





**GENERAL INSTRUCTION MANUAL
FOR
NEKOOSA PAPERS
ASHDOWN, ARKANSAS**

ROLL GRINDER S/N R89-6037

VOITH

01.01

MACHINE DESCRIPTION

The Voith Two-Wheel Roll Grinder is built to perform cylindrical grinding on long paper machine rolls and other types of rolls to precise finish and shape requirements.

Voith Two-Wheel Roll Grinders have the following components: bed, carriage, swing rest, grinding wheel supports, tilt infeed devices, roll supports, headstock, and traverse drive. These are described in the succeeding sections.

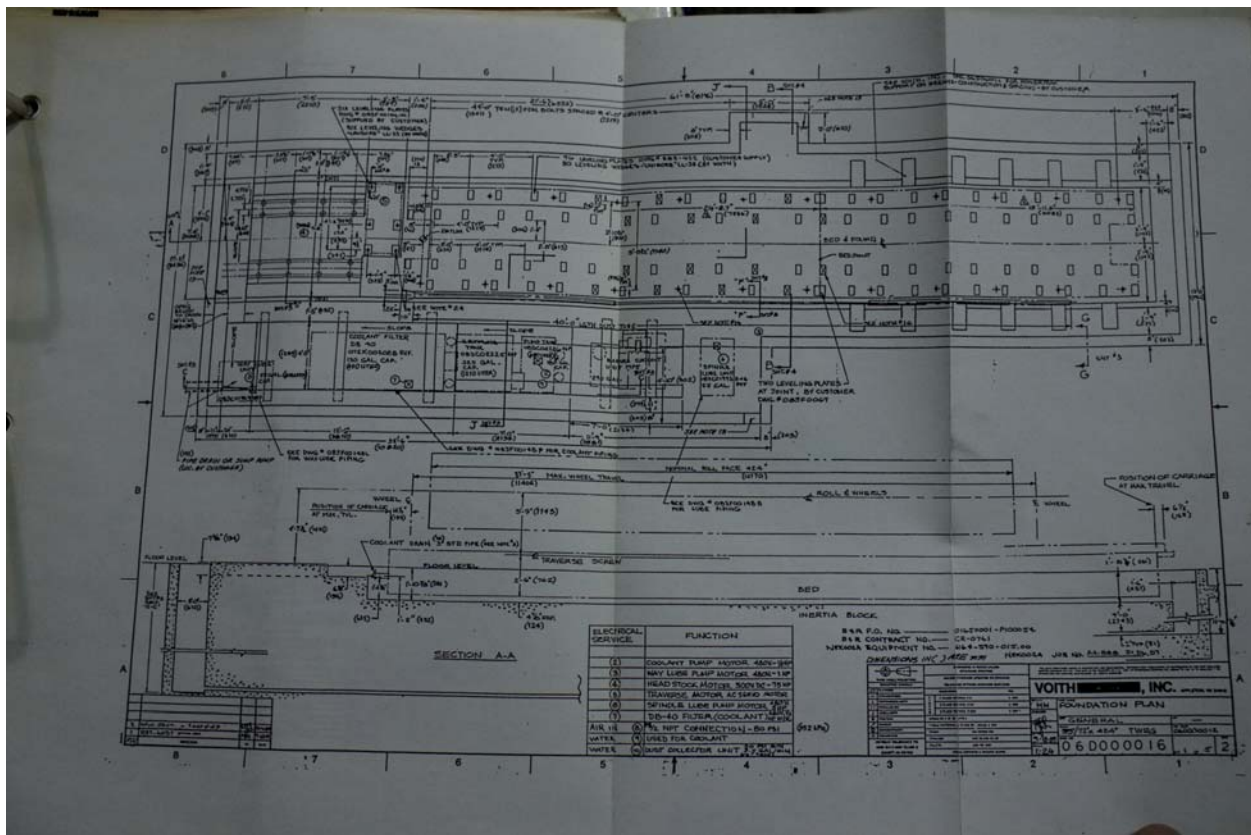
There are additional options available for particular services. The descriptions of the options furnished with this machine are included at the end of this section.

BEDS

The grinder bed is an iron casting, formed with deep box sections, and ribbed for strength and rigidity.

The bed supports the carriage, swing rest, grinding wheel, work piece and some electrical control equipment.

A drainage trough is cast integral with the bed and is sloped for drainage of the coolant toward the headstock.



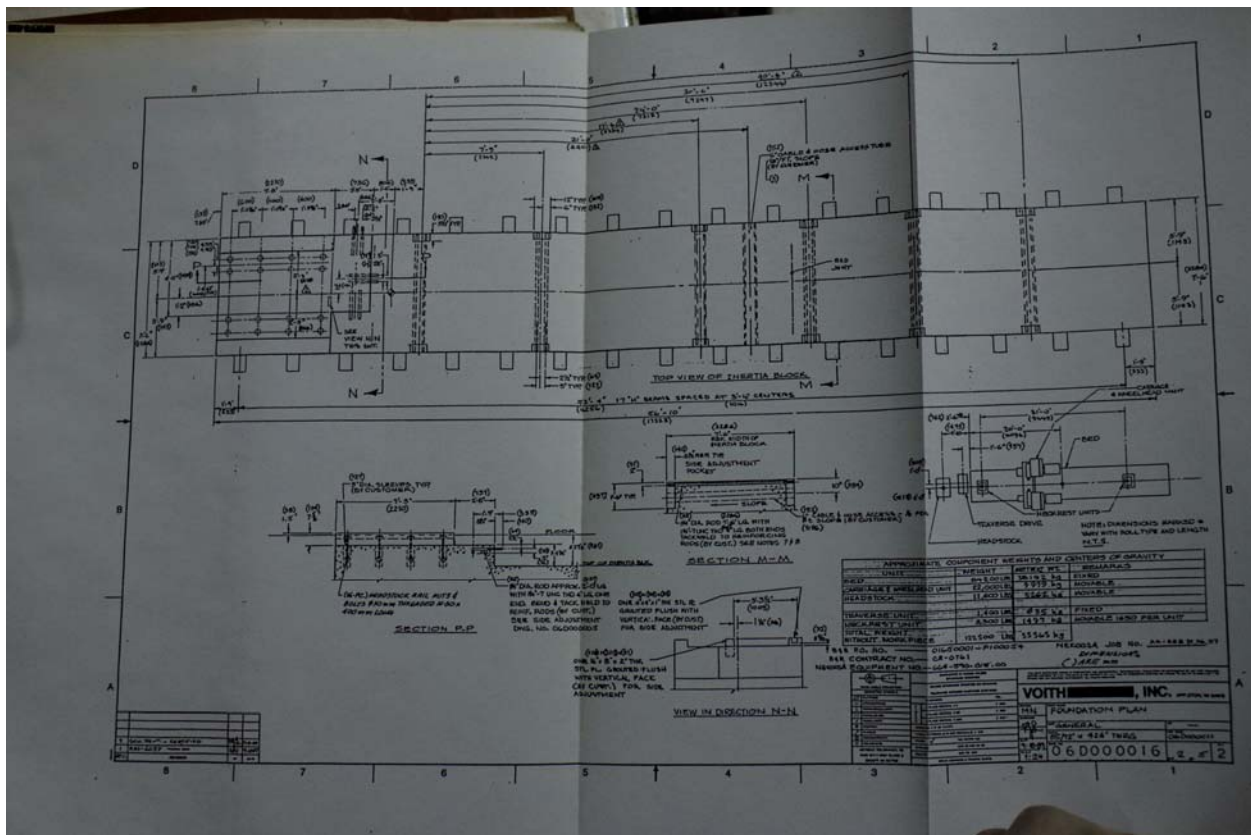
ELECTRICAL SERVICE	FUNCTION
(1)	COOLANT PUMP MOTOR 480V-3PH
(2)	500 GPM PUMP MOTOR 480V-3PH
(3)	HEAD STOCK MOTOR 300V-3PH
(4)	TECHNOLOGICAL MOTOR 480V-3PH
(5)	500 GPM PUMP MOTOR 480V-3PH
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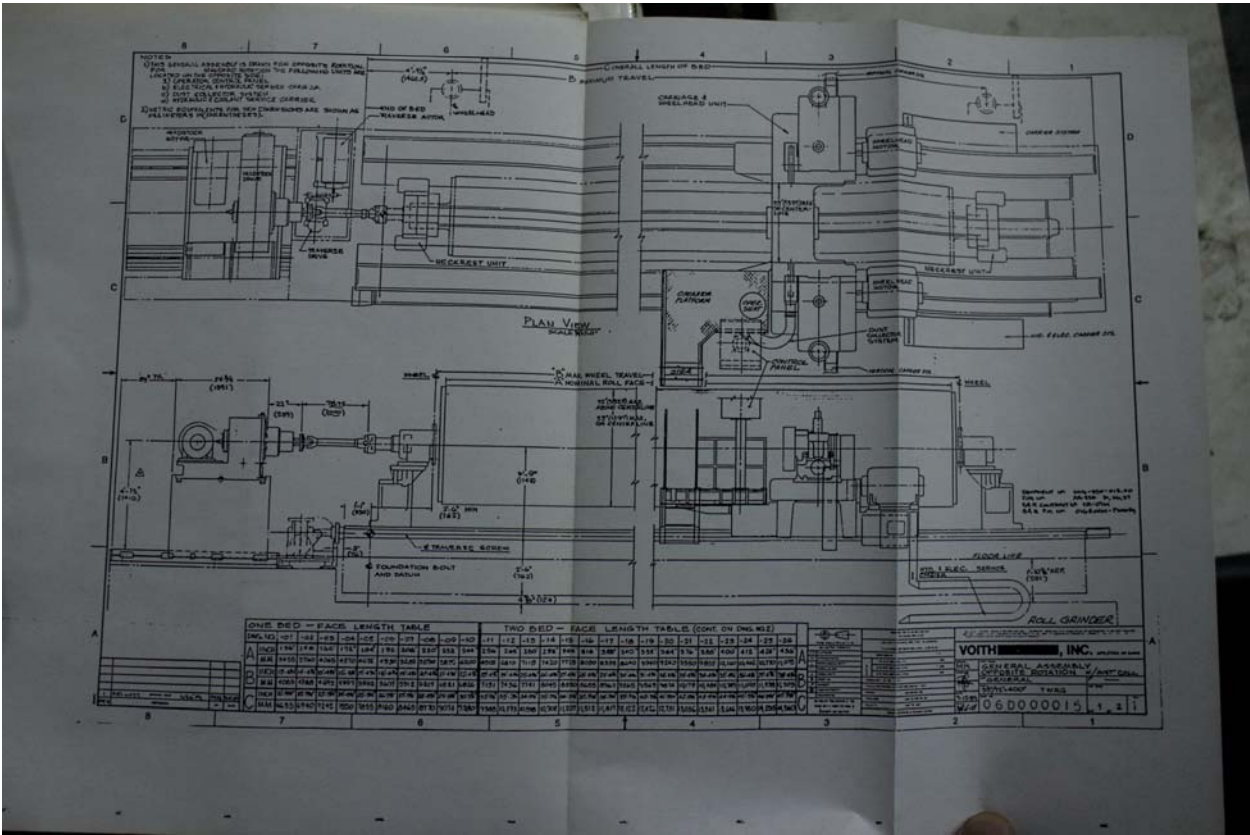
SECTION A-A

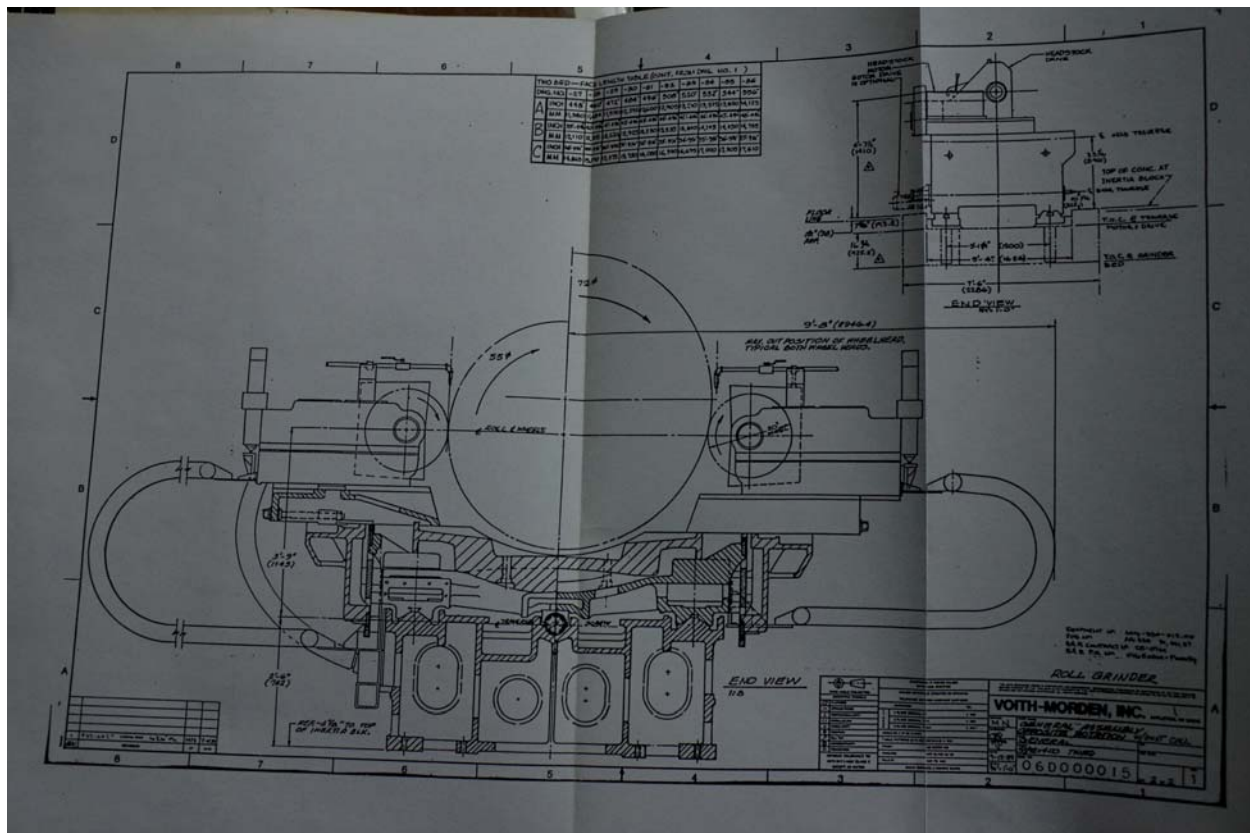
FOUNDATION PLAN

VOITH, INC.

060000016















MACHINE SERIAL NO.

R89-6037

MACHINE CAPACITY

'55-72X424

IMPORTANT—SEE INSTRUCTION MANUAL BEFORE STARTING MACHINE, WHEN CHANGING SUPERVISION OR OPERATORS, AND FOR INFORMATION ON SAFETY DEVICES AND SAFETY PRECAUTIONS.

A REQUEST FROM ANY SUBSEQUENT PURCHASER OF THIS MACHINE WILL RESULT IN PROMPT FURNISHING OF CURRENT INFORMATION ON SAFETY. IN ABSENCE OF ANY SUCH REQUEST, V.M.I. DISCLAIMS ALL LIABILITY FOR OPERATION CONTRARY THERETO.

Voith-Morden, Inc.

2620 E. Glendale Avenue, Appleton, Wisconsin 54915

501571













03.01
03.02

MACHINE SPECIFICATIONS

MACHINE SIZE

Roll Diameter Ground on Center	55" Max. 8" Min.
Roll Diameter Ground Above Center	72"
Grinding Wheel Max. Size	20" Dia. X 3" Face

SPEEDS AND FEEDS

Grinding Wheel Motor	15 HP	650/1600	RPM
Grinding Wheel Speeds		0/1040	RPM
Headstock Motor Normal Grind	75 HP	1750/2500	RPM
Roll Speed Ranges (2)		.5/20 & 3/140	RPM
Traverse Motor		AC Servo	
Carriage Speed		0/100	IPM
Subbase Infeed Motor		AC Servo	
Tilt Infeed Motor		AC Servo	
Wheel Infeed		.00001/.0099	IPM
Total Range of Tilt Infeed		.200	

VOITH

03.03
03.04MACHINE SPECIFICATIONSLUBRICATION SYSTEM

Spindle Oil Pump Motor	3 HP	3450	RPM
Spindle Oil Pressure		350	PSI
Safety Shut-Off Pressure Switch Set At		200	PSI
Ways Oil Pump Motor	1 HP	1725	RPM
Ways Oil Pressure		10	PSI
Safety Shut-Off Pressure Switch Set At		8	PSI
Headstock		12 2	PSI Max. PSI Min.

COOLANT SYSTEM & AUX. COOLANT SYSTEM

Coolant Pump Motor	1/2 HP	1725	RPM
Coolant Head & GPM		30	GPM
Measured at Pump Discharge		20 ft.	Head

05.51.01

EXAMPLE

ROLL GRINDING LOG

Roll Description

Bø116Shape

Roll Setup

Wheels Used

Coolant

Remarks

20" X 298" Inter. Cal. Roll For
No. 2 P.M.

Require 70 deg.

Support in Hsg's use 4-1/2" hsg.
support plus 1/2 thk filler roll 1/8"
above center roll drive end 5" dia. use
pockethead

39C100IE9X14 Norton 2" Wide

Cook Cool 1975

GRINDING

ROUGH GRIND

Roll Speed

Wheel Speed

Carriage Trav.

Auto-Infeed

9 RPM approx. 25% on rheostat

650 RPM approx. 40% on rheostat

1/2" Wheel overlap approx. 27 in. per
min. 45% on rheostat

Approx. 30% on rheostat for 18 amp. cut
(max. load wheels will take)

SEMI-FINISH GRIND

Roll Speed

Wheel Speed

Carriage Trav.

Auto-Infeed

9 RPM at start drop to 6-1/2 RPM
approx. 10% on rheostat

Same

Decrease in stages to 1" wheel overlap
approx. 15 in. per min. 20% on rheostat

Decrease in stages to 8 amp. cut

Georgia Pacific

#2 ROLL GRINDER
OPERATOR'S MANUAL

GRINDING (Cont.)FINISH GRIND

Roll Speed	Same
Wheel Speed	Same
Carriage Trav.	Decrease in stages to 1-1/2" Wheel overlap approx. 9 in. per min. 12% on rheostat
Auto-Infeed	Decrease in stages to 5 amp cut.
	NOTE: Wheels draw 4.0 amps No load

ROLL HISTORYRoll Description

20" X 298" Inter. Cal.
Roll for No. 2 P.M.

Serial No.

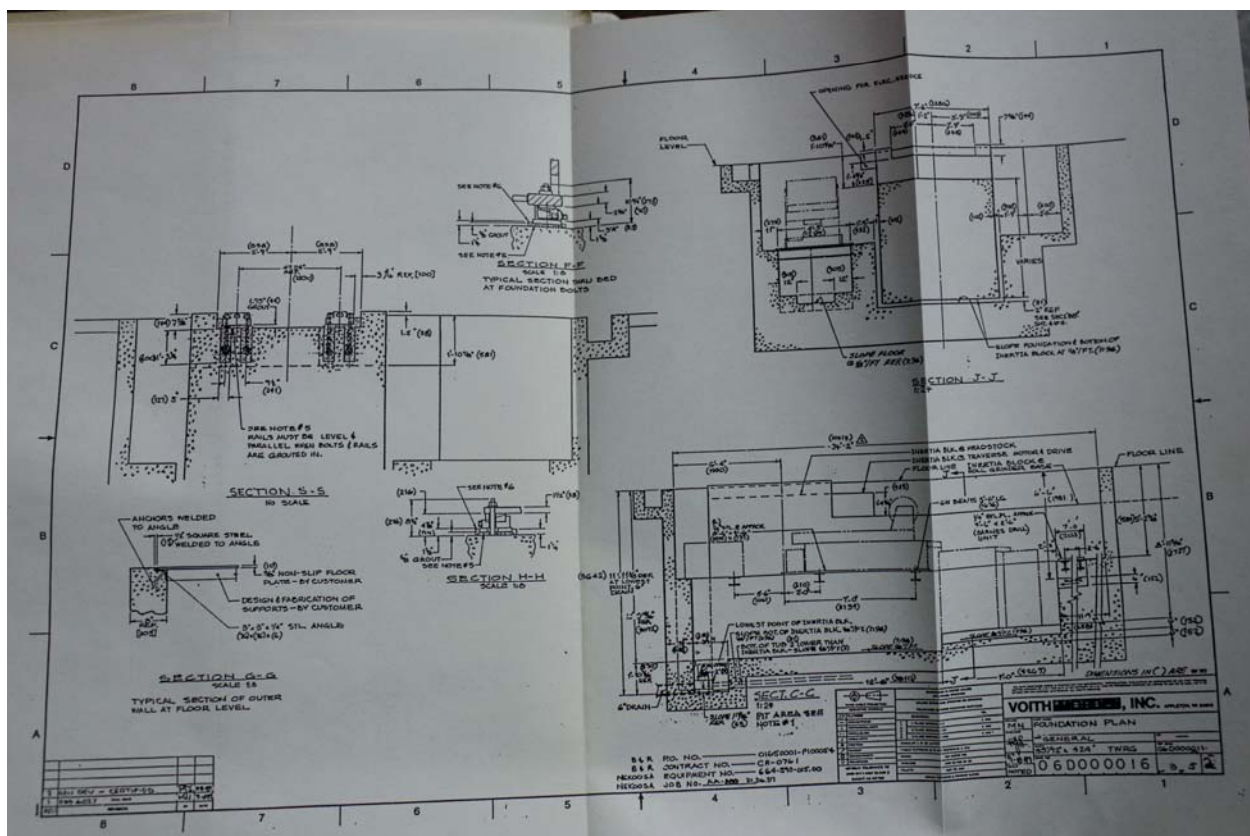
72H196 - 1-7-8-72

Regrind LogRemarks

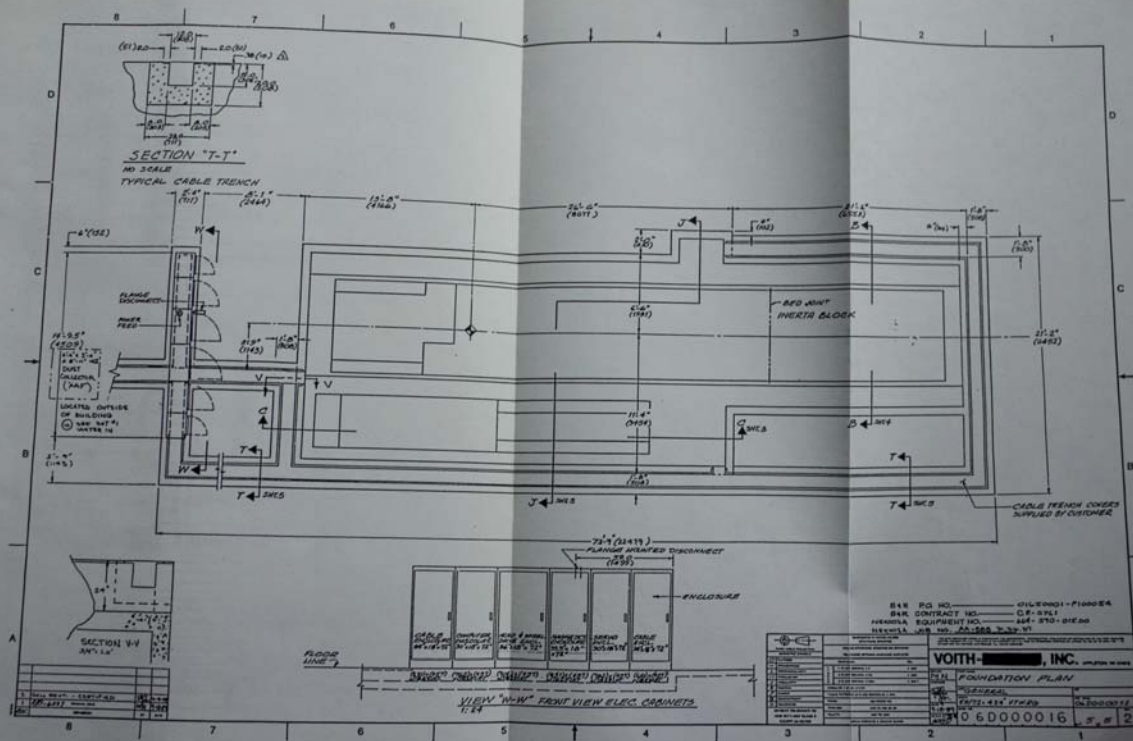
June 12, 1973	See roll profile dated June 14, 1973
Feb. 20, 1974	See roll profile dated Feb. 21, 1974 - Approx. 3/4 chip out of roll face drive end - roll still usable
July 8, 1974	See roll profile dated July 9, 1974
March 10, 1975	See roll profile dated March 14, 1975 - small pits starting approximately 50" from drive end. Had to remove .200 from roll dia. to clean up. Had hardness check made. 68 Shore Scleroscope O.K.
Oct. 19, 1975	See roll profile dated October 21, 1975
June 3, 1976	See roll profile dated June 4, 1976.

Georgia-Pac

12 ROLL
OPERATOR







Wallen inc.
Roll Grinder Service & Parts

William A. Braun
President

803.951.1944
fax: 803.951.1701

Bill@WallenInc.com

P.O. Box 2187
Lexington, SC 29071-2187

196 Shirway Road
Lexington, SC 29073

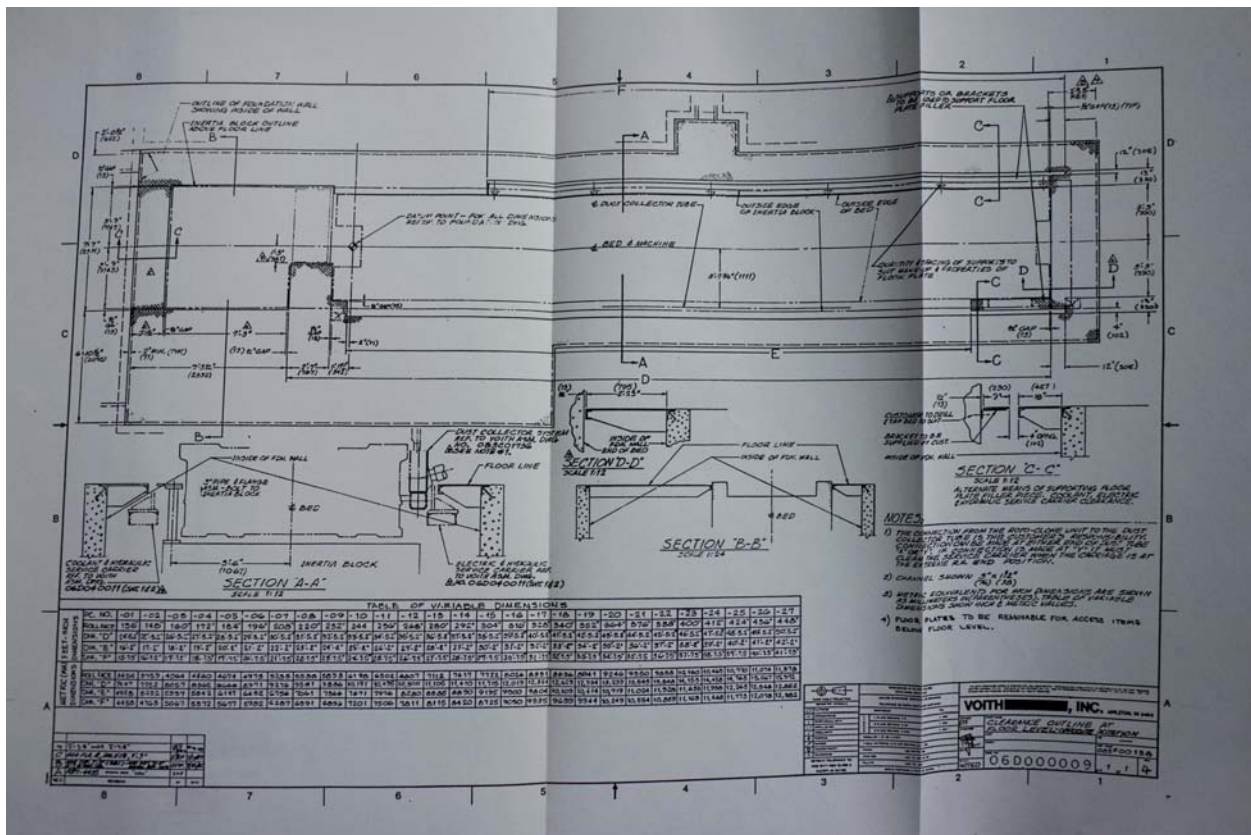


		TABLE OF VARIABLE DIMENSIONS																																
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NOTES

- 1) THE CONNECTION FROM THE ROOF-CLIMB UNIT TO THE DUCT... (text continues)
- 2) CHANNEL SADDLE... (text continues)
- 3) METAL EQUIPMENT FOR EACH... (text continues)
- 4) FLOOR PLATES TO BE REMAINABLE FOR ACCESS... (text continues)

VOITH, INC.

CLEARANCE OUTLINE AT... (text continues)

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