	139		5	NOZZLE HOLDER			53	
6	BOLT	A193-B7	1/2"-13 UNC X 1 3/4" LG.	210		4	HEX BOLT	A193-B7	1 1/4"-8 UNC X 4 1/2" LG.	138		4	ADJUSTABLE MOUNTING BRACKET ASSEMBLY			52	
6	U-BOLT		8875T82 3/8"-16 UNC	209	McMASTER-CARR	4	HEX BOLT	A193-B7	3/4"-10 UNC X 6" LG.	137	THREAD FULL LENGTH	1	COVER GASKET			51	
1	NUT	A194-2H	5/8"-11 UNC	208		6	HEX BOLT	A193-B7	2"-8 UN X 4" LG.	136		1	BEARING COVER			50	
5	COTTER PIN		1/4" X 2 1/2" LG.	207		4	HEX BOLT	A193-B7	2"-8 UN X 9" LG.	135	THREAD FULL LENGTH	1	SEALING RING			49	
1	TEFLON SEAL	GARLOCK	PACKMASTER, #1-1 1/4" SQ. X 42 FT.	206		32	WASHER	F436 (THROUGH HARDENED)	1 3/4" I.D., 3" O.D., 1/4" THICK	134		1	GUIDE ROLLER			48	
12	HEX NUT	A194-GR. 8	1/2"-13UNC	205		8	HEX BOLT	A193-B7	1 5/8"-8UNC X 9" LG.	133		1	AXIAL ROLLER SHAFT			47	
12	SOCKET HEAD CAPSCREW	A193-B8	1/2"-13UNC X 1 3/4" LG.	204		4	HEX NUT	A194-2H	2"-8 UN	132		1	BASE PLATE			46	
20	HEX HEAD CAPSCREW	A193-B7	5/8"-11UNC X 2 1/2" LG.	203	GALVANIZED	20	HEX BOLT	A193-B7	1 1/4"-8UNC X 4 1/2" LG.	131		4	SUPPORT ROLLER GUARD			45	
20	HEX NUT	A194-2H	5/8"-11UNC	202	GALVANIZED	20	HEX BOLT	A193-B7	1"-8UNC X 6" LG.	130	THREAD FULL LENGTH	1	AXIAL ROLLER GUARD			44	
16	HEX NUT	A194-2H	7/8"-9UNC	201	GALVANIZED	20	WASHER	F436 (THROUGH HARDENED)	1 3/8" I.D. X 2 1/2" O.D. X 1/4" THK.	129		8	STOP BLOCK			43	
16	HEX HEAD CAPSCREW	A193-B7	7/8"-9UNC X 2 1/2" LG.	200	GALVANIZED	32	HEX NUT	A194-2H	1 5/8"-8 UNC	128		4	ROLLER POSITION SWITCH BRACKET			42	
18	HEX HEAD CAPSCREW	A193-B8	1/2"-13UNC X 2 1/4" LG.	199		1	COUPLING		1070G20	127	FALK	4	ROLLER POSITION SWITCH BRACKET STAND			41	
3	GASKET	GARLOCK 3700	1/8" X 5 3/8" O.D. X 3 1/2" I.D.	198		1	REDUCER		485A2-C-19.20:1, ASSY 18	126	FALK	4	SUPPORT ROLLER SHAFT			40	
1	GASKET	GARLOCK 3700	1/8" X 8 1/2" O.D.	197	BLIND, NO I.D.	1	MAGNETIC COUPLING		EMTO 33.0S BMC	125	REYNORD	4	SUPPORT ROLLER			39	
8	HEX NUT	A194-2H	3/4"-10UNC	196	GALVANIZED	1	MOTOR		900 HP, 1800 RPM, TYPE 500M	124	ASEA-BY CUST.	1	DRUM STOP			38	
8	HEX HEAD CAPSCREW	A193-B7	3/4"-10UNC X 3 1/2" LG.	195	GALVANIZED	1	COTTER PIN	304 S.S.	5/32" DIA. X 1" LG. P/N 98401A493	123	McMASTER-CARR	1	AXIAL ROLLER ASSEMBLY			37	
1	BLIND FLANGE	A105/GALV.	6"-150#	194		1	CLEVIS PIN	18-8 S.S.	1/2" DIA. X 1 1/4" LG. P/N 92390A381	122	McMASTER-CARR	1	SUPPORT ROLLER FRAME (DISCHARGE)			36	
5	LOCKWASHER	A36	3/8" STANDARD	193		2	VALVE, BUTTERFLY	316 S.S./S.S. HANDLE	4", WAFER SERIES 20	121	BRAY	1	SUPPORT ROLLER FRAME (INLET)			35	
5	HEX NUT	A194-2H	3/8"-16UNC	192		26	HEX HEAD BOLT	A193-B8/GALV.	5/8"-11UNC X 1 3/4" LG.	120		1	COUPLING GUARD, MAGNETIC COUPLING			34	
1	LOCKWASHER	A36	#10 STANDARD	191		16	HEX NUT	A194-GR8	5/8"-11UNC	119		1	COUPLING GUARD, PINION SHAFT			33	
1	HEX NUT	A194-2H	#10-24UNC	190		16	HEX HEAD BOLT	A193-B8	5/8"-11UNC X 5 1/2" LG.	118		4	STOP BLOCK			32	
1	HEX HEAD CAPSCREW	A193-B7	#10-24UNC X 2" LG	189		8	HEX NUT	A194-2H/GALV.	3/4"-10UNC	117		1	SUPPORT RAIL			31	
2	LOCKWASHER	A36	5/16" STANDARD	188		8	HEX HEAD BOLT	A193-B7/GALV.	3/4"-10UNC X 1 3/4" LG.	116		1	SUPPORT RAIL			30	
2	HEX NUT	A194-2H	5/16"-18UNC	187		2	GASKET	GARLOCK 3700	1/16" X 10 5/8" DIA. (FULL FACE)	115		1	SUPPORT RAIL			29	
3	COTTER PIN	P/N 98338A22		186	McMASTER-CARR	2	GASKET	GARLOCK 3700	1/16" X 8 1/2" DIA. (FULL FACE)	114		2	SUPPORT RAIL			28	
3	WASHER	A36	1" O.D. X 3/8" I.D. X 1/8" THK.	185		48	HEX HEAD BOLT	A193-B7/GALV.	5/8"-11UNC X 5 1/2" LG.	113		1	DRIVE SUPPORT FRAME			27	
8	HEX NUT	A194-2H	1/2" - 13UNC	184		90	HEX NUT	A194-2H/GALV.	5/8"-11UNC	112		1	DRIVE GEAR ASSEMBLY			26	
8	HEX HEAD CAPSCREW	A193-B7	1/2" - 13UNC X 1 1/4" LG.	183		16	HEX HEAD BOLT	A193-B7/GALV.	5/8"-11UNC X 3" LG.	111		5	ARM WELDMENT			25	
3	COTTER PIN	A36	P/N 98338A22	182	McMASTER-CARR	2	FLANGE, BLIND	CARBON STEEL STAINLESS CLAD	8"-150#	110	PAINTED	1	HEADER ASSEMBLY			24	
1	LOCK WASHER	A36	NO. 10 STANDARD	181		8	HEX HEAD BOLT	A193-B8/GALV.	3/4"-10UNC X 1 3/4" LG.	109		2	INSPECTION HATCH ASSEMBLY			23	
1	HEX NUT	A307	NO. 10-24UNC	180		2	FLANGE, BLIND	CARBON STEEL STAINLESS CLAD	4"-150#	108	PAINTED	1	GASKET			22	
1	HEX HEAD BOLT	A307	NO. 10-24UNC X 2" LG.	179		6	VALVE, BUTTERFLY	CAST IRON EDPM	4", WAFER SERIES 20	107	BRAY	1	MANHOLE COVER ASSEMBLY			21	
2	LOCK WASHER	A36	5/16" STANDARD	178		1	GASKET	GARLOCK 3700	1/8" THK. FULL FACE	106		12	ASSEMBLY TOOL			20	
2	HEX NUT	A194-2H	5/16"-18UNC	177		8	HEX NUT	A194-2H	3/4"-10UNC	105		22	PLATE		SANTASALO	19	
5	LOCK WASHER	A36	3/8" STANDARD	176		8	HEX HEAD BOLT	A193-B7	3/4"-10UNC X 2 1/2" LG.	104		11	GEAR SEGMENT		SANTASALO	18	
5	HEX NUT	A194-2H	3/8"-16UNC	175		1	FLANGE, BLIND	CARBON STEEL STAINLESS CLAD	8"-150#	103	PAINTED	1	DRIVE GEAR		SANTASALO	17	
6	LOCKWASHER	STEEL	5/8"	174		10	COTTER PIN	304 S.S.	5/32" DIA. X 1" LG. P/N 98401A493	102	McMASTER-CARR	1	SUPPORT RING - DISCHARGE END			16	
6	HEX NUT	A194-2H	5/8"-11UNC	173		10	CLEVIS PIN	18-8 S.S.	1/2" DIA. X 1 1/4" LG. P/N 92390A381	101	McMASTER-CARR	1	SUPPORT RING - INLET END			15	
						1	COTTER PIN	STN. ST.	3/16" X 2 1/2"	100		2	SEAL RING			14	
						1	THREADED STUD	A193-B7/GALV.	5/8"-11UNC X 6" LG.	99		1	SLOPE GUAGE			13	
						3	HEX NUT	A194-2H/GALV.	5/8"-11UNC	98		1	WEIGHT GUARD			12	
						1	FLAT WASHER	A36	5/8" STD.	97		1	GIRTH GEAR GUARD ASSEMBLY			11	
						4	SPRAY NOZZLE	P/N 1/2GDS25	96	SPRAYING SYSTEMS CO.		1	INLET SEAL ASSEMBLY			10	
						10	HEX NUT	A194-2H/GALV.	3/4"-10UNC	95		1	INLET FUNNEL & SUPPORT ASSEMBLY			9	
						10	HEX HEAD BOLT	A193-B7/GALV.	3/4"-10UNC X 3 1/4" LG.	94		1	SUPPORT ROLLER ASSEMBLY, AXIAL ROLLER, INLET END			8	
						6	THREADED STUD	A240-304L	5/8"-11UNC X 2 3/4" LG.	93		1	SUPPORT ROLLER ASSEMBLY, DISCHARGE END			7	
						1	INSPECTION COVER	MODEL # CMD-R3	92	TSUBAKI		1	DRIVE ASSEMBLY			6	
						56	WASHER	A36/GALV.	5/8"	91		1	HOOD ASSEMBLY			5	
						56	HEX NUT	A194-2H/GALV.	5/8"-11 UNC	90		1	BOTTOM VAT ASSEMBLY			4	
						56	HEX BOLT	A193-B7/GALV.	5/8"-11UNC X 1 1/2" LG.	89							

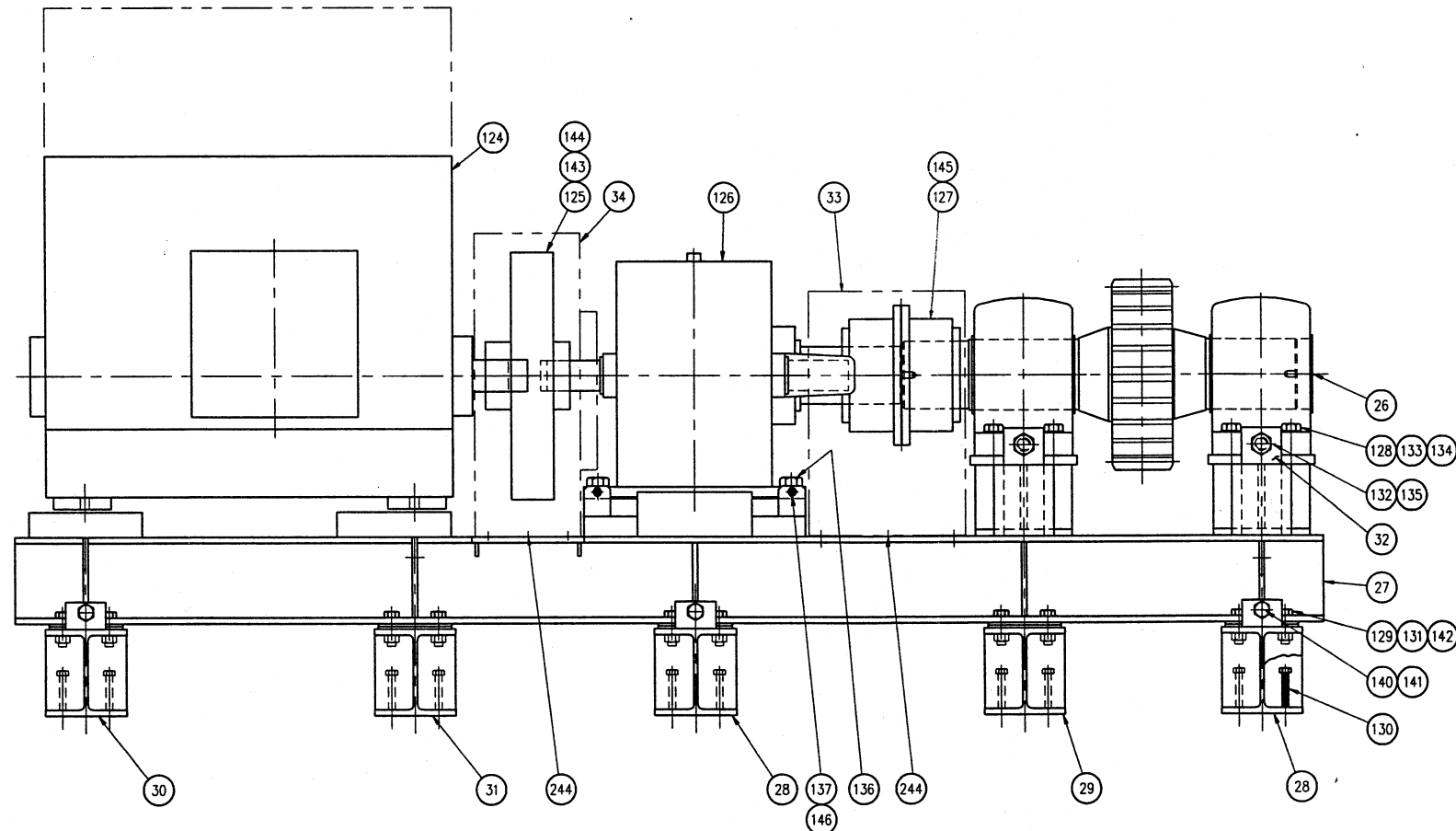
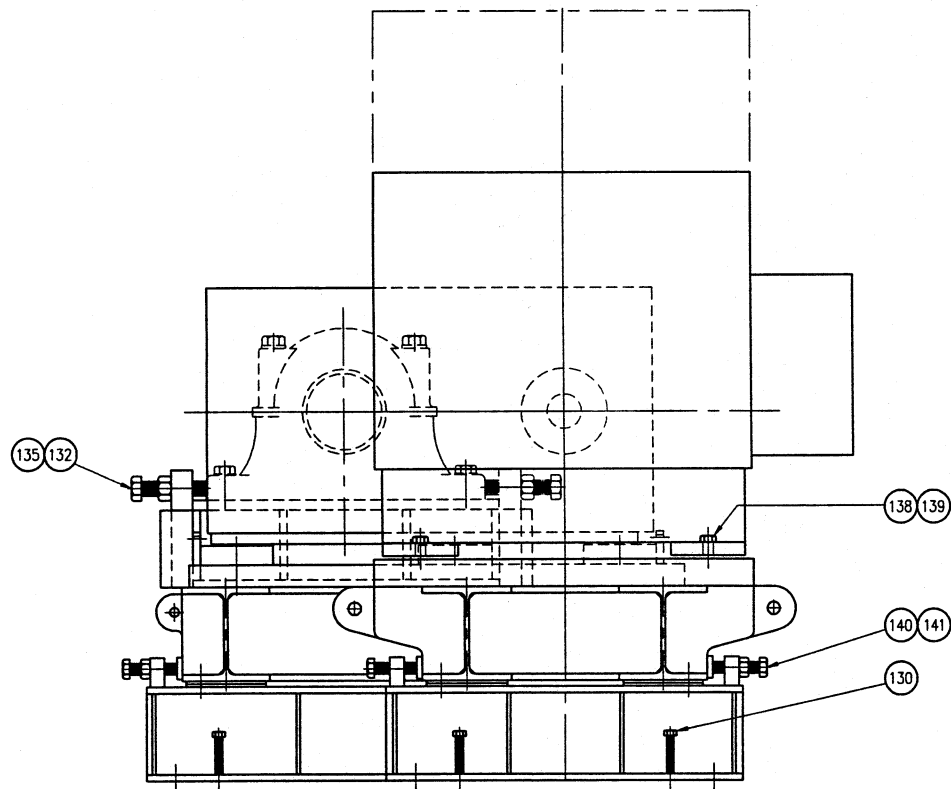
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DETAIL ITEM 26



DETAIL ITEM 6



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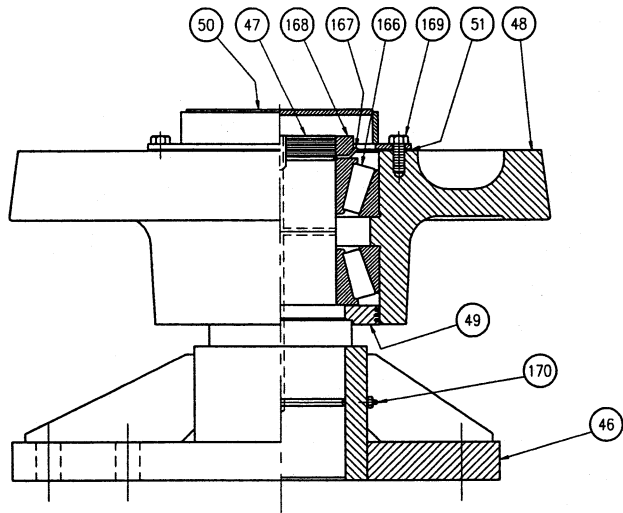
AHLSTROM ADELSTROM MACHINERY INC.
1000 CORTER
CLARK FALLS, NY 12041

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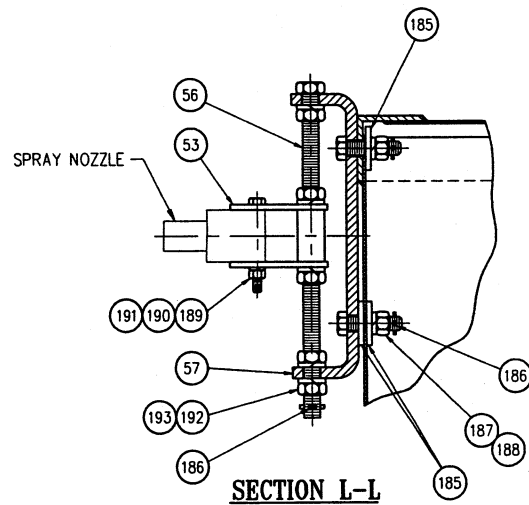
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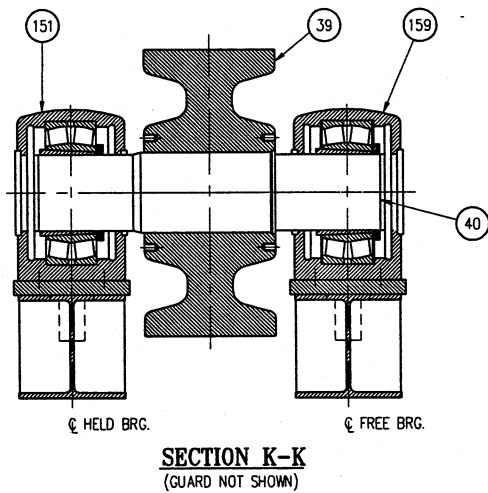
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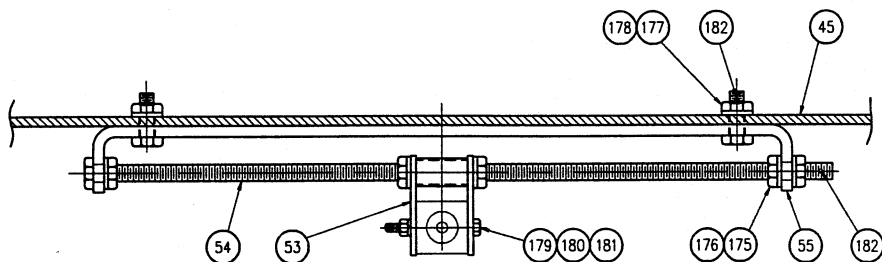
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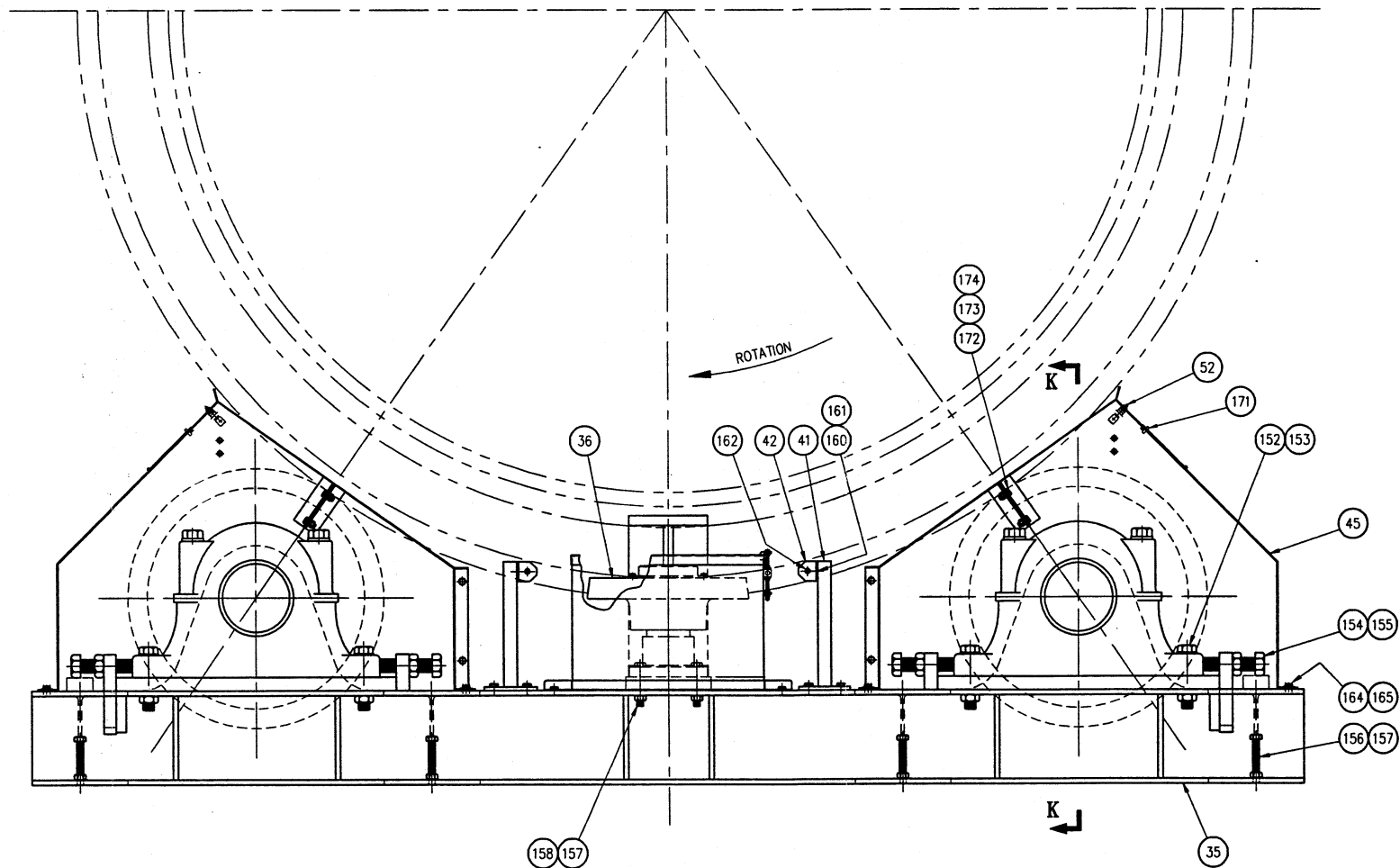
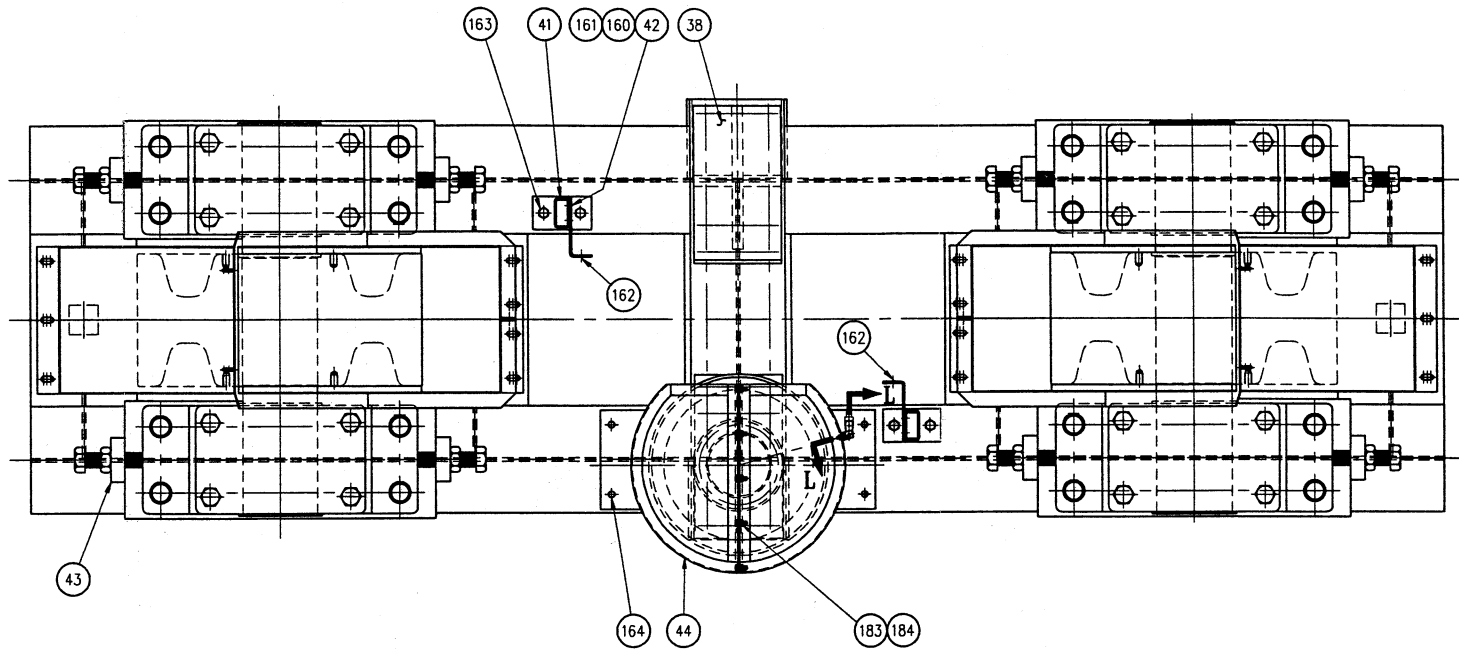
SECTION L-L



SECTION K-K
(GUARD NOT SHOWN)



DETAIL ITEM 52

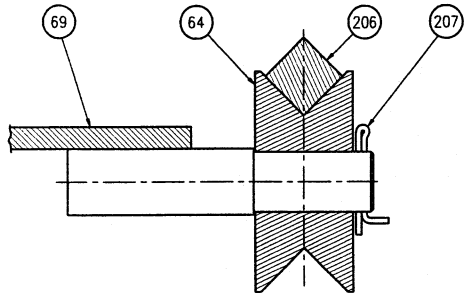


VIEW LOOKING TOWARD INLET
DETAIL ITEMS 7 & 8

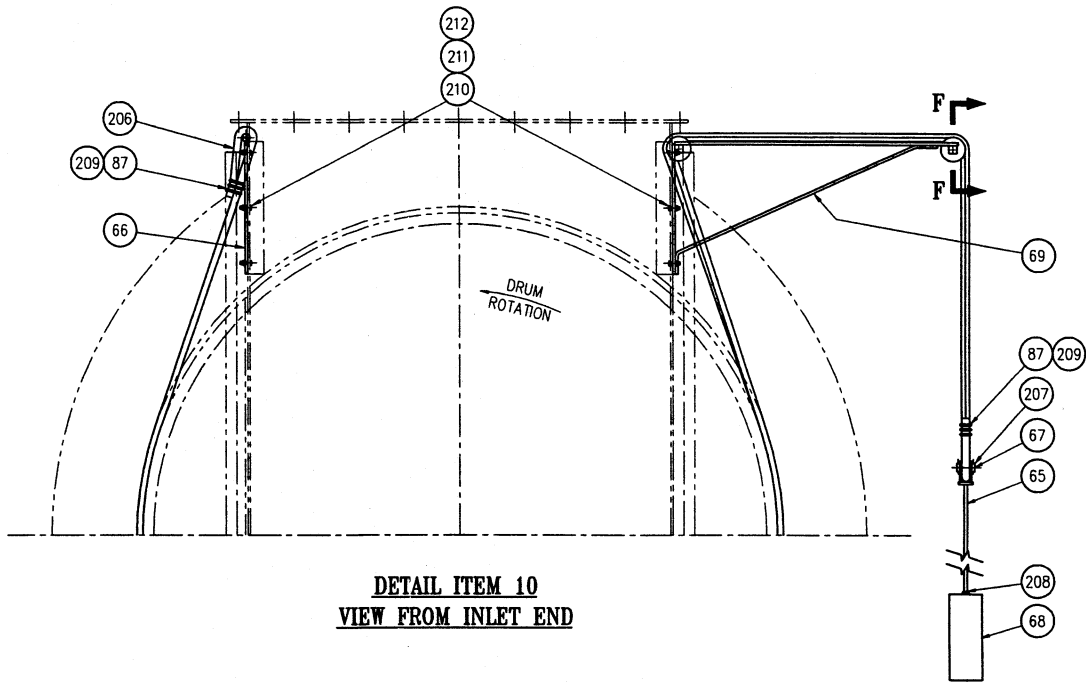
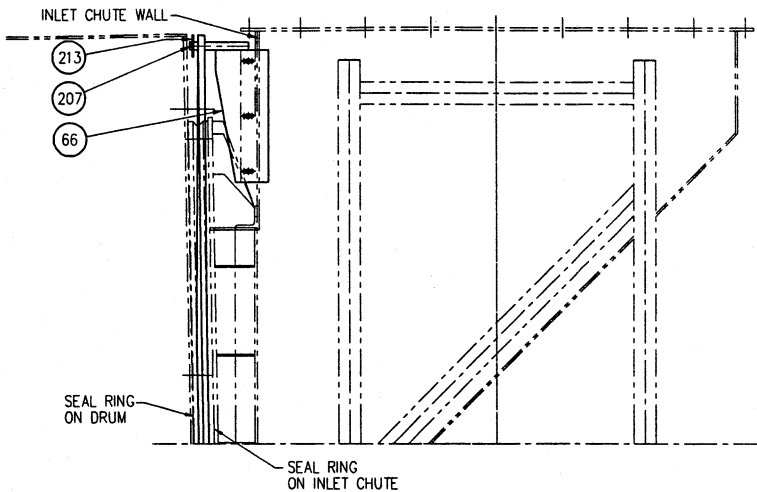
ITEM 8 IS SHOWN. ITEM 7 DOES NOT INCLUDE ITEMS 37,38,44,46,47,48,49,50,51 AND 164.
ALSO, ITEM 36 IS USED INSTEAD OF ITEM 35

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DRAWN: <u>TP</u>	SCALE: <u>NONE</u>	DATE: <u>7-11-00</u>	SHEET 4 OF 6		1-01413-51		R1
CHECKED: <u>JB</u>	FILE: <u>WHE 000/101/001-000/1000/1000/1-01413-51/5</u>						

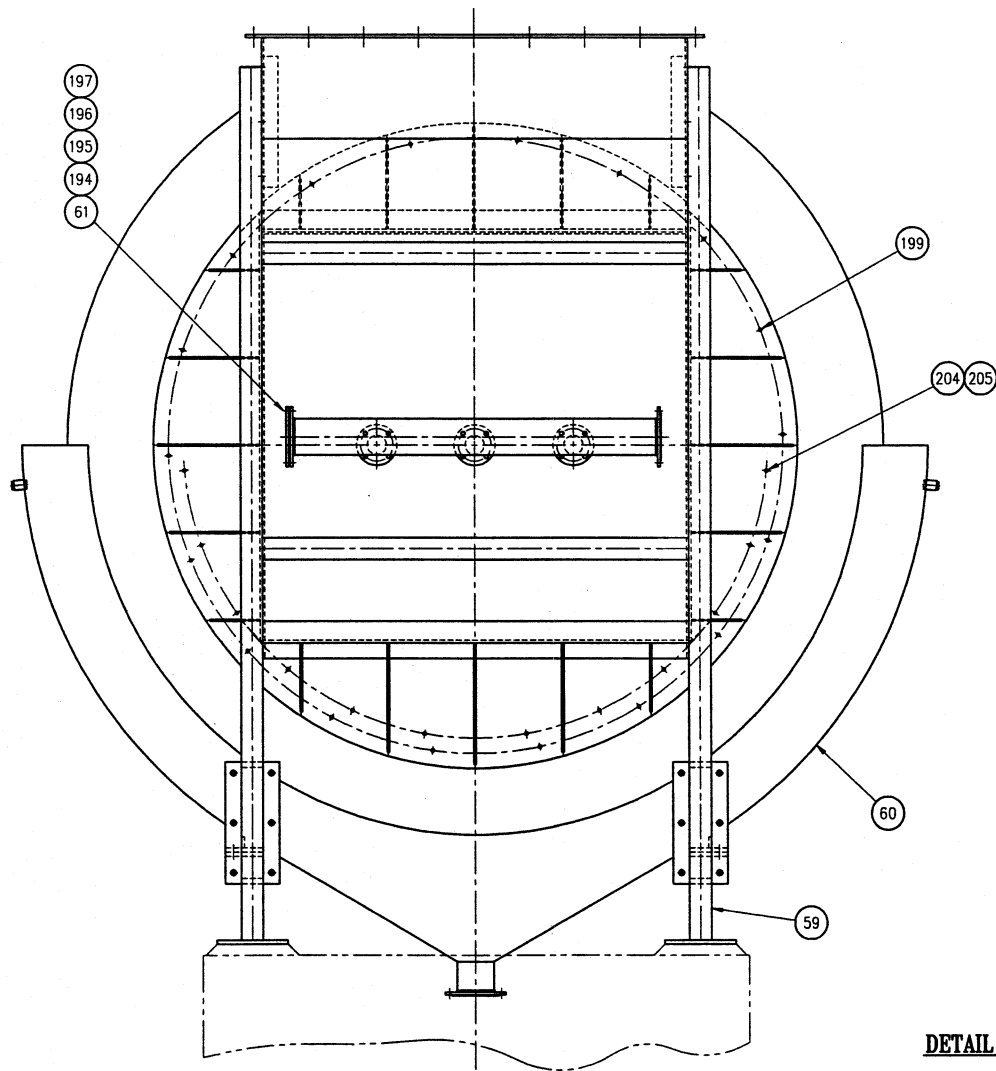
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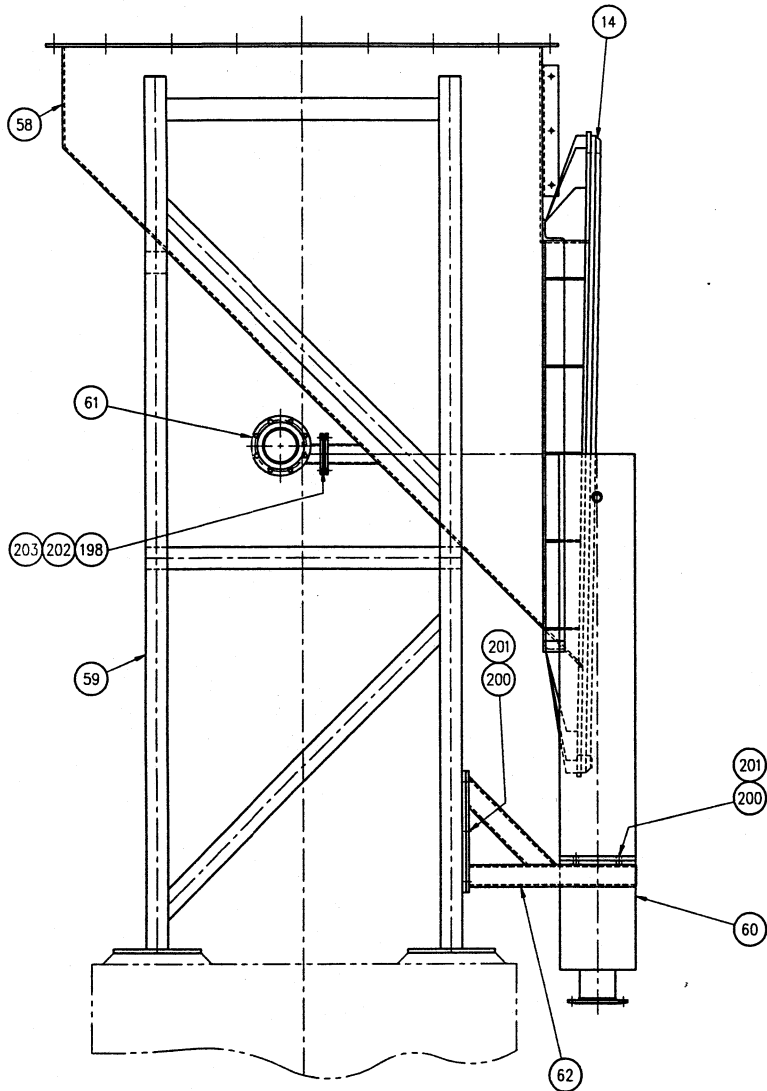
SECTION F-F



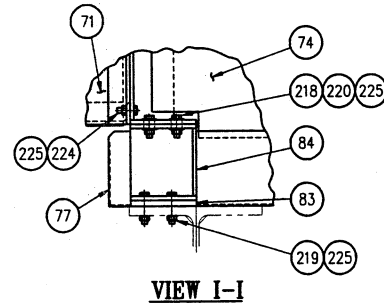
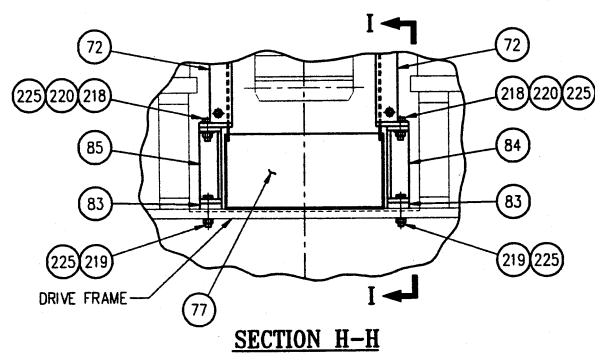
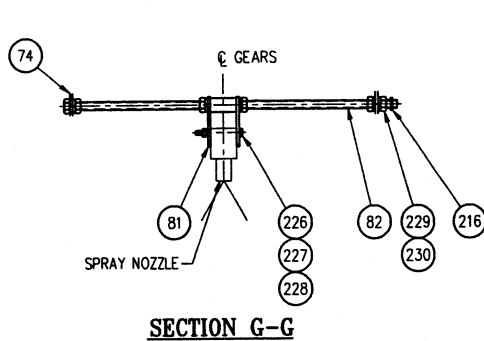
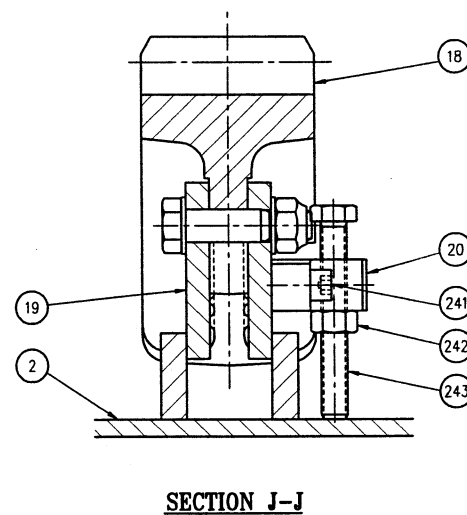
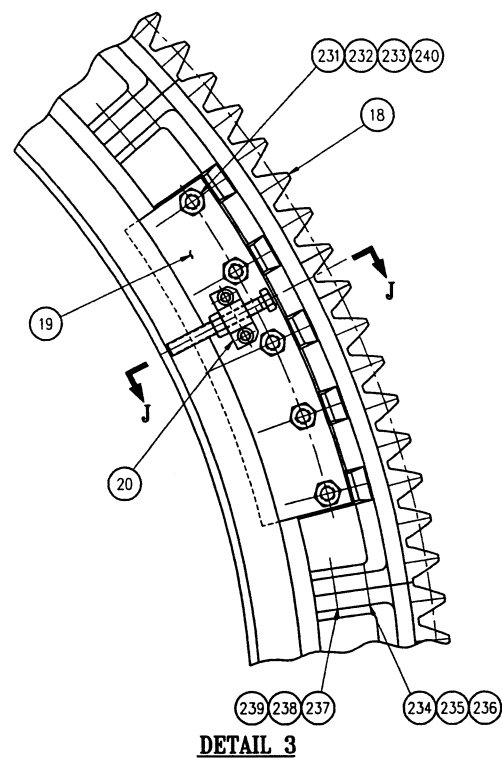
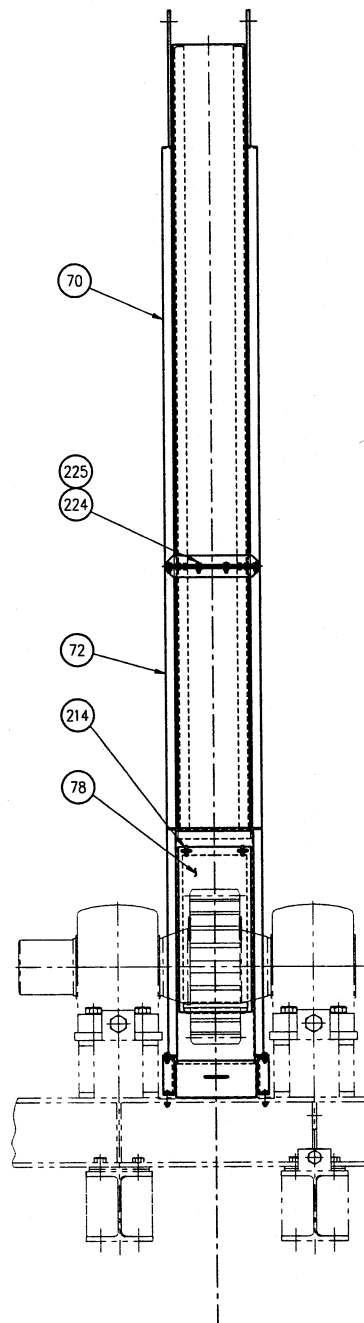
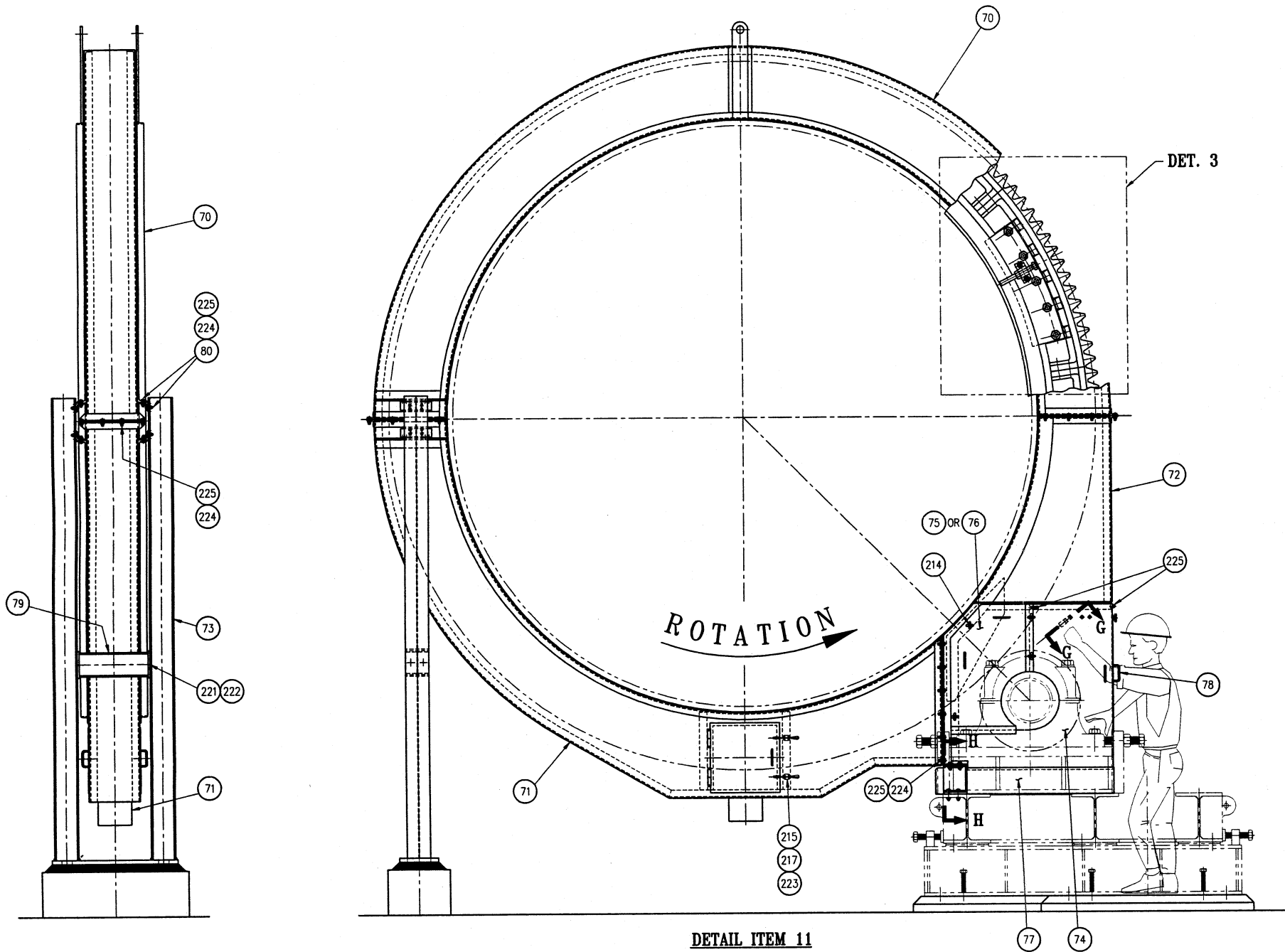
DETAIL ITEM 10
VIEW FROM INLET END



DETAIL ITEM 9

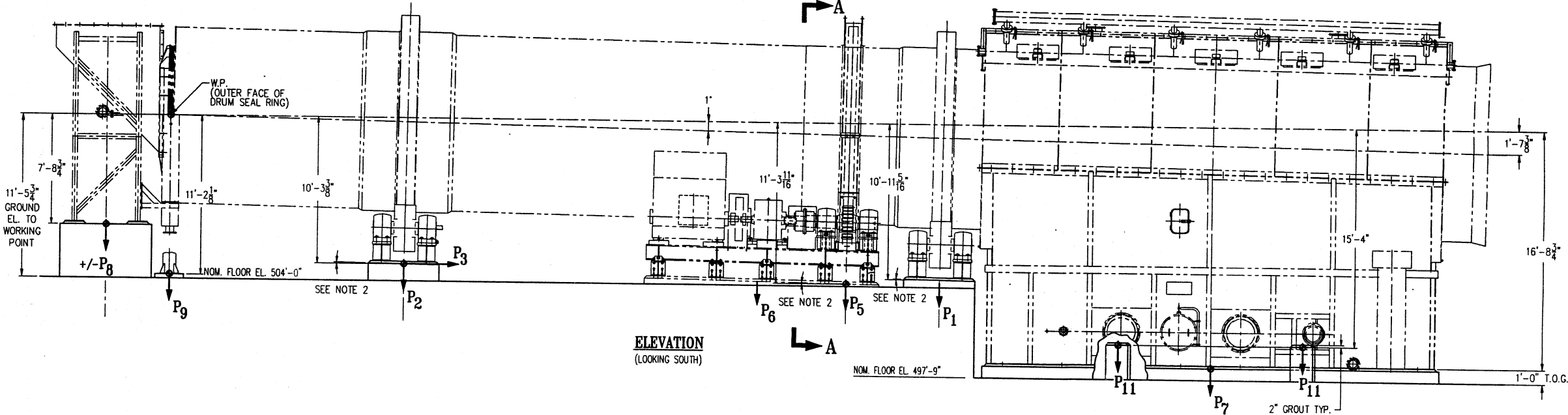
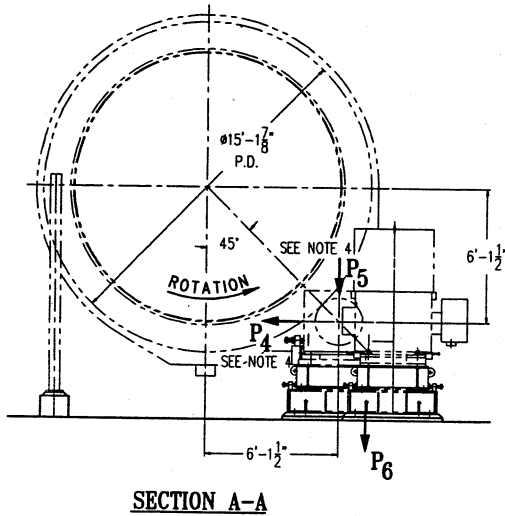
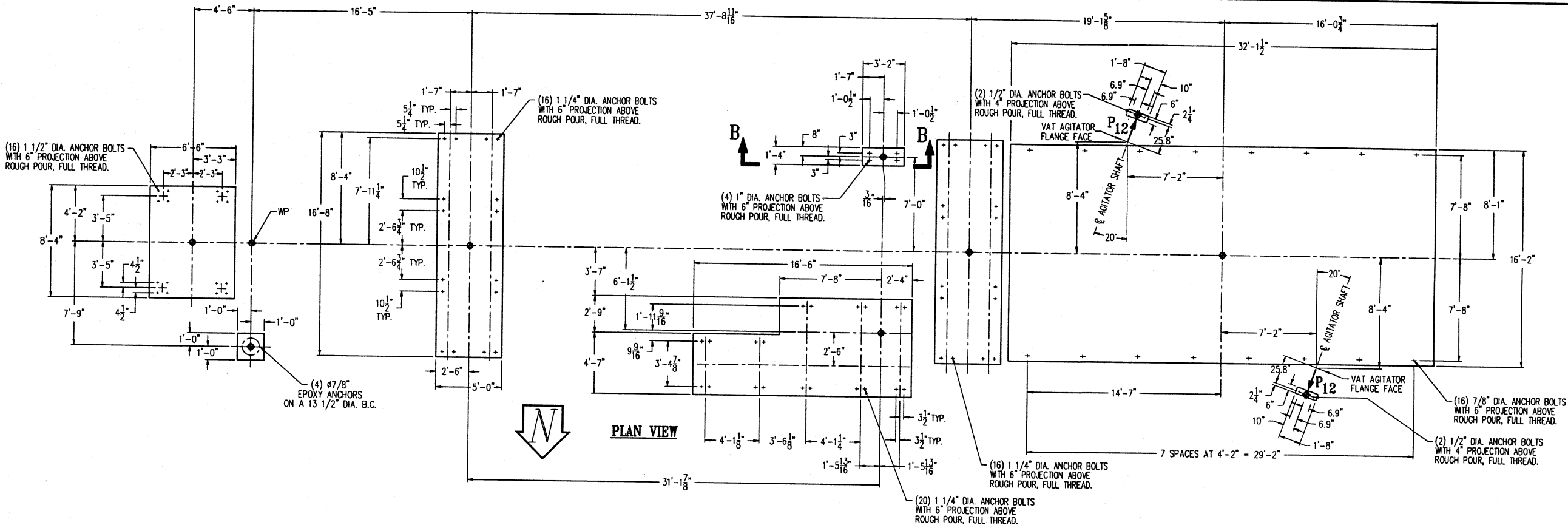


REVISIONS				
NO.	DATE	REMARKS	BY	APP.
		SEE SHEET 1		



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DRAWN	TOP	SCALE	NONE	DATE	7-11-00	SHEET 6 OF 6	
CHECKED	JL	FILE	WHS/DES/CD/DES-000/0003/0003/1-01413-5158			1-01413-51	R1

REVISIONS			
NO.	DATE	REMARKS	BY
1	3-14-00	Issued	TDP
2	4-14-00	RELOCATE DRIVE FOUNDATION RAISE GROUND ELEVATION PER CUSTOMER. UPDATE DRIVE LOADS.	EDF
3	6-16-00	DM 11-3 11/16 WAS 11'-2 1/2 TYP. EDF FINALIZE AGITATOR AND DRIVE COMPONENT FOUNDATIONS 11'-2 1/8 WAS 10'-5 1/4". 10'-6 1/8 WAS 9'-7 3/4".	EDF



NOTES:

1. PLAN VIEW DIMENSIONS ARE ON THE HORIZONTAL TO BOTTOM OF EQUIPMENT BASE WORK POINTS (WP).
2. THIS FOUNDATION IS AT A 1" SLOPE TO MATCH THE DRUM.
3. A 2" GROUT ALLOWANCE HAS BEEN ASSUMED FOR ALL FOUNDATIONS.
4. GEAR LOADS AND SEISMIC LOADS ARE SHOWN AT POINT OF APPLICATION. IT IS THE RESPONSIBILITY OF THE FOUNDATION DESIGNER TO ENSURE THAT SHEAR LOADS AND OVER TURNING MOMENTS ARE PROPERLY TRANSMITTED TO THE POINTS OF INTEREST WHEN DESIGNING FOUNDATION FEATURES. DEAD LOADS & WEIGHTS ARE SHOWN AT THE TOP OF THE ROUGH POUR.
5. PAD AND ANCHOR BOLT SIZES SHOULD BE CONSIDERED THE MINIMUM ALLOWABLE SIZE TO ACCEPT THE EQUIPMENT COMPONENTS. ACTUAL PAD SIZE & CONFIGURATION IS THE RESPONSIBILITY OF THE OWNER'S DESIGNER IN ORDER TO MEET THE GIVEN LOADS.
6. SETTLEMENT:

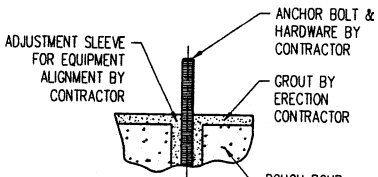
-DIFFERENTIAL SETTLEMENT BETWEEN ROLLER SUPPORT AND DRIVE PADS IS TO BE 0".

-TOTAL SETTLEMENT OF ROLLER SUPPORT AND DRIVE PADS IS NOT TO EXCEED 3/8".

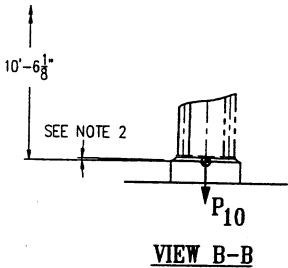
-TOTAL SETTLEMENT OF THE VAT PAD IS NOT TO EXCEED 3/8".

-DIFFERENTIAL SETTLEMENT OF INLET CHUTE PAD IS NOT TO EXCEED 1/8" FROM ROLLER SUPPORT AND DRIVE PADS.

-TOTAL SETTLEMENT OF INLET CHUTE PAD IS NOT TO EXCEED 3/8".
7. ANCHOR BOLTS SHOULD BE INSTALLED WITH ADJUSTMENT SLEEVES.



RECOMMENDED ANCHOR BOLT DETAIL
NOT TO SCALE



VIEW B-B

CERTIFIED
6-16-00

LOAD No.	WEIGHT (LBS)		DYNAMIC COEFFICIENT	TOTAL LOAD (LBS)	EQUIPMENT	DIRECTION OF LOAD
	EQUIPMENT	CONTENTS				
P1	179,525	88,385	1.5	401,865	DRUM WEIGHT	VERTICAL DOWN
P2	106,445	81,615	1.5	282,090	DRUM WEIGHT	VERTICAL DOWN
P3	27,260	-	1.5	40,890	THRUST LOAD ON AXIAL ROLLER	HORIZONTAL
P4	42,000	-	2.0	84,000	GEAR LOAD	HORIZONTAL
P5	24,250	-	2.0	48,500	GEAR LOAD	VERTICAL DOWN
P6	42,000	-	1.5	63,000	DRIVE COMPONENTS (DEAD LOAD)	VERTICAL DOWN
P7	47,930	203,685	1	251,615	VAT WEIGHT + HOOD	VERTICAL DOWN
P8	7,250	13,000	1.5	30,375	INLET CHUTE WEIGHT	VERTICAL DOWN
P9	250	-	1	250	SEAL WEIGHT GUARD	VERTICAL DOWN
P10	2,310	-	1	2,310	GIRTH GEAR GUARD	VERTICAL DOWN
P11	3,000	-	2.0	6,000	AGITATOR	VERTICAL DOWN
P12	1,500	-	2.0	3,000	AGITATOR	HORIZONTAL

Tolerance, Unless Noted Otherwise
Fractional
Under 12" ±1/16"
12" to 120" ±1/8"
over 120" ±1/4"
Angular: ±1/2°, not to exceed 1/16" per 12"

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FOUNDATION
FIBERFLOW 375
SCALE 1/4"=1'-0"
DATE 3-10-00
DRAWN TDP
CHECKED TDP

AHLSTROM MACHINERY INC
RIDGE CENTER
CLARK FALLS, NY 12801

RF068
JOB NO.



- A. SIGNAL TO START GREASE PUMP. SIGNAL IS 120 VOLTS AC TO OPEN SOLENOID VALVE.
- B. SIGNAL TO MOVE SHUTTLE VALVE FOR GREASE FLOW TO GREASE LINE #1. CUSTOMER SUPPLIES 120 VOLTS AC SIGNAL TO SOLENOID VALVE.
- C. SIGNAL TO MOVE SHUTTLE VALVE FOR GREASE FLOW TO GREASE LINE #2. CUSTOMER SUPPLIES 120 VOLTS AC SIGNAL TO SOLENOID VALVE.
- D. FEEDBACK TO INDICATE THAT GREASE HAS COMPLETED FILLING OF ALL DOSING MODULES FROM LINE #1. WHEN FILLING IS COMPLETE, PRESSURE INCREASES IN GREASE LINE #1 TO CLOSE THE PRESSURE SWITCH CONTACT. CUSTOMER TO PROVIDE 120 VOLT AC ELECTRICAL CURRENT TO THE PRESSURE SWITCH.
- E. FEEDBACK TO INDICATE THAT GREASE HAS COMPLETED FILLING OF ALL DOSING MODULES FROM LINE #2. WHEN FILLING IS COMPLETE, PRESSURE INCREASES IN GREASE LINE #2 TO CLOSE THE PRESSURE SWITCH CONTACT. CUSTOMER TO PROVIDE 120 VOLT AC ELECTRICAL CURRENT TO THE PRESSURE SWITCH.
- F. FEED BACK TO INDICATE WHEN GREASE BARREL IS EMPTY. CUSTOMER TO PROVIDE 120 VOLT AC ELECTRICAL CURRENT TO THE SWITCH.

PROGRAM THE GREASE PUMP TO START AT THE DESIRED GREASING TIME INTERVAL. ALSO PROGRAM LENGTH OF TIME FOR PUMP TO RUN. PUMP RUN TIME IS TO BE LONG ENOUGH FOR ALL GREASE DOSING MODULES TO FILL WITH GREASE. PRESSURE SWITCH CONTACT WILL CLOSE AFTER ALL DOSING MODULES ARE FILLED WITH GREASE. IF THE PRESSURE SWITCH CONTACT DOES NOT CLOSE BEFORE THE PUMP STOPS RUNNING, A FAILURE ALARM IS TO BE INDICATED BY THE DCS.

THE SIGNALS TO THE SHUTTLE VALVE SOLENOIDS ARE TO BE ALTERNATED BETWEEN A & B EACH TIME BEFORE THE PUMP IS STARTED. THE GREASING SYSTEM IS A DUAL LINE TYPE. WHEN THE DOSING MODULE IS FILLING, THE PILOT PISTON PUSHES GREASE OUT TO THE COMPONENT TO BE GREASED. WHEN SHUTTLE VALVE ALTERNATES, THE DOSING MODULE PILOT PISTON FUNCTIONS IN REVERSE FOR NEXT PUMP RUN.

1. ALL TUBING IS TO BE CLEANED BY BLOWING CLEAN DRY AIR PRIOR TO INSTALLATION AND CAPPED THEREAFTER.
2. QUARTER INCH TUBING IS TO BE FILLED WITH GREASE BEFORE CUTTING.
3. HOSES ARE TO BE FILLED WITH GREASE BEFORE INSTALLATION.
4. TUBING IS TO BE WELL SUPPORTED AND INSTALLED CLOSE TO FRAME IN A WAY WHICH PROTECTS THE TUBING & FITTINGS AGAINST DAMAGE.
5. ALWAYS LOCATE PRESSURE SWITCH JUST BEFORE THE BASEPLATE WHICH IS FARTHEST FROM THE PUMPING CENTER.
6. MAIN HEADER SHOULD BE FLUSHED THROUGH BASEPLATES UNTIL CLEAN GREASE, FREE OF AIR IS SEEN.
7. EACH BASEPLATE (ITEMS 3,4&5) INCLUDES TWO 5/16"x1-1/2" BOLTS TO USE FOR ATTACHING THE BASEPLATE, NOT INCLUDED, BUT BOLTS MAY BE USED IN A TAPPED HOLE IF BETTER SUITED.
8. EACH DOSING MODULE (ITEMS 1&2) INCLUDES TWO BOLTS FOR MOUNTING IT TO THE BASEPLATE. THEY HAVE METRIC THREADS. ALSO INCLUDED IS ONE HEX PLUG 1/8"NPT TO BE INSTALLED IN THE UNUSED HOLE IN THE BASEPLATE.
9. ALL TUBING AND FITTINGS BY CUSTOMER.
TUBING AND FITTING MATERIAL TO BE A269-TP316
WALL THICKNESS: 1/4" - .035" WALL
1/2" - .065" WALL
1" - .092" WALL

NOTE

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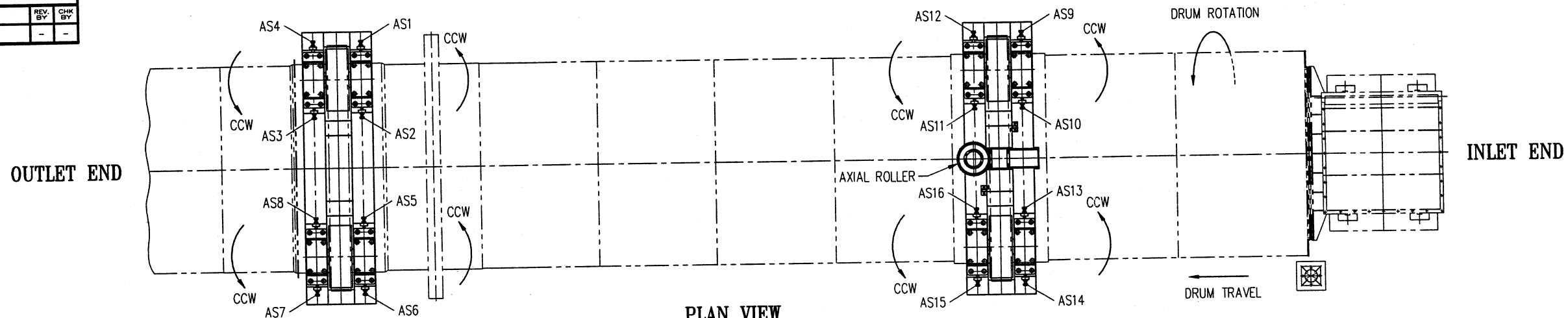
GREASE LUBRICATION SYSTEM
FIBERFLOW 375

AHLSTROM AHLSTROM MACHINERY INC
RIDGE CENTER
CLINTON, WASH. 98742

DRAWN	JN	SCALE	NONE	DATE	6/09/00
CHECKED	ENC	REF. SVG	nms ref projects \rf068\enwin 1-09-3		

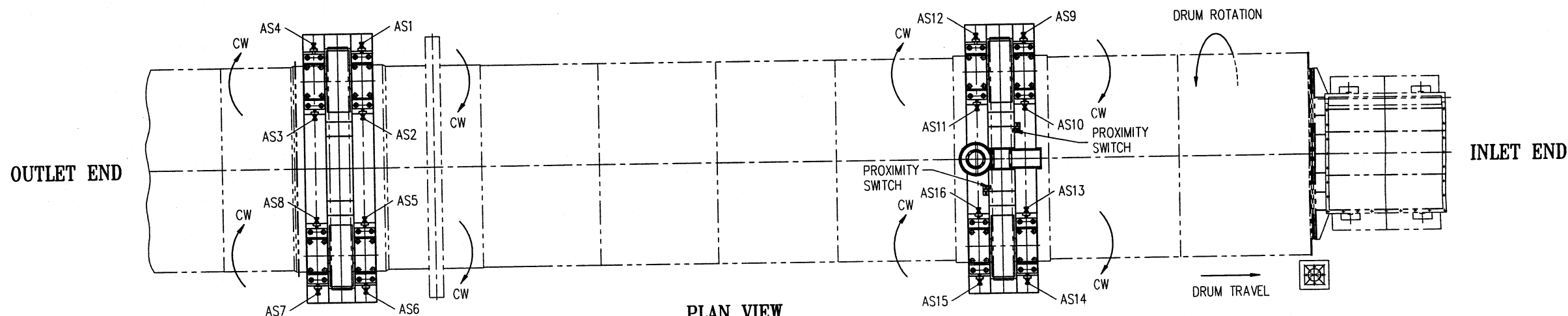
1-RF068-09-3 R1

REVISIONS				
REV. NO.	DATE	REMARKS	REV. BY	CHK. BY
1	5-8-00	ISSUED	-	-



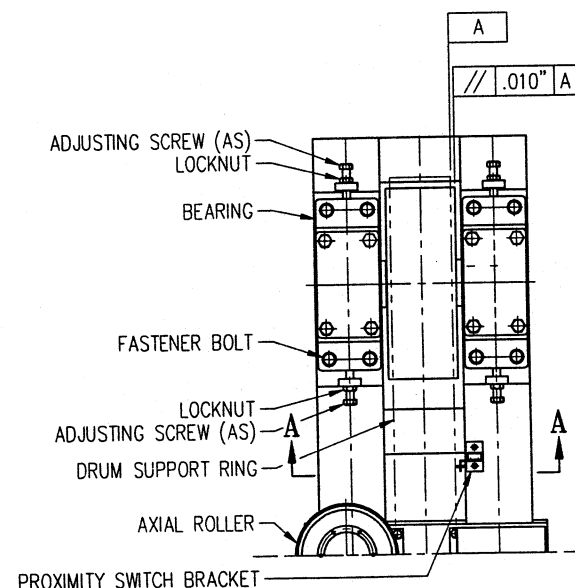
PLAN VIEW DOWN HILL TRACKING PROCEDURE

- LOOSEN ALL FASTENER BOLTS
- LOOSEN ALL LOCKNUTS
- LOOSEN ODD NUMBERED ADJUSTING SCREWS 1/4 TURN
- TIGHTEN EVEN NUMBERED ADJUSTING SCREWS 1/4 TURN
- TIGHTEN ALL LOCKNUTS
- TIGHTEN ALL FASTENER BOLTS

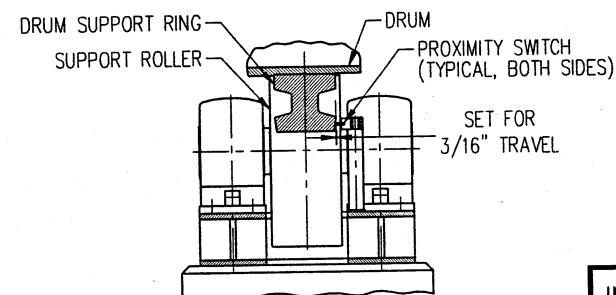


PLAN VIEW UP HILL TRACKING PROCEDURE

- LOOSEN ALL FASTENER BOLTS
- LOOSEN ALL LOCKNUTS
- LOOSEN EVEN NUMBERED ADJUSTING SCREWS 1/4 TURN
- TIGHTEN ODD NUMBERED ADJUSTING SCREWS 1/4 TURN
- TIGHTEN ALL LOCKNUTS
- TIGHTEN ALL FASTENER BOLTS



**TYPICAL
BEARING SET-UP**



SECTION A-A

IMPORTANT !!!
IF DRUM ROTATION IS
OPPOSITE HAND,
REVERSE PROCEDURES.

CAUTION !!!
STOP DRUM BEFORE
PERFORMING ADJUSTMENTS

INITIAL SET-UP

- ADJUST ALIGNMENT OF SUPPORT ROLLERS TO DRUM SUPPORT RING ACCORDING TO TOLERANCE SHOWN IN TYPICAL BEARING SET-UP.
- DRUM WILL TRACK DOWN HILL, DUE TO 1" SLOPE.
- IF AXIAL ROLLER TEMPERATURE EXCEEDS 170°F, ADJUST ROLLERS USING UP HILL TRACKING PROCEDURE.
- IF DRUM TRACKS UPHILL AND TRIPS THE PROXIMITY SWITCH, ADJUST THE ROLLERS USING THE DOWN HILL TRACKING PROCEDURE.

Tolerance, Unless Noted Otherwise
Fractional Decimal
under 12" $\pm 1/16"$ 2 places x.xx $\pm .05"$
12" to 120" $\pm 1/8"$ 3 places x.xxx $\pm .010"$
over 120" $\pm 1/4"$
Angular: $\pm 1/2'$, not to exceed $1/16"$ per 12"

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COUNTER-CLOCKWISE ROTATING DRUM
TRAVEL ADJUSTMENT INSTRUCTIONS
FIBREFLOW DRUM

DRAWN: TOP SCALE: NONE DATE: 5-8-00
CHECKED: EDE FILE NAME: PMS/RCF/PROJ-DWG/MECH/2-26009/2-26009-04

AHLSTROM AHLSTROM MACHINERY INC
RIDGE CENTER
GLENS FALLS, NY 12801

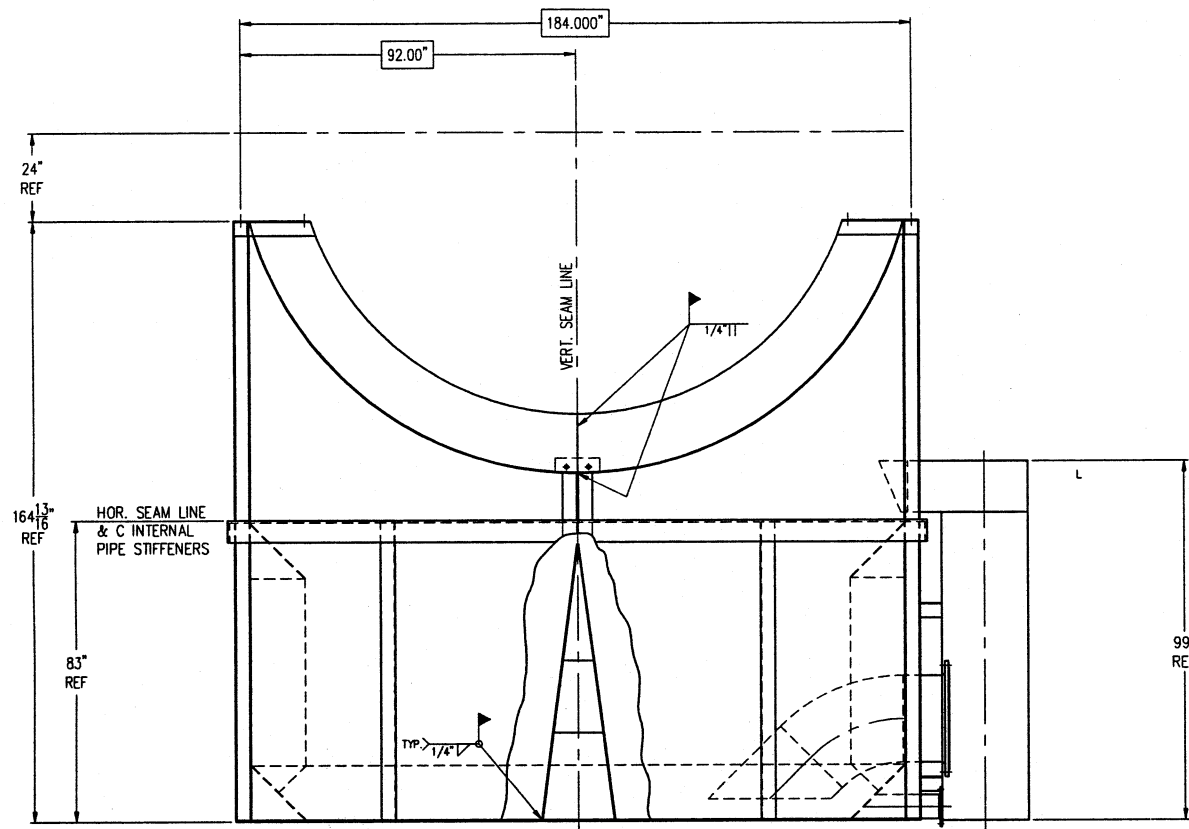
2-26009-04 R1

JOB NO.

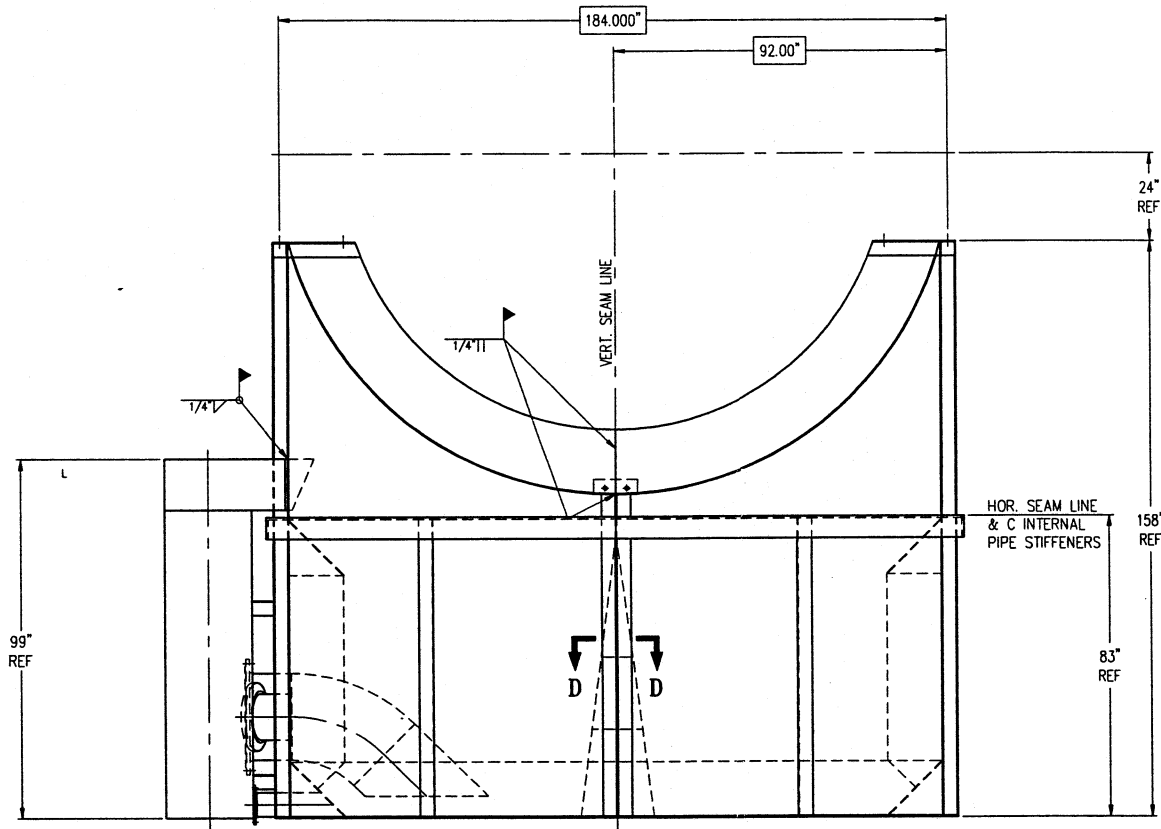
RF068
JOB NO.

Tolerance, Unless Noted Otherwise		NOTE		BOTTOM VAT		 AHLSTROM AHLSTROM MACHINERY INC. 8000 CENTER GLENDALE, ILL 60040	
Fractional	Decimal	THIS DRAWING IS THE PROPERTY OF AHLSTROM. NEITHER THIS DRAWING OR ANY DATA OR INFORMATION THEREIN SHALL BE COPIED OR REPRODUCED IN ANY MANNER, LOANED OR OTHERWISE DISPOSED OF, OR USED FOR ANY PURPOSE, WHATSOEVER WITHOUT THE PRIOR WRITTEN PERMISSION OF AHLSTROM. IF ANY OF THIS DRAWING IS LOANED BY OR WITH AUTHORITY OF AHLSTROM, THE BORROWER, IN CONSIDERATION OF SUCH LOAN, AGREES TO THE FOLLOWING CONDITIONS AND TO RETURN THIS DRAWING UPON REQUEST.		FIBERFLOW 375			
under 1/2" ± 1/16"	2 places .xx ± .05"					SHEET 1 OF 3	
1/2" to 120" ± 1/8"	3 places .xxx ± .010"					1-26009-15	
over 120" ± 1/4"						R1	
Angular: ± 1/2', not to exceed 1/16" per 12"							
		DRAWN <u>AN</u>		SCALE <u>1/2"=1'-0"</u>		DATE <u>6/17/90</u>	
		CHECKED <u>WJ</u>		FILE NAME <u>PUS 001 PROBLEM WITH 1-26009-151</u>			

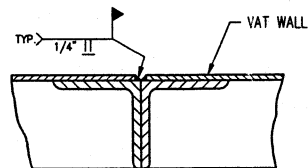
REVISIONS					
REV. NO.	DATE	REMARKS	REV. BY	CHK. BY	
		SEE SHEET 1			



INLET END



DISCHARGE END



SECTION D-D

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CONSIDERATION OF SUCH LOAN, AGREES TO THE FOREGOING CONDITIONS AND TO
RETURN THIS DRAWING UPON REQUEST.

BOTTOM VAT
FIBERFLOW 375

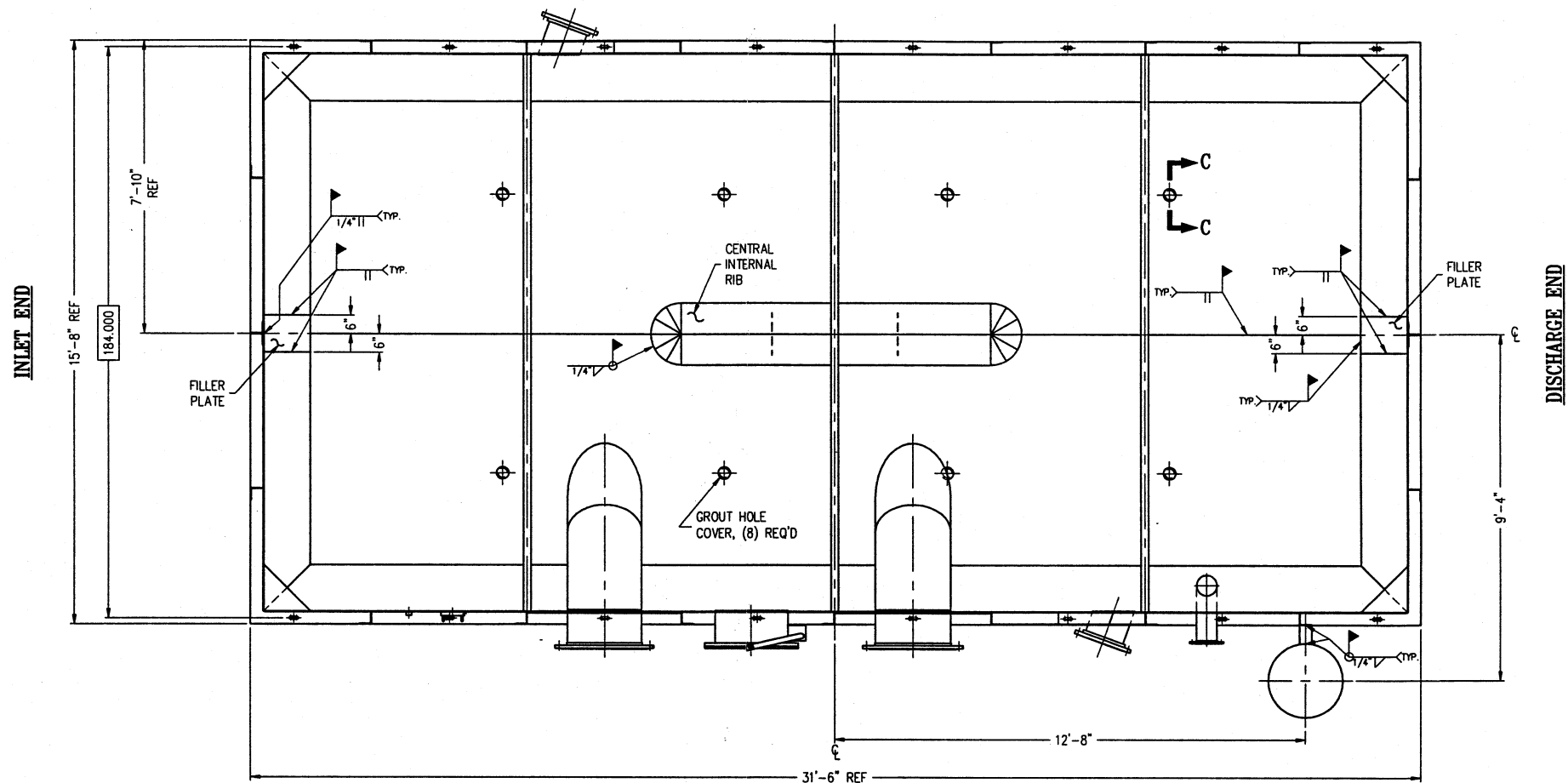
DRAWN BY SCALE 1/2"=1'-0" DATE 6/12/00
CHECKED BY FILE NAME PWS/RT/PROJ-ENG/TECH/1-2609-152

AHLSTROM AHLSTROM MACHINERY INC.
INDUS. CENTER
CLARK, ILL. 61701

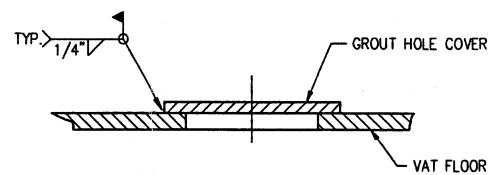
SHEET 2 OF 3
1-26009-15 R1

RF068
JOB NO.

REVISIONS				
REV. NO.	DATE	REMARKS	REV. BY	CHK. BY
1		SEE SHEET 1		



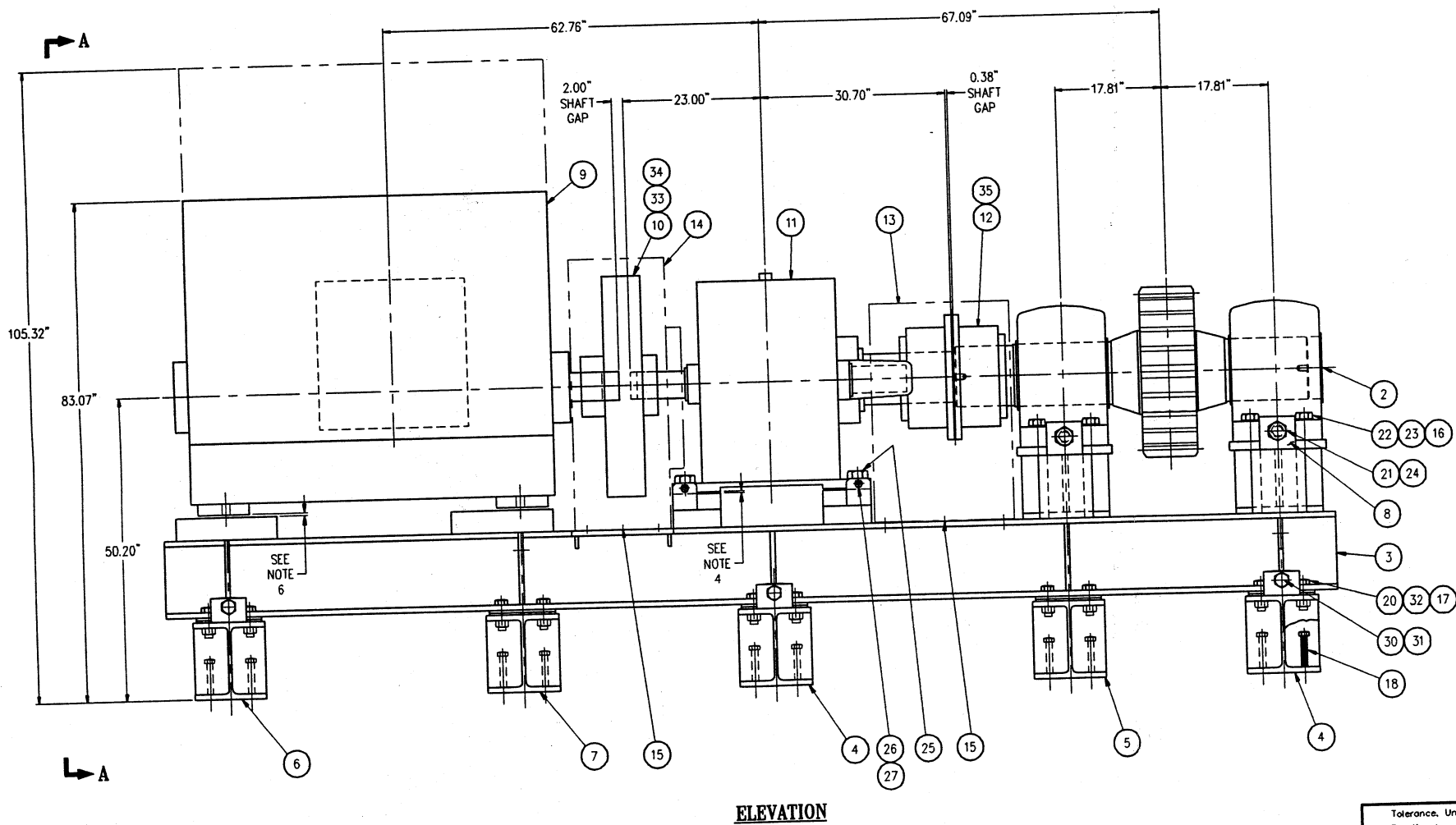
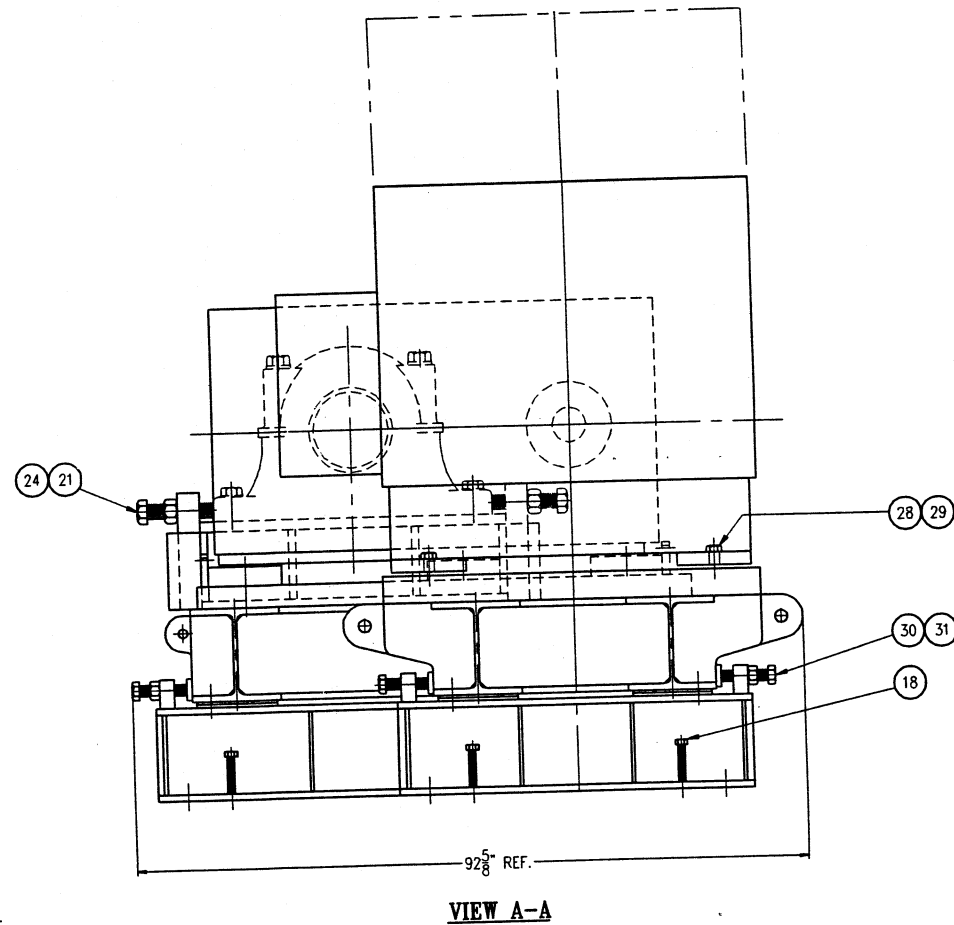
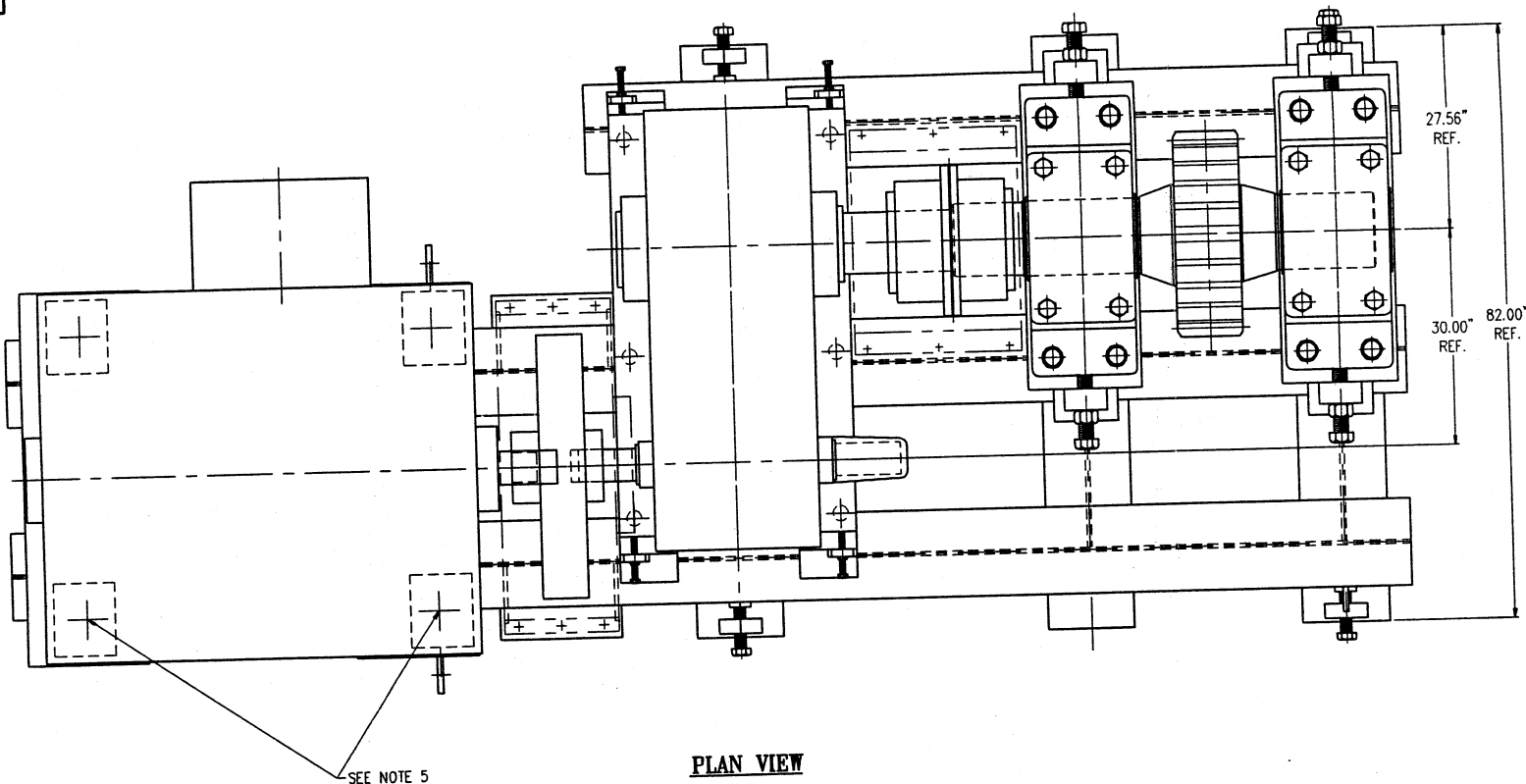
SECTION A-A



SECTION C-C

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DRAWN: N CHECKED: N	SCALE: 1/2"=1'-0" DATE: 6/12/00 FILE NO: 16/01/PRO-100/001-1000	SHEET 3 OF 3 26009-15	R1		

REVISIONS				
REV.	DATE	REMARKS	BY	CHK.
1	4-21-00	ISSUED	-	-



1	KEY	A108-1045	2" X 1 1/2" X 13"	35	
1	KEY	A108-1045	1" X 1" X 6"	34	
1	KEY	A108-1045	1" X 1" X 8"	33	
20	HEX NUT	A194-2H	1 1/4"-8 UNC	32	
6	HEX BOLT	A193-B7	1 1/2"-8 UNC X 6 1/2" LG.	31	THREAD FULL LENGTH
6	HEX NUT	A194-2H	1 1/2"-8 UNC	30	
4	HEX NUT	A194-2H	1 1/4"-8 UNC	29	
4	HEX BOLT	A193-B7	1 1/4"-8 UNC X 4 1/2" LG.	28	
				27	
4	HEX BOLT	A193-B7	3/4"-10 UNC X 6" LG.	26	THREAD FULL LENGTH
6	HEX BOLT	A193-B7	2"-8 UN X 4" LG.	25	
4	HEX BOLT	A193-B7	2"-8 UN X 9" LG.	24	THREAD FULL LENGTH
32	WASHER	F436 (THROUGH HARDENED)	1 3/4" LD., 3" O.D., 1/4" THICK	23	
8	HEX BOLT	A193-B7	1 5/8"-8UNC X 9" LG.	22	
4	HEX NUT	A194-2H	2"-8 UN	21	
20	HEX BOLT	A193-B7	1 1/4"-8UNC X 4 1/2" LG.	20	
				19	
20	HEX BOLT	A193-B7	1"-8UNC X 6" LG.	18	THREAD FULL LENGTH
20	WASHER	F436 (THROUGH HARDENED)	1 3/8" LD. X 2 1/2" O.D. X 1/4" THK.	17	
32	HEX NUT	A194-2H	1 5/8"-8 UNC	16	
12	HEX BOLT	A193-B7	1/2"-13UNC X 3/4" LG.	15	
1	COUPLING GUARD, MAGNETIC COUPLING			14	
1	COUPLING GUARD, PINION SHAFT			13	
1	COUPLING	FALK	1070G20	12	
1	REDUCER	FALK	485A2-C-19.20:1, ASSY 18	11	
1	MAGNETIC COUPLING	REXNORD	EMTO 33.0S BMC	10	
1	MOTOR	ASEA	900 HP, 1800 RPM, TYPE 500M	9	BY CUSTOMER
4	STOP BLOCK			8	
1	SUPPORT RAIL			7	
1	SUPPORT RAIL			6	
1	SUPPORT RAIL			5	
2	SUPPORT RAIL			4	
1	DRIVE SUPPORT FRAME			3	
1	DRIVE GEAR ASSEMBLY			2	
1	ASSEMBLY			1	
QTY	DESCRIPTION	MATERIAL	DIMENSIONS	ITEM	DWG. NO.

NOTES:

- ALL WELDS TO BE PER AHLSTROM WELD SPEC. WGL-004, LATEST REVISION.
- BREAK SHARP EDGES. REMOVE ALL BURRS.
- APPROXIMATE WEIGHT = 36,600 LBS.
- NOMINAL 1/4" SHIM.
- MARK AND DRILL & TAP (4) 1 1/4"-8UNC x 3" DP. MOUNTING HOLES IN FIELD AFTER ALIGNMENT.
- NOMINAL 1/2" SHIM.

Tolerance, Unless Noted Otherwise

Fractional	Decimal
under 12" $\pm 1/16"$	2 places x.xxx $\pm .05"$
12" to 120" $\pm 1/8"$	3 places x.xxx $\pm .010"$
over 120" $\pm 1/4"$	

Angular: $\pm 1/2'$, not to exceed 1/16" per 12"

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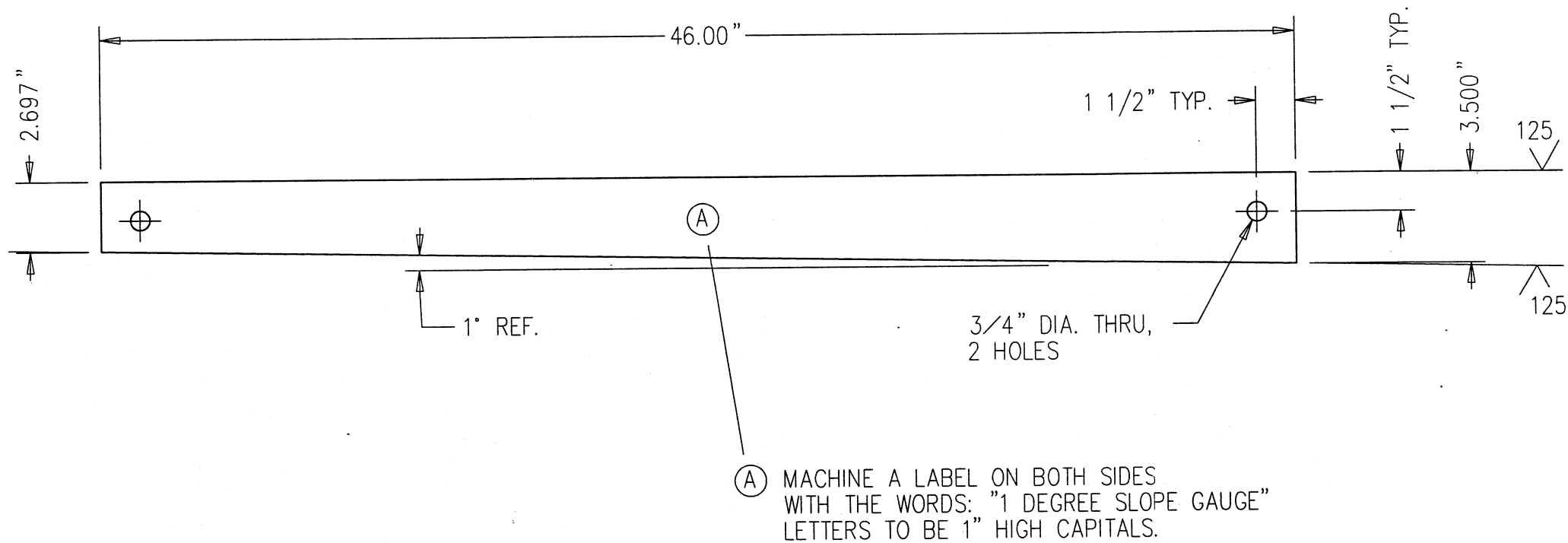
DRIVE ASSEMBLY
FIBERFLOW 375

DATE: 6-21-00
SCALE: 1"=1'-0"

AHLSTROM
AHLSTROM MACHINERY INC.
BRIDGE CENTER
CLINTON FALLS, NY 12901

1-26009-16 R1

REVISIONS				
DATE	REMARKS	REV. BY	CHK BY	
10-10-97	ISSUED			
4-3-00	ADD RF068, REVISE LABEL NOTE.	TDP	JM	



MATERIAL: A36, 1" THK.

NOTES :

- BREAK SHARP EDGES. REMOVE ALL BURRS.
- ALL SURFACES, UNLESS OTHERWISE SPECIFIED, WILL BE 500 MICROINCHES (RMS) OR FINER. A MILL FINISH IS ACCEPTABLE IF IT MEETS THE ABOVE CRITERIA.

REF. DWG: MDS.3.26012.56

RF068
RF050
RF039
JOB NO.

Tolerance, Unless Noted Otherwise		
Fractional	Decimal	
under 12" ±1/16"	2 places x.xx ±.05"	
12" to 120" ±1/8"	3 places x.xxx ±.010"	
over 120" ±1/4"		
Angular: ±1/2°, not to exceed 1/16" per 12"		

NOTE

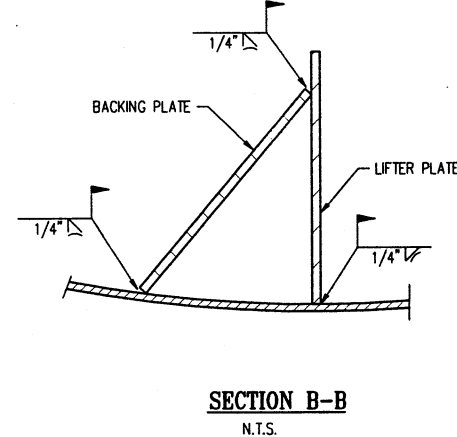
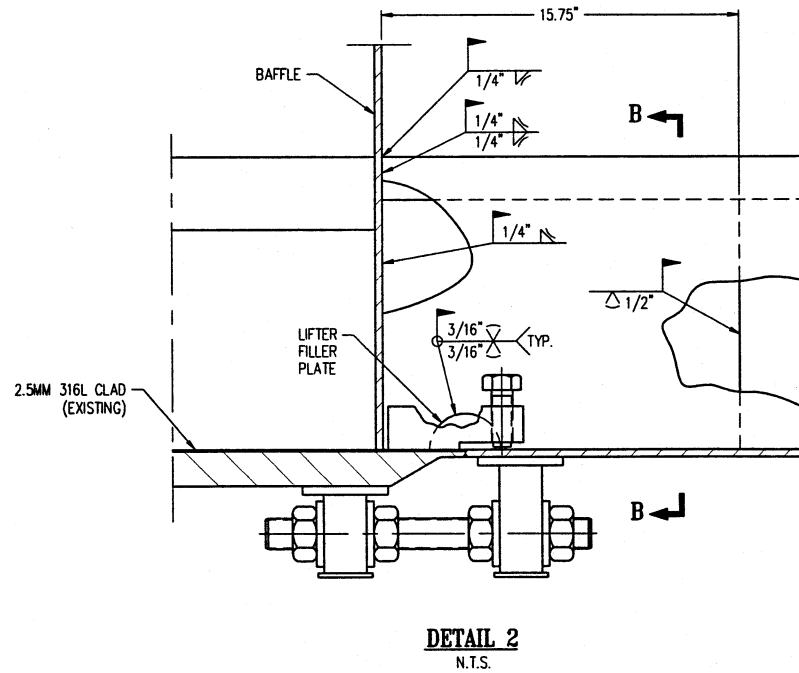
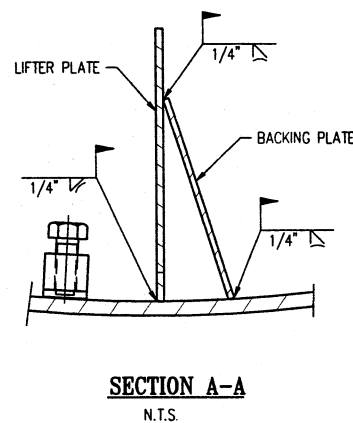
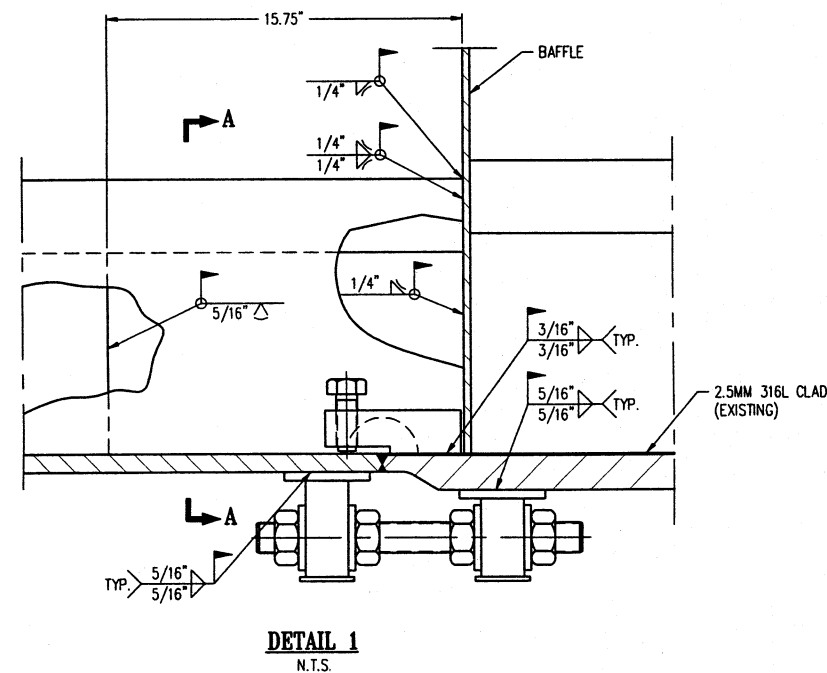
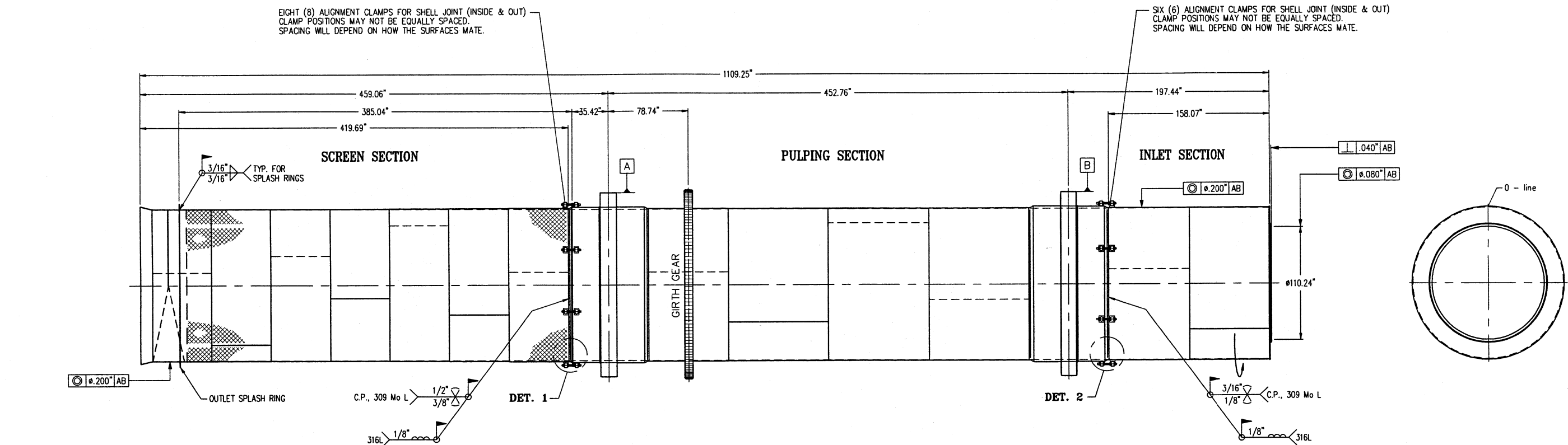
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SLOPE GAUGE FIBERFLOW DRUM		
DRAWN CUSHING	SCALE 3/16" = 1"	DATE 06-17-97
CHECKED SMS	FILE NAME pms/rcf/rf039/mech/26012/3-84	

	AHLSTROM MACHINERY INC RIDGE CENTER GLENS FALLS, NY 12801	
	3-26012-84	R3

REVISIONS				
REV	DATE	REMARKS	BY	CHK
1	7-11-00	Issued	-	-
2	8-1-00	JOINT WELD MAT'L 309 Mo L TDP EDF	-	-

WAS 309L JOINT WELD MAT'L 316L WAS INCONEL 625



NOTES:

- WELDERS AND WELD PROCEDURES TO BE QUALIFIED AND CERTIFIED TO ASME SECTION IX.
- WELD INSPECTORS TO BE QUALIFIED AND CERTIFIED TO ASNT STANDARDS.
- FINAL JOINT WELDS ARE TO BE ULTRASONIC INSPECTED.
- NO CRACKS OR LACK OF FUSION ALLOWED. ALL SLAG INCLUSIONS, GAS PORES, AND CLUSTERS TO BE LESS THAN 1/3 THE THICKNESS OF THE JOINT WELD.
- APPROXIMATE WEIGHT = 233,700 LBS.

Tolerance, Unless Noted Otherwise	
Fractional	Decimal
under 12" $\pm 1/16"$	2 places x.xx $\pm 0.05"$
12" to 120" $\pm 1/8"$	3 places x.xxx $\pm 0.010"$
over 120" $\pm 1/4"$	
Angular: $\pm 1/2^\circ$; not to exceed 1/16" per 12"	

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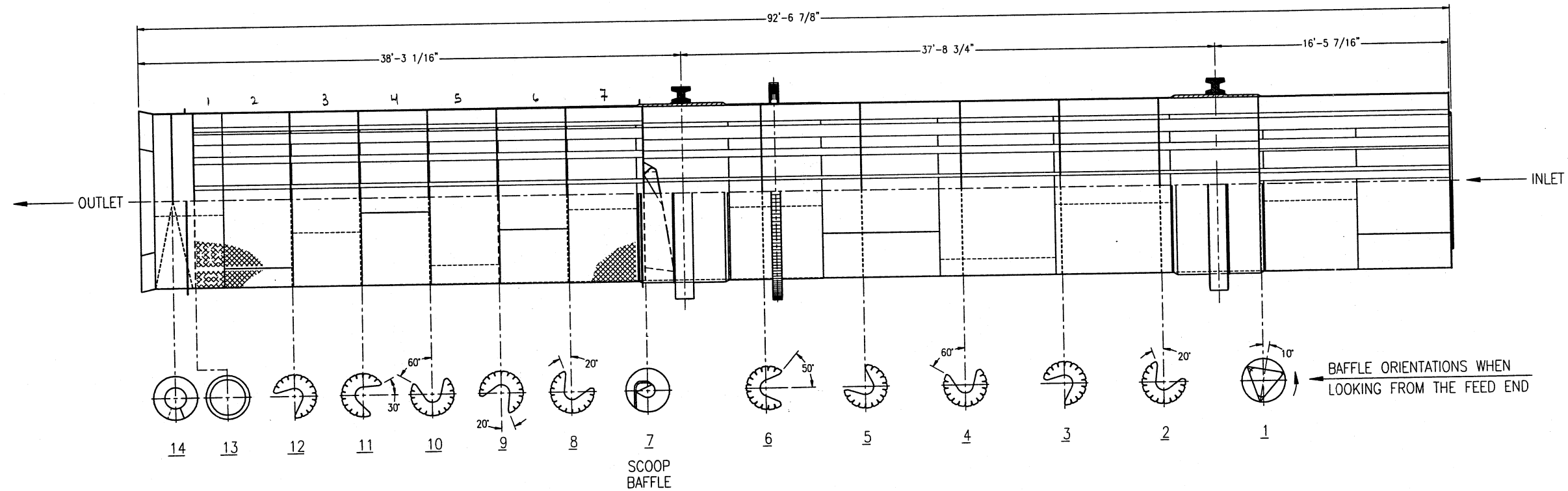
DRUM JOINT FIBERFLOW 375		
DRAWN TDP	SCALE 1/4"=1'-0"	DATE 7-11-00
CHECKED HTP	FILE NO. 166/837/PROJ-100/1668/FOUR/11-08-1	

AHLSTROM	
AHLSTROM MACHINERY INC.	BRIDGE CENTER
CLARK FALLS, VT 02801	

1-RF068-09-4

R2

REVISIONS				
REV.	DATE	REMARKS	BY	CHK
1	6-21-00	ISSUED	-	-



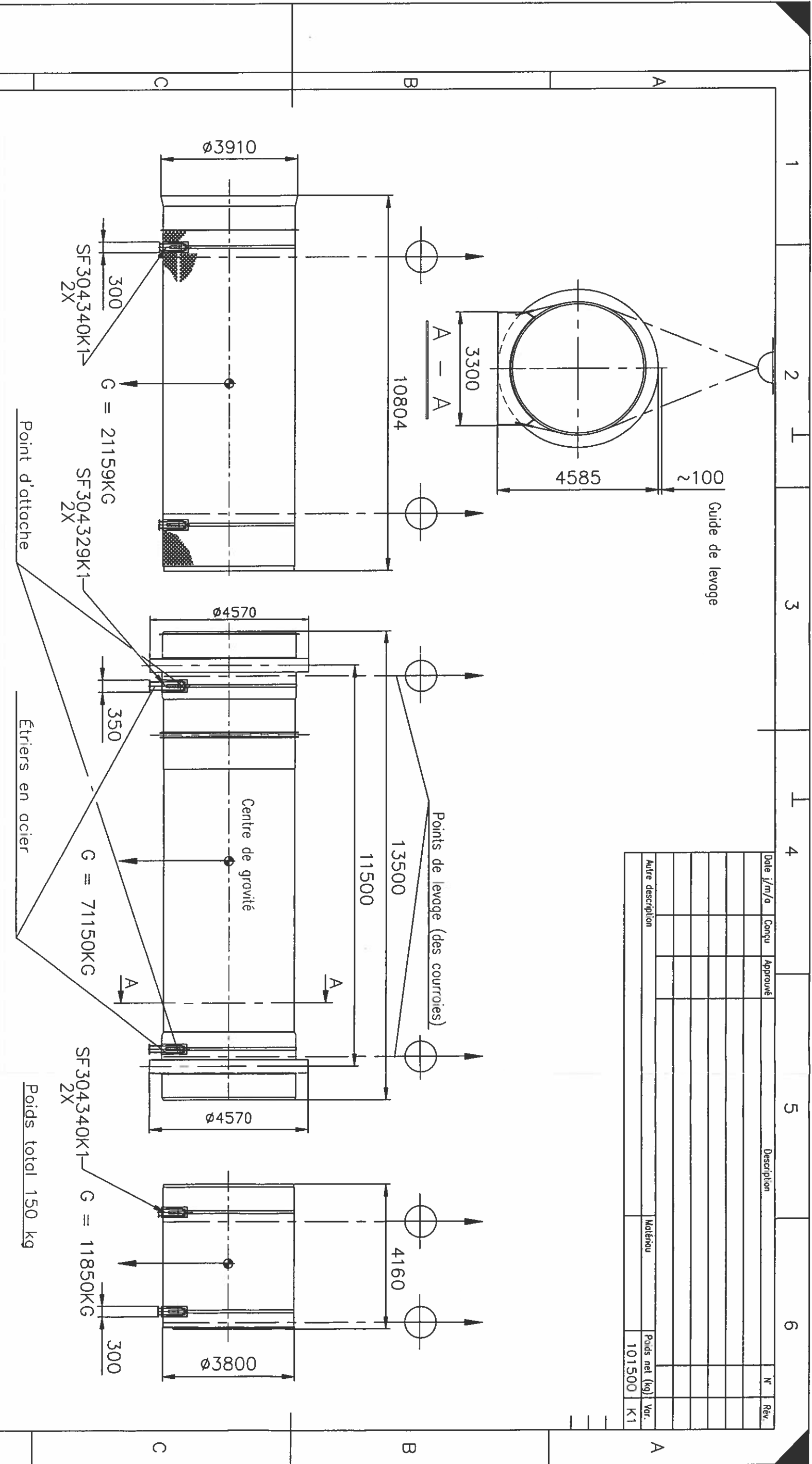
Tolerance, Unless Noted Otherwise	
Fractional	Decimal
under 12" $\pm 1/16"$	2 places x.xx $\pm .05"$
12" to 120" $\pm 1/8"$	3 places x.xxx $\pm .010"$
over 120" $\pm 1/4"$	
Angular: $\pm 1/2^\circ$; not to exceed $1/16"$ per 12"	

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FIBERFLOW DRUM BAFFLE ORIENTATION FIBERFLOW 375			
DRAWN	TP	SCALE	1/4"=1'-0"
CHECKED		DATE	6-21-00
		FILE NAME	ahs\vol\vol-dm\mch11-26009-17

AHLSTROM	
AHLSTROM MACHINERY INC.	BRIDGE CENTER
GLENS FALLS, NY 12081	
1-26009-17	R1

Date j/m/a		Conçu	Approuvé	Description		N°	Rév.
Autre description				Matériau	Poids net (kg)	Var.	
					101500	K1	



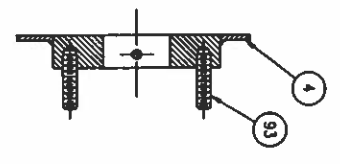
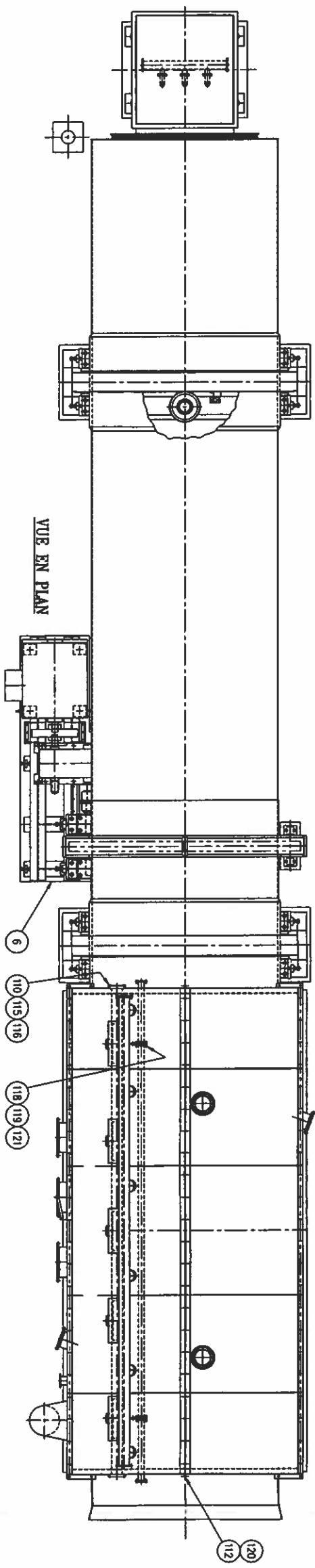
Rugosité de surface		ISO 1302-Ro	Tolérances géométriques :		EN 33920-BF	Tolérances géométriques :		ISO 8062 CT10
Symboles de soudage		ISO 2553	- Constr. soudée		ISO 2768-mK	- Moulages		SFS 3507
Tolérancement		ISO 8015	- Usinage		SFS 4072-B	- Pièces forgées		< DIN 7527
Tolérances géom.		ISO 1101	- Coupage aux gaz		DIN 2510-B			
Mesure		normale						
Tolérances		général						
Constr. soudée		EN 33920-1	Classe de précision		B			
Usinage		ISO 2768-1	Classe de tolérance		m			
					± 0.1			
					± 0.2			
					± 0.3			
					± 0.5			
					± 0.8			
					± 1.2			
					± 2			
					± 3			
					± 4			
					± 5			
					± 6			
					-			

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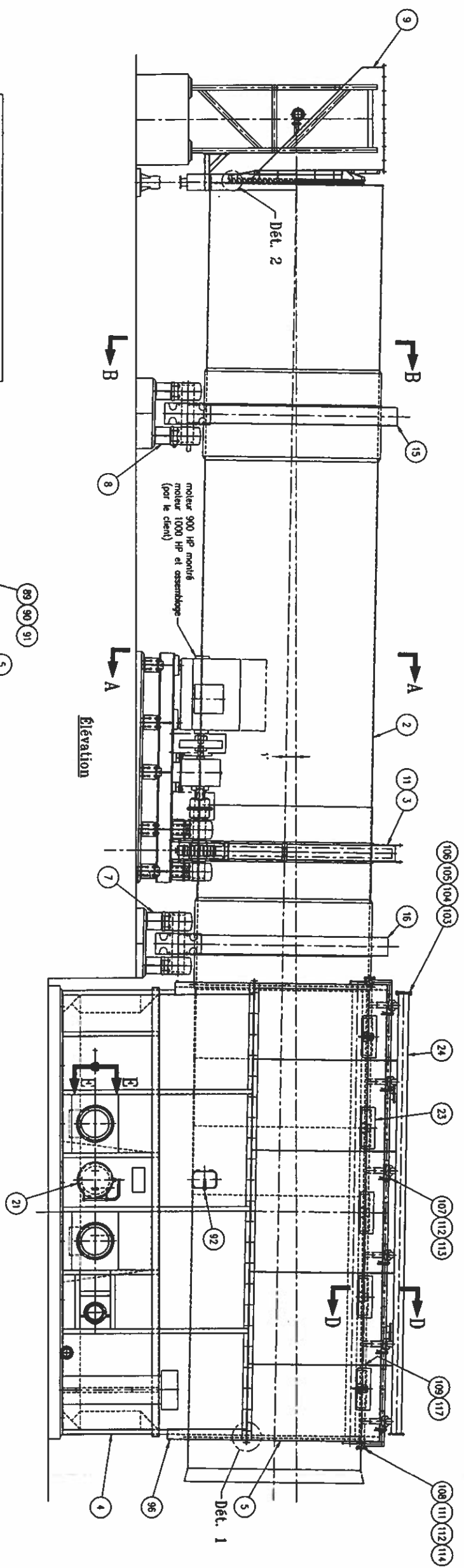


PMA Systems
Sovonlinna Finlande

FF Rujpu nosto		FF Levage du tambour	
FibreFlow FF375			
Conçu	Date j/m/a	Sch. réf. préc.	Poids kg/lb
VILK	29.02.2000	SF305265	12101
Échelle	1:100	Projet n°	48
Approuvé		Système n°	Réf.
		SF310168	



SECTION E-E



Jouge de pente 1°
1° REF.
Art. 13

