



Drawing Transmittal #5

Valmet, Inc.
 1 Cellu Drive, Suite 200
 Nashua, NH 03064
 Tel. No.: (603) 882-2711
 Fax No.: (603) 598-7979

Date: May 24, 2024

S.O. # : N209282
 Cust. P.O. # : 2113681
 Acct. No.: 236

Project Manager: Steve Gaines Page: 1 of 1
 Area Manager: Mark Howell

Customer Name: Georgia-Pacific Cedar Springs LLC
Address: 12551 GA Highway 273 West
1 City, State, Zip: Cedar Springs, GA 39832 US
Attention: Ezekiel Jones
Telephone #: 404-652-5305

Consulting Firm: EGS
Address: 2431 West Main St, Suite 801
2 City, State, Zip: Dothan, AL, 36301
Attention: Barry Tierce
Telephone #: 344-677-7775/ 239-209-1264 m

Other: Georgia-Pacific Cedar Springs LLC
Address: 12551 GA Highway 273 West
4 City, State, Zip: Cedar Springs, GA 39832 US
Attention: Kyle Davis
Telephone #: 0

Format: **P** - Print, **C** - CDROM, **E** - Electronic Copy, **USB** - USB Flash Drive
 Drawing Type: **Ref** - Reference, **App** - Approval, **Rapp** - Re-Approval, **Cert** - Certified, **Rcert** - Re-Certified

Serial No	Drawing No.	Rev	Drawing Title	Dwg. Type	Distribution			
					1	2	3	4
23H9676	G010295-186	G	Field Welding Instructions	Cert				
	G010295-770		Field Welding Instructions	Cert				
	000642N02		Support Saddle Assembly	Cert				
	001782N02		Shower Locations and Flow Rates	Cert				
	006735N02		UFM Shower Pipe Assembly	Cert				
	002091N01	C	Cylinder General Arrangement	Cert				
	003929N02		Main Drive Assembly	Cert				
	NAS0200428		Main Vat General Arrangement	Cert				
	NAS0200431		Field Installation - Inlet Nozzles	Cert				

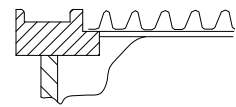
Approval & or Certified drawings requesting information NOT returned within two weeks of receipt will not be released for manufacture and will cause delay in shipping. Delay will be based on shop load at the time the information is received.

A signed copy of the transmittal must be returned to acknowledge receipt.

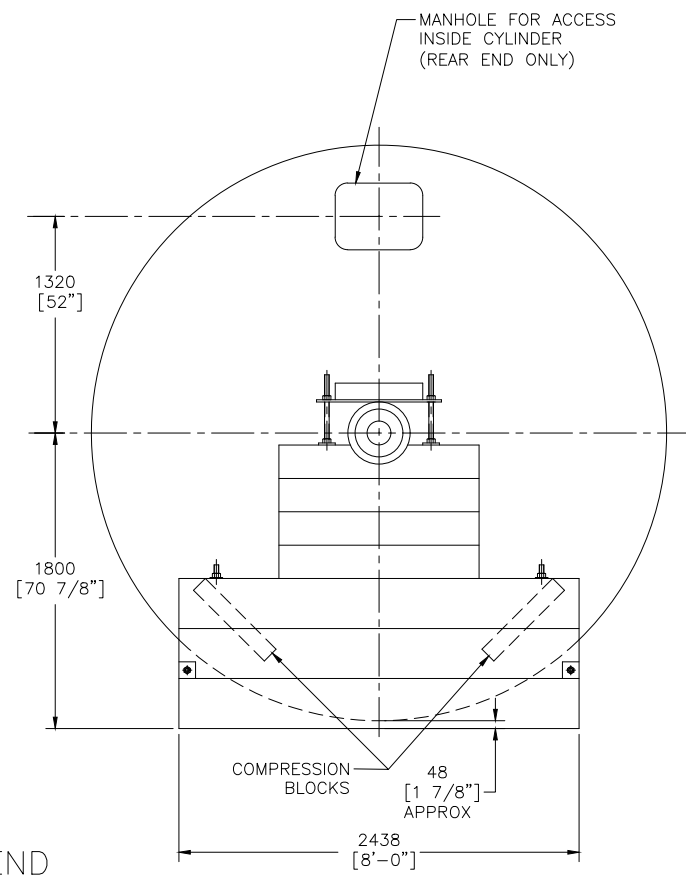
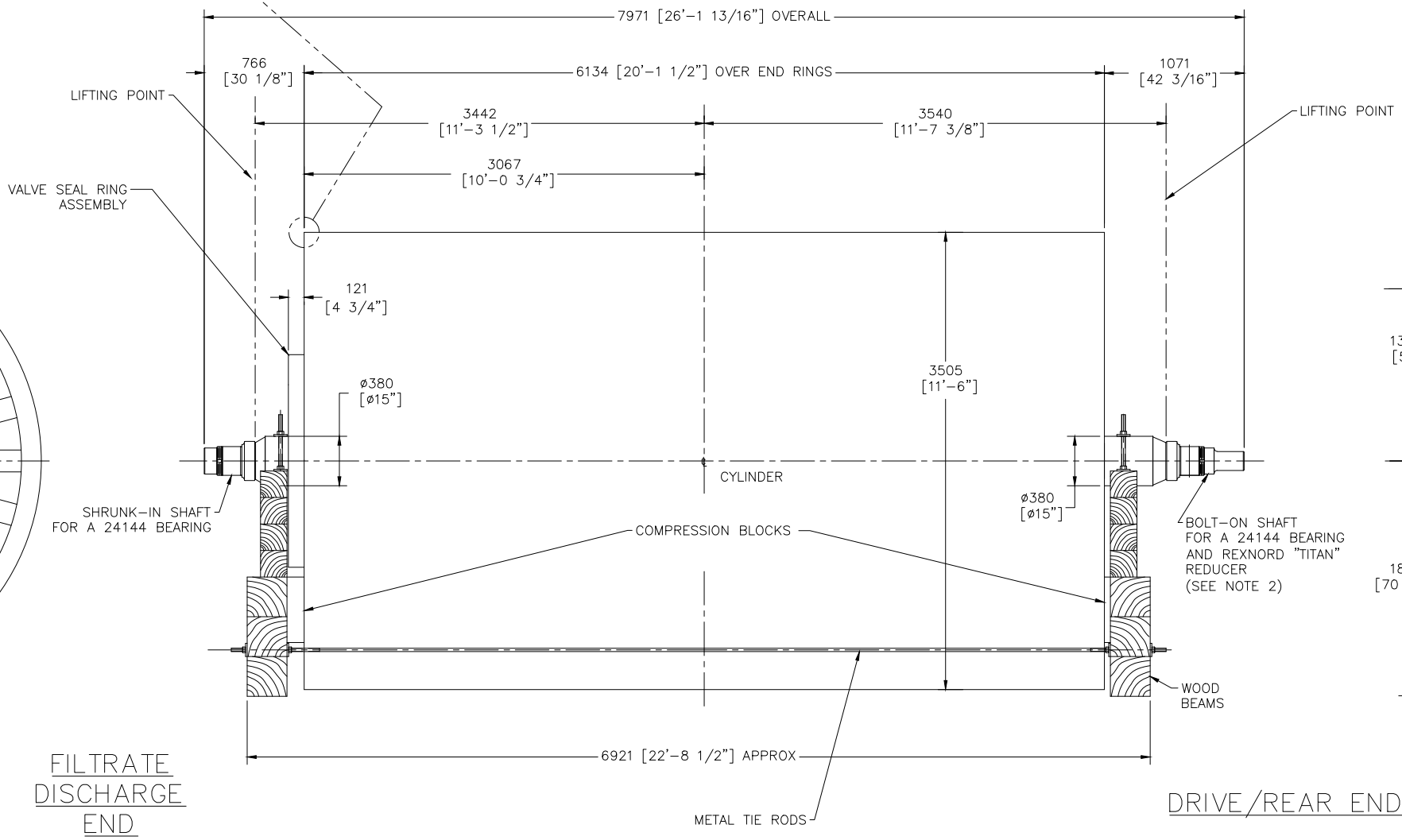
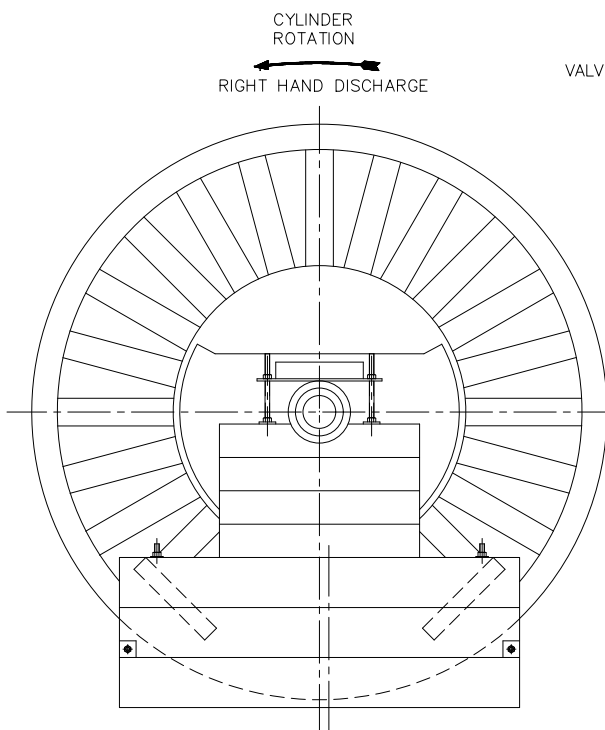
Received by: _____

NOTES:

- 1. SEE "INSTALLATION AND MAINTENANCE MANUAL" FOR RECOMMENDED FACE WIRE AND BANDING INSTALLATION PROCEDURES.
- 2. SHAFT TORQUE REQUIREMENTS:
BOLT-ON SHAFT: 382 FT-LBS
LOCTITE OR EQUIVALENT MUST BE USED WITH THE TORQUE VALUES ABOVE.



END RING CONSTRUCTION TYPICAL BOTH ENDS



CYLINDER ESTIMATED WEIGHT LESS SHIPPING CRADLE: 27,900 LBS / 12.65 METRIC TONNES
CYLINDER ESTIMATED WEIGHT WITH SHIPPING CRADLE: 30,400 LBS / 13.79 METRIC TONNES

CERTIFIED CORRECT

CUSTOMER: GEORGIA-PACIFIC LLC - CEDAR SPRINGS, GA
P.O. NO.: 02113681
SERIAL NO. 23H9676 EQUIPMENT NO. M15-6510 S.O. NO. N209282
TOP LINER 1ST STAGE WASHER

DATE: 28-MAY-2024 BY: M.KUBA

CUSTOMER SIGNATURE

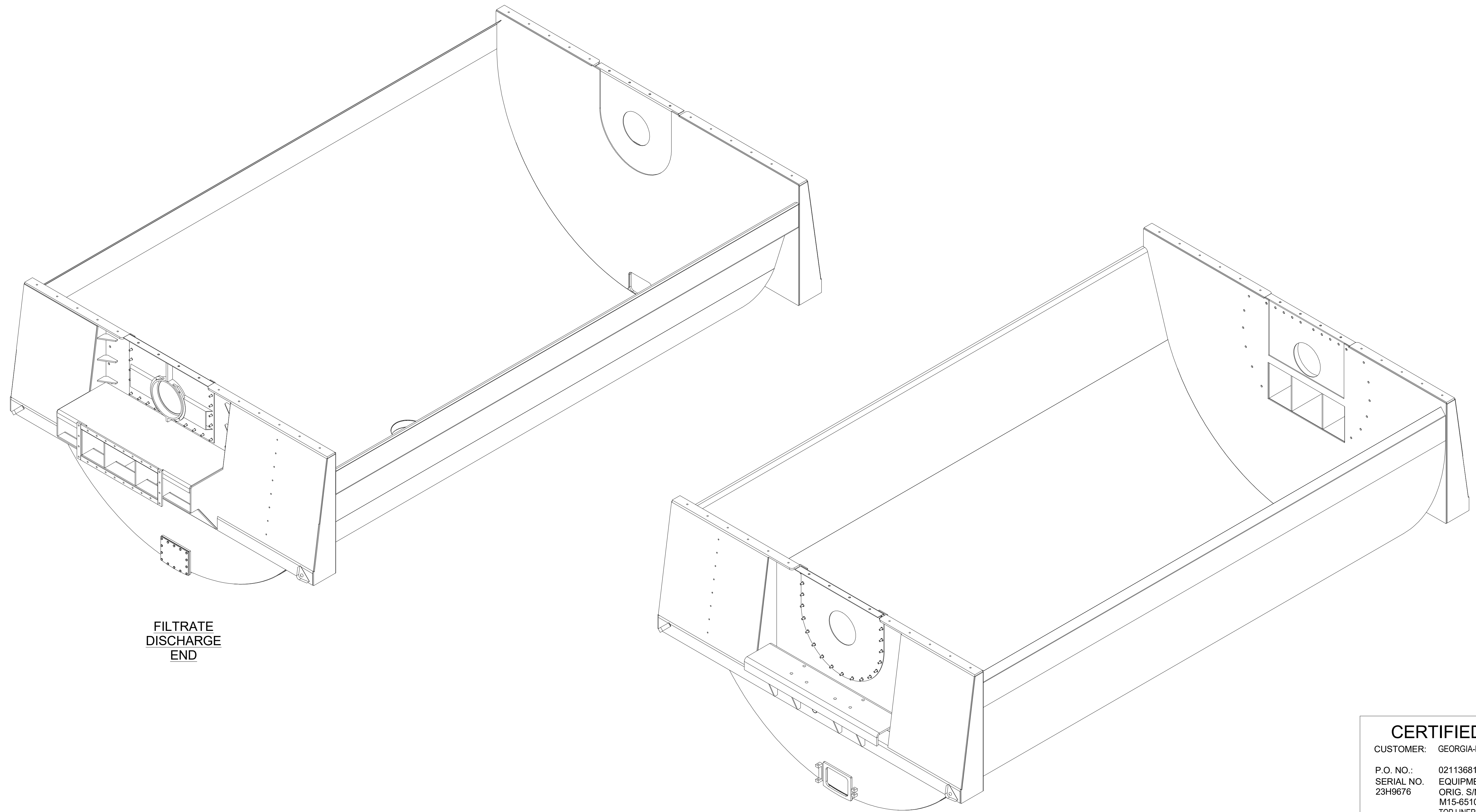
APPROVED _____ PRINT NAME
 APPROVED _____ SIGNATURE
 AS NOTED _____ DATE

REV	DESCRIPTION	DATE	DRAWN BY	CHECKED	APPROVED
0	INITIAL RELEASE.	14-MAY-2014	LH SMITH	LH SMITH	LH SMITH

Title Information		Project Number	
VACUUM WASHER		002042N01	
CYLINDER GENERAL ARRANGEMENT		Reason For Issue	
L.H. FILTRATE DISCHARGE/R.H. DRIVE		RELEASED FOR MANUFACTURE	
Reference Drawing	Scale	Weight	Sheet size
002042N01	NONE		D
Sheet	Drawing No	Rev	
1 of 1	002091N01	0	



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**FILTRATE
DISCHARGE
END**

REAR END

CERTIFIED CORRECT
 CUSTOMER: GEORGIA-PACIFIC LLC - CEDAR SPRINGS,GA
 P.O. NO.: 02113681
 SERIAL NO. 23H9676 EQUIPMENT NO. M15-6510 S.O. NO. N209282
 TOP LINER 1ST STAGE WASHER
 DATE: 24-MAY-2024 BY: M.KUBA

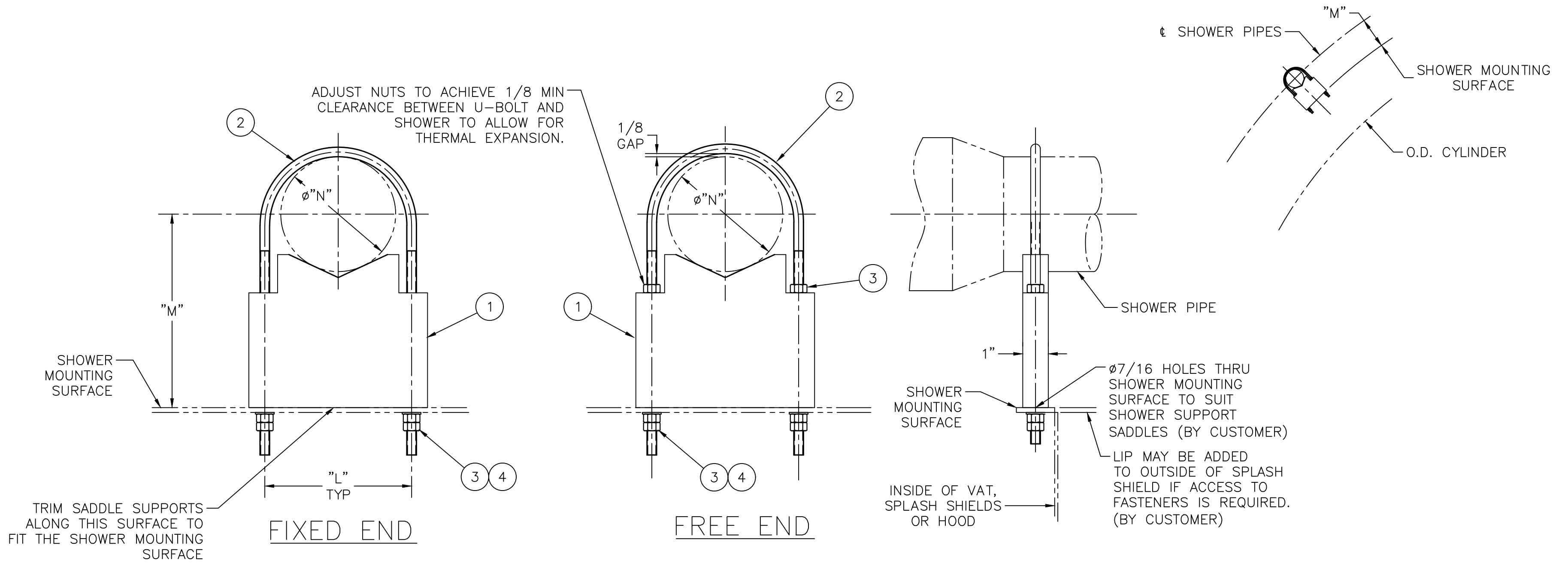
CUSTOMER SIGNATURE
 APPROVED _____ PRINT NAME
 APPROVED AS NOTED _____ SIGNATURE DATE

Title Information		Project Number		REMOVE BURRS & BREAK ALL SHARP EDGES	
VACUUM WASHER		N209282		Reason for Issue	
Ø11'-6" X 20' LG. CORU-DEK V		All project Number		RELEASED FOR MANUFACTURE	
MAIN VAT GENERAL ARRANGEMENT		Next Assembly		Scale Weight Sheet size	
DORR-OLIVER REPLACEMENT		Reference Drawing		NONE 11510 lbmass D	
R.H. DISCHARGE		NAS0200210		Revision	
Sheet Drawing No		2 of 2 NAS0200428		1	



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NOTES:
 1. USE CERTIFIED PRINTS ONLY FOR MANUFACTURE AND INSTALLATION



CERTIFIED CORRECT
 CUSTOMER: GEORGIA-PACIFIC LLC - CEDAR SPRINGS, GA
 P.O. NO.: 02113681
 SERIAL NO. 23H9676 EQUIPMENT NO. M15-6510 S.O. NO. N209282
 TOP LINER 1ST STAGE WASHER
 DATE: 28-MAY-2024 BY: M.KUBA

CUSTOMER SIGNATURE

APPROVED _____
 PRINT NAME

APPROVED _____
 AS NOTED SIGNATURE DATE

REV	DESCRIPTION	DATE	DRAWN BY	CHECKED	APPROVED
0	INITIAL RELEASE	24-JUN-2004	LH SMITH	LH SMITH	LH SMITH
A	SEE SHEET 2 FOR CHANGES	21-SEP-2004	WBJ	WBJ	WBJ
B	SEE SHEET 2 FOR CHANGES	10-DEC-2004	LHS	LHS	LHS
C	WAS 12" DIM, WAS 75 9/16" RADIUS	25-AUG-2005	WBJ	WBJ	WBJ
D	SEE SHEET 2 FOR CHANGES	20-OCT-2005	LHS	LHS	LHS
E	SEE SHEET 3 FOR CHANGES	10-MAY-2007	RCS	RCS	RCS
F	SEE SHEET 3 FOR CHANGES	28-AUG-2007	RCS	RCS	RCS
G	REMOVED 14" DIMENSION	01-APR-2009	RCS	RCS	RCS
-	TYPE F: TITLE BLOCK CHANGED, VALMET WAS GL&V	26-AUG-2019	JPT	JPT	GAC

Third Angle Projection Units: INCH Welding: E-4000 Tolerances: E-2167 Thread: E-825	Title Information VACUUM WASHER SUPPORT SADDLE ASSEMBLY		Project Number Alt Project Number Next Assembly		REMOVE BURRS & BREAK ALL SHARP EDGES Reason For Issue
	Reference Drawing B-1983		Scale: NONE	Weight: NONE	
	Valmet		Sheet: 1 of 3 Drawing No: 000642N02	Rev: G	
	Revision				

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2

1

STOCK LIST 000642N02--SEE TABLE				
QTY	PART NO.	DESCRIPTION	MATERIAL	ITEM
2	SEE TABLE	SADDLE SUPPORT		1
2	SEE TABLE	U-BOLT		2
10		3/8-16UNC HEX NUT	SEE TABLE	3
4		3/8 STD WASHER	SEE TABLE	4

PART NO	MATERIAL ITEMS 2, 3 & 4	PART NO ITEM 1	PART NO ITEM 2	"M"	"N"	"L"	ADDED BY
000642N02-10	316 STST	000641N02-01	000640N02-02	7 1/2	4 1/2	5 3/4	
-11	S1501	000641N02-02	000640N02-05	4 13/16	4		LHS 1-JUL-04
-12	316 STST	000641N02-03	000640N02-02	7	5		LHS 19-AUG-04
-13	S1501	000641N02-05	000640N02-03	7 1/2	3 1/2		GPS 4-DEC-04
-14	316 STST	000641N02-06	000640N02-02	8	3 1/2		GPS 10-DEC-04
-15	317 STST	000641N02-01	000640N02-09	7 1/2	4		LHS 4-JAN-05
-16	317 STST	000641N02-07	000640N02-09	7 1/16	4 1/2		LHS 10-JAN-05
-17	304 STST	000641N02-07	000640N02-01	7 1/16	4 1/2		LHS 12-JAN-05
-18	S1501	000641N02-07	000640N02-10	7 3/8	5		LHS 4-FEB-05
-19	316 STST	000641N02-07	000640N02-02	7 3/8	5		LHS 11-FEB-05
-20	316 STST	000641N02-09	000640N02-12	7 7/16	2 7/8		LHS 8-MAR-05
-21	316 STST	000641N02-05	000640N02-02	7 1/2	3 1/2		LHS 13-APR-05
-22	316 STST	000641N02-07	000640N02-02	7 1/16	4 1/2		LHS 26-APR-05
-23	317 STST	000641N02-03	000640N02-09	7	5		LHS 21-JUL-05
-24	316 STST	000641N02-10	000640N02-14	5 7/16	4 1/2		WLB 16-AUG-05
-25	317 STST	000641N02-07	000640N02-09	7 3/8	5		LHS 28-OCT-05
-26	316 STST	000641N02-11	000640N02-17	12	4		LHS 28-JUL-06
-27	317 STST	000641N02-12	000640N02-18	8	4		RCS 17-AUG-06
-28	317 STST	000641N02-06	000640N02-09	8	5		RCS 06-SEP-06
-29	316 STST	000641N02-13	000640N02-17	10 5/8	4 1/2		RCS 13-SEP-06
-30	316 STST	000641N02-15	000640N02-17	9 3/16	3 1/2		RCS 14-NOV-06

CERTIFIED CORRECT

CUSTOMER: GEORGIA-PACIFIC LLC - CEDAR SPRINGS, GA
P.O. NO.: 02113681
SERIAL NO. 23H9676 EQUIPMENT NO. M15-6510 S.O. NO. N209282
TOP LINER 1ST STAGE WASHER


DATE: 28-MAY-2024 BY: M.KUBA

CUSTOMER SIGNATURE

APPROVED _____ PRINT NAME
 APPROVED _____ SIGNATURE DATE
AS NOTED

(FOR METRIC ASSY SEE 000700N02)

REV	DESCRIPTION	DATE	DRAWN BY	CHECKED	APPROVED
C	FOR -20 MAT'L ITEMS 3 & 4 WAS 317L	20-OCT-2005	LHS	LHS	LHS
B	FOR -13 MAT'L WAS S1901	10-DEC-2004	LHS	LHS	LHS
A	FOR -11 "M" DIM. WAS 5 1/8	21-SEP-2004	WBJ	WBJ	WBJ
-	TYPE F: ADDED METRIC ASSY DWG.#	25-AUG-2004	WBJ	WBJ	WBJ
0	INITIAL RELEASE	24-JUN-2004	LH SMITH	LH SMITH	LH SMITH

Third Angle Projection	Title Information VACUUM WASHER SUPPORT SADDLE ASSEMBLY	Project Number	REMOVE BURRS & BREAK ALL SHARP EDGES
Units INCH		Alt Project Number	
Welding E-4000	Valmet 	Next Assembly	Reason For Issue
Tolerances E-2167		Reference Drawing B-1983	Scale NONE
Thread E-825	Sheet 2 of 3	Drawing No 000642N02	Rev G

4

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2

1

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PART NO	MATERIAL ITEMS 2, 3 & 4	PART NO ITEM 1	PART NO ITEM 2	"M"	"N"	"L"	ADDED BY
-31	316 STST	000641N02-14	000640N02-12	5 3/4	3 1/2		RCS 14-NOV-06
-32	316 STST	000641N02-02	000640N02-14	4 13/16	4 1/2		RCS 21-DEC-06
-33	S1601	000641N02-07	000640N02-04	6 13/16	4		RCS 06-FEB-07
-34	316 STST	000641N02-04	000640N02-02	6	4 1/2	5 3/4	RCS 14-MAR-07
-35	316 STST	000641N02-16	000640N02-12	8	4 1/2		RCS 14-MAR-07
-36	316 STST	000641N02-07	000640N02-02	6 9/16	3 1/2		RCS 08-MAY-07
-37	317 STST	000641N02-06	000640N02-19	8 3/4	5		RCS 04-JUN-07
-38	317 STST	001973N02-01	000640N02-20	7 1/2	3 1/2	5 1/4	RCS 24-JUL-07
-39	316 STST	000641N02-01	000640N02-21	7 1/2	2 3/8		RCS 07-AUG-07
-40	317 STST	000641N02-01	000640N02-22	7 1/2	2 3/8		RCS 07-AUG-07
-41	S1601	000641N02-17	000640N02-03	7 1/2	5		RCS 16-NOV-07
-42	S1601	000641N02-01	000640N02-04	7 1/2	4 1/2	5 3/4	RCS 21-DEC-07
-43	317 STST	000641N02-14	000640N02-23	5 3/4	3 1/2		RCS 25-JAN-08
-44	304 STST	000641N02-18	000640N02-24	6 1/2	2 3/8		RCS 28-JAN-09
-45	S1601	000641N02-19	000640N02-25	4	2 3/8		RCS 12-MAR-09
-46	316 STST	000641N02-20	000640N02-26	5 1/2	4		RCS 30-MAR-09
-47	304 STST	44-27270	000640N02-27	6	6 5/8	8 3/8	RCS 17-JUN-09
-48	S1601	000641N02-21	000640N02-28	9	2 3/8		RCS 27-JUL-09
-49	316 STST	000641N02-22	000640N02-02	7	5		RCS 15-SEP-09
-50	316 STST	000641N02-23	000640N02-29	4 3/16	2 3/8		RCS 07-OCT-09
-51	304 STST	000641N02-10	000640N02-30	5 7/16	2 3/8		RCS 30-NOV-09
-52	316 STST	000641N02-19	000640N02-31	4	2 3/8		RCS 26-MAR-10
-53	316 STST	000641N02-17	000640N02-32	7 1/2	5	5 3/4	LHS 19-APR-10
-54	316 STST	000641N02-24	000640N02-21	6	3 1/2		RCS 05-MAY-10
-55	S1601	000641N02-25	000640N02-33	6	4		RCS 28-DEC-10
-56	S1601	000641N02-01	000640N02-04	7 1/2	4		RCS 16-FEB-11
-57	S1601	000641N02-04	000640N02-34	5	2 3/8		RCS 17-FEB-11
-58	304 STST	000641N02-01	000640N02-01	7 1/2	4		RCS 26-JUN-12
-59	S1601	000641N02-07	000640N02-34	6	2 3/8		RCS 19-JUL-12
-60	S1601	000641N02-26	000640N02-35	12	4 1/2		RCS 20-AUG-12
-61	S1601	000641N02-01	000640N02-36	7 1/2	2 3/8		RCS 4-SEP-12
-62	316 STST	003561N02-01	000640N02-37	10	6 5/8	8 3/8	RCS 25-JUN-13
-63	316 STST	000641N02-07	000640N02-21	6 1/4	3 1/2	5 3/4	RCS 18-SEP-13
-64	S1601	44-27270	000640N02-38	6	6 5/8	8 3/8	RCS 05-NOV-13
-65	S1901	000641N02-17	000640N02-41	7 1/2	5	5 3/4	LHS 15-MAR-16
-66	S1601	000641N02-27	000640N02-44	3 9/16	5	5 3/4	JPT 5-SEP-17
-67	316 STST	000641N02-04	000640N02-45	10	2 3/8	5 3/4	POB 03-JAN-18
-68	304 STST	000641N02-28	000640N02-30	4	3 1/2	5 3/4	JPT 14-FEB-18
-69	S1202	000641N02-04	000640N02-03	6	4 1/2	5 3/4	POB 28-APR-23

STOCK LIST 000642N02-SEE TABLE				
QTY	PART NO.	DESCRIPTION	MATERIAL	ITEM
2	SEE TABLE	SADDLE SUPPORT		1
2	SEE TABLE	U-BOLT		2
10		3/8-16UNC HEX NUT	SEE TABLE	3
4		3/8 STD WASHER	SEE TABLE	4

(FOR METRIC ASSY SEE 000700N02)

CERTIFIED CORRECT
 CUSTOMER: GEORGIA-PACIFIC LLC - CEDAR SPRINGS, GA
 P.O. NO.: 02113681
 SERIAL NO. 23H9676 EQUIPMENT NO. M15-6510 S.O. NO. N209282
 ORIG. S/N: M15-6510
 TOP LINER 1ST STAGE WASHER
 DATE: 28-MAY-2024 BY: M.KUBA

CUSTOMER SIGNATURE
 APPROVED PRINT NAME
 APPROVED SIGNATURE DATE
 AS NOTED

REV	DESCRIPTION	DATE	DRAWN BY	CHECKED	APPROVED
F	FOR -39 MATERIAL WAS 317 ST ST	28-AUG-2007	RCS	RCS	RCS
E	FOR -36 ITEM 2 WAS -04	10-MAY-2007	RCS	RCS	RCS
0	INITIAL RELEASE	24-JUN-2004	LH SMITH	LH SMITH	LH SMITH

 Third Angle Projection Units: INCH Welding: E-4000 Tolerances: E-2167 Thread: E-825	Title Information		Revision	
	VACUUM WASHER		Project Number	REMOVE BURRS & BREAK ALL SHARP EDGES
	SUPPORT SADDLE ASSEMBLY		Alt Project Number	Reason For Issue
			Next Assembly	Scale Weight Sheet size
		Reference Drawing	B-1983	NONE C
		Sheet	3 of 3	Rev
		Drawing No	000642N02	G

NOTES:

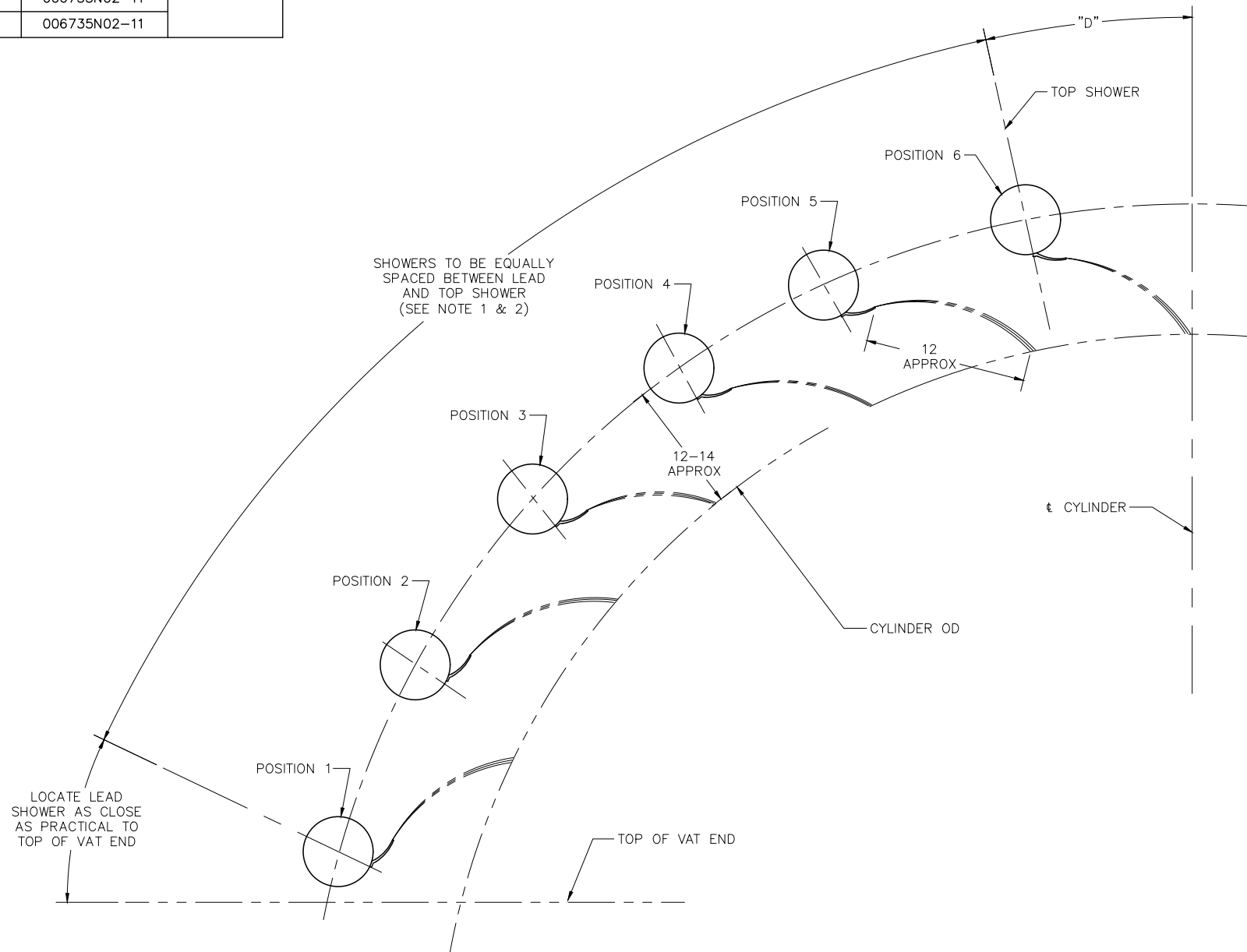
- 1. PIPES TO BE INSTALLED PER TABLE (BY CUSTOMER).
- 2. OPERATING PRESSURE AT THE SHOWER INLETS IS 1/2 TO 1 PSI.
- 3. USE CERTIFIED PRINTS ONLY FOR ASSEMBLY AND INSTALLATION.

SHOWER TYPE	ORIFICE SIZE	FLOW RATE GPM	SHOWER POSITION	PART NO.	TOTAL FLOW GPM
UFM	3/8"	52-74	1	006735N02-21	536 MIN. 762 MAX.
	3/8"	52-74	2	006735N02-21	
	7/16"	71-101	3	006735N02-10	
	7/16"	71-101	4	006735N02-10	
	5/8"	145-206	5	006735N02-11	
	5/8"	145-206	6	006735N02-11	

6 (20' LG) PIPES SUPPLIED WITH THIS ORDER

RECOMMENDED DISTANCE OF TOP SHOWER TO CYLINDER CENTERLINE

CYLINDER DIAMETER	"D"
8'-0"	24" MIN.
9'-6"	24" MIN.
11'-6"	30" MIN.
13'-6"	32" MIN.



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 TOP LINER 1ST STAGE WASHER
 DATE: 28-MAY-2024 BY: M.KUBA

CUSTOMER SIGNATURE
 APPROVED PRINT NAME
 APPROVED SIGNATURE DATE
 AS NOTED

REV	DESCRIPTION	DATE	R. SHORT	R. SHORT	LH SMITH
0	INITIAL RELEASE.	03-JAN-2007	R. SHORT	R. SHORT	LH SMITH

Title Information		Project Number	
VACUUM WASHER		44-33546, 44-32821	
UFM STYLE SHOWERS		Reason For Issue	
SHOWER LOCATIONS AND FLOW RATES		RELEASED FOR MANUFACTURE	
Units	INCH	Scale	Weight
Welding	E-4000	Scale	Weight
Tolerances	E-2167	Scale	Weight
Thread	E-825	Scale	Weight

Sheet	1 of 1	Drawing No.	001782N02	Rev	0
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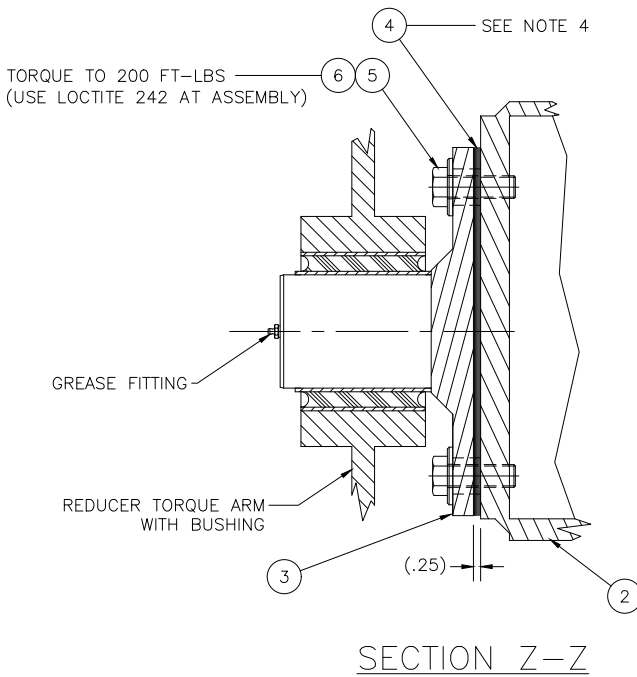
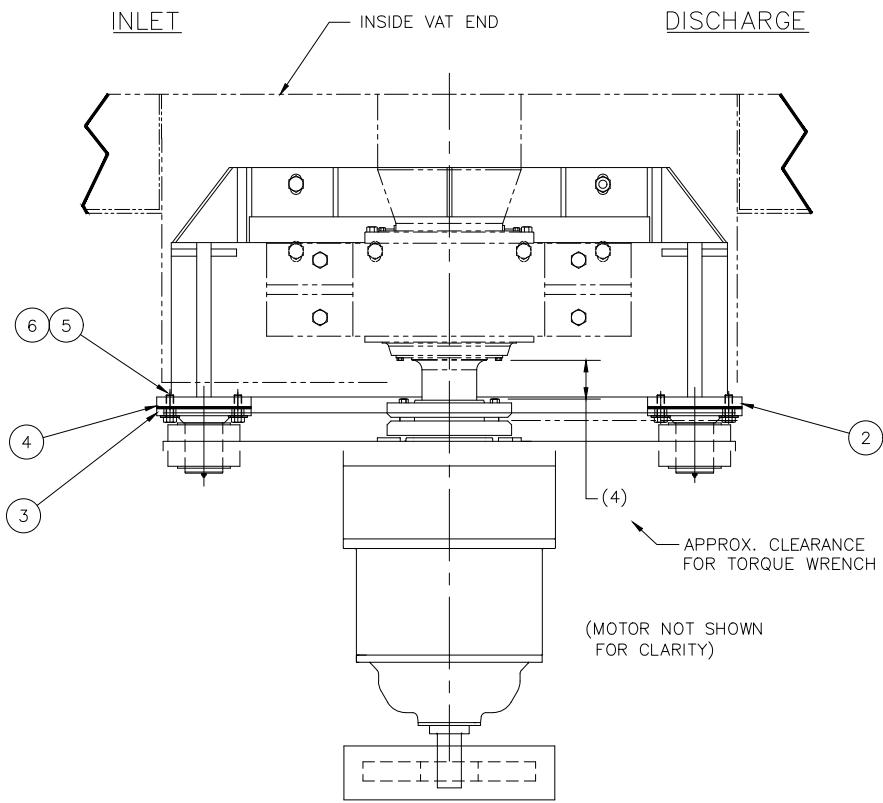


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 TOP LINER 1ST STAGE WASHER
 DATE: 28-MAY-2024 BY: M.KUBA

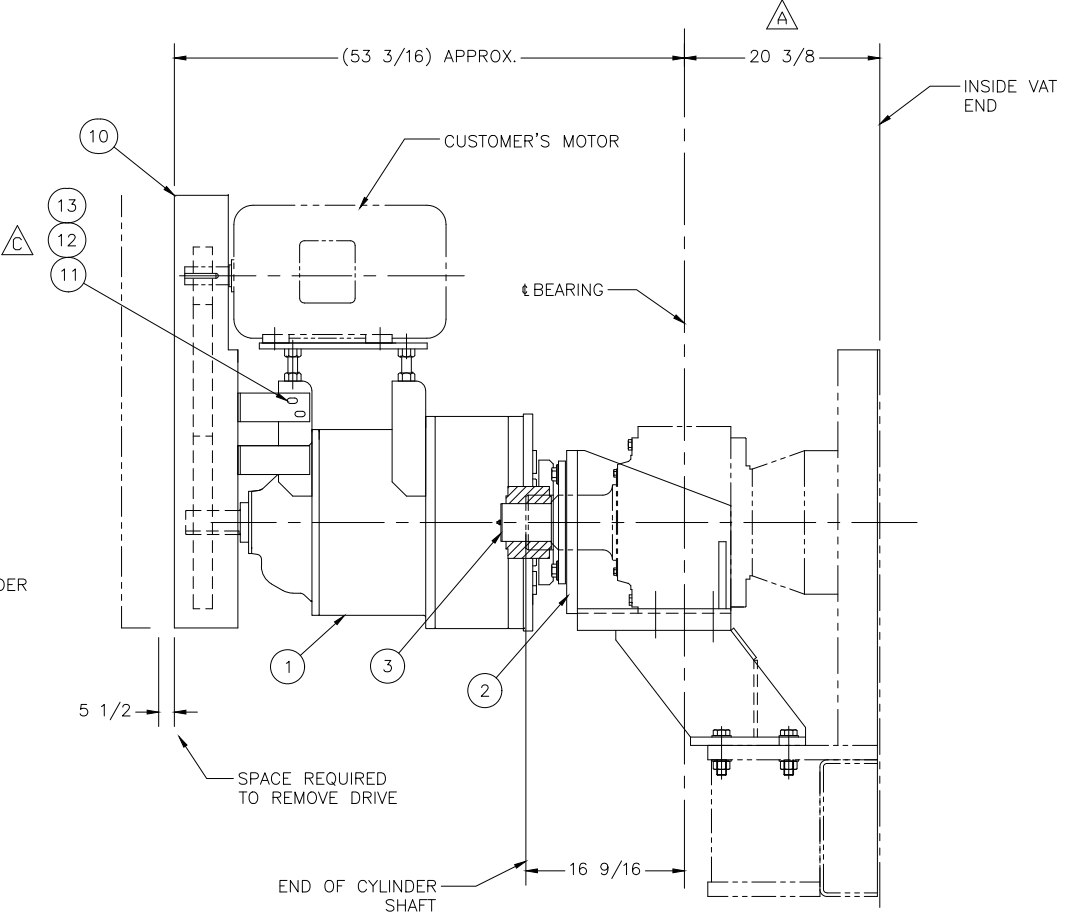
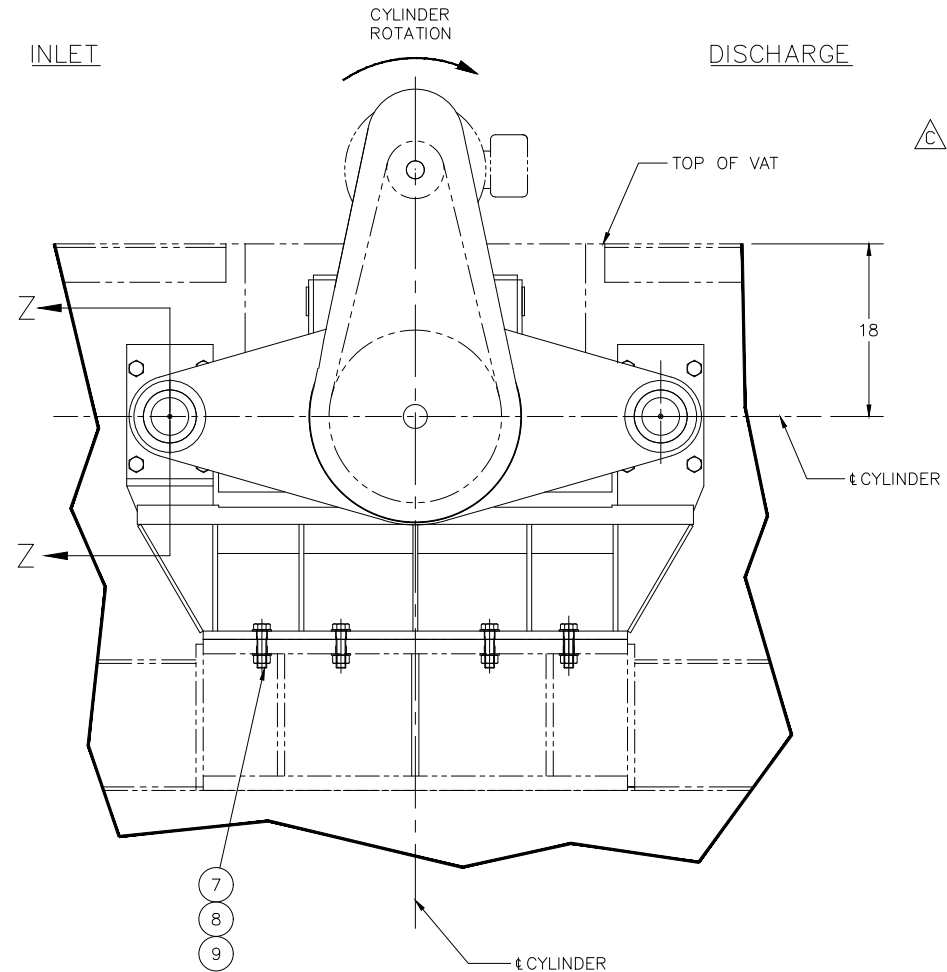
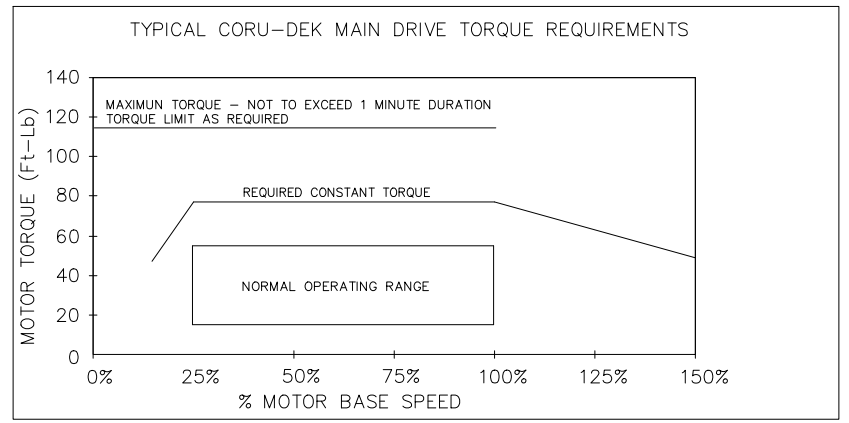
CUSTOMER SIGNATURE
 APPROVED _____
 PRINT NAME
 APPROVED _____
 AS NOTED SIGNATURE DATE



- NOTES:
- ALL DIMENSIONS ARE CERTIFIED FOR MECHANICAL EQUIPMENT FURNISHED BY VALMET ONLY.
 - CYLINDER SPEED 1 TO 5 RPM.
 - INSTALL CYLINDER INTO VAT, POSITION & ALIGN PER INSTRUCTION MANUAL & SECURE.
 - INSERT TORQUE ARM PINS IN REDUCER TORQUE ARM. INSTALL REDUCER ONTO SHAFT, ALIGN & SQUARE UP ACCORDING TO VENDORS INSTRUCTIONS. ALIGN TORQUE ARM PINS WITH MOUNTING BASES. SHIM AS REQUIRED & SECURE.

THE STANDARD VACUUM WASHER MAIN DRIVE MOTOR IS REQUIRED TO PRODUCE CONSTANT TORQUE FROM 25% TO 100% OF IT'S BASE SPEED AND CONSTANT HORSEPOWER FROM 100% TO 150% OF IT'S BASE SPEED. HIGH EFFICIENCY MOTORS OR LARGER DERATED MOTORS MUST BE USED. IF A LARGER DERATED MOTOR IS USED, IT MUST BE TORQUE LIMITED. SEE CHART BELOW.

REQUIRED CONSTANT TORQUE (TO 25% OF BASE SPEED)	76.8 Ft-Lb 104.1 N-m	% BASE SPEED	FILTER SPEED	TORQUE		POWER		MAX TORQUE	
				Ft-Lb	N-m	HP	Kw	Ft-Lb	N-m
MINIMUM INSTALLED MOTOR SIZE	20 HP 15 Kw	0%	0.0	0	0	0	0	115	156
REQUIRED OVERLOAD TORQUE (1 MINUTE DURATION)	115.2 Ft-Lb 156.2 N-m	25%	0.8	77	104	4.4	3.3	115	156
		100%	3.3	77	104	17.5	13.1	115	156
		150%	5.0	51	69	17.5	13.1		



REDUCER: (BY VALMET)

MAKE: REXNORD
 TYPE: SHAFT MOUNTED PLANETARY REDUCER - TITAN SERIES
 RATIO: 150.4:1

REDUCER SUPPLIED COMPLETE WITH SHRINK DISC FOR Ø145MM SHAFT, DOUBLE TORQUE ARM W/ULTRA BUSHINGS, MOTOR AND DRIVE SHEAVES, AND BELTS. SLOW SPEED OUTPUT SHAFT ROTATES IN EITHER DIRECTION.

BELT DRIVE: (BY VALMET)

MAKE: GATES POLYCHAIN
 RATIO: 2.29:1

MOTOR: (BY CUSTOMER)

FRAME: 286T
 HP: 20 HP
 RPM: 1200 BASE - 1800 MAX. SPEED
 VOLTS: 460 PHASE: 3 HERTZ: 60
 SHAFT: Ø1 7/8 KEY: 1/2 SQ.

TO REVERSE DIRECTION, REWIRE MOTOR FEED.

QTY	PART NO.	DESCRIPTION	MATERIAL	ITEM
16	NW00032-1368	1/2 STD WASHER	316 STST	13
8	NNH0032-1368	1/2-13UNC HEX NUT	316 STST	12
8	NXS0157-1368	1/2-13UNC X 1 3/4 LG HEX HD CAP SCR	316 STST	11
1	004467N02-10	GUARD		10
12		1" STD WASHER	STEEL	9
6		1"-8UNC HEX NUT	STEEL	8
6		1" X 8UNC X 4 LG HEX HD CAP SCR	STEEL	7
8	17078-03	WASHER		6
8		3/4-10UNC X 2 1/2 LG HEX HD CAP SCR GR5	STEEL	5
4	M550081-01	LAMINATED SHIMS		4
2	D550356-11	TORQUE ARM MOUNTING PIN		3
1	001149N02-10	TORQUE ARM BRACKET		2
1	A12935-886	REDUCER		1

STOCK LIST - 003929N02-10

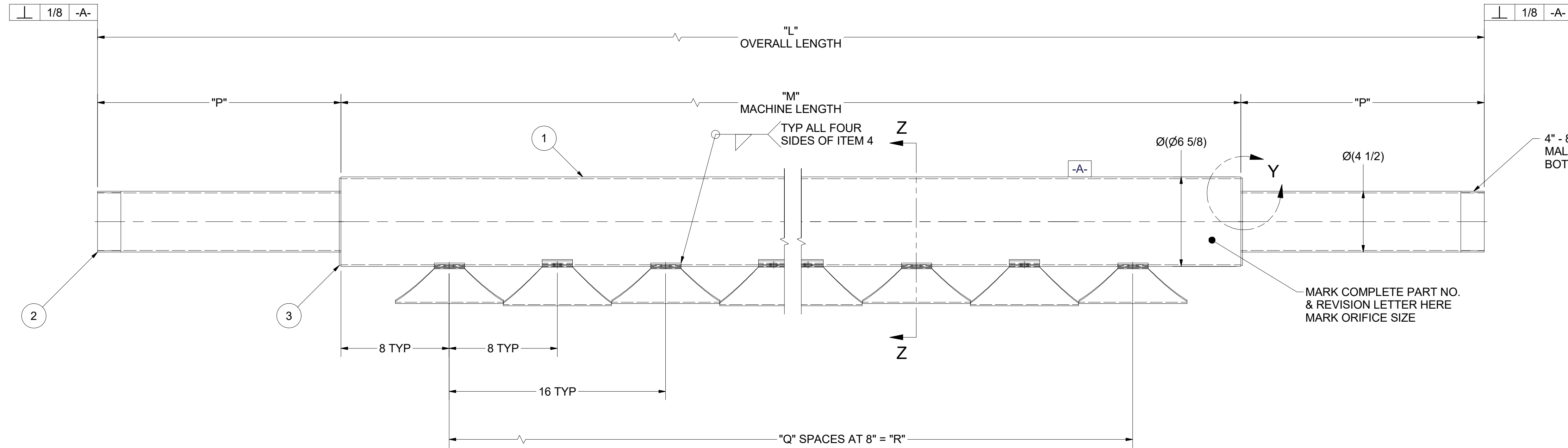
REV	DESCRIPTION	DATE	DRAWN BY	CHECKED	APPROVED
C	ITEM 1, A12935-886 WAS A12935-823. ADDED ITEMS 11, 12 & 13.	06-JAN-2022	P.O'BRIEN	P.O'BRIEN	P.O'BRIEN
B	ADDED ITEM 10.	31-AUG-2015			RCS
A	20 3/8 WAS 16 1/2. VAT END UPDATED.	20-MAY-2014			LHS
0	INITIAL RELEASE.	14-MAY-2014	LH SMITH	LH SMITH	LH SMITH

Revision	Project Number	Reason For Issue
1	003929N02	RELEASED FOR MANUFACTURE

Reference Drawing	Scale	Weight	Sheet	Drawing No	Rev
001161N02	NONE		1 of 1	003929N02	C

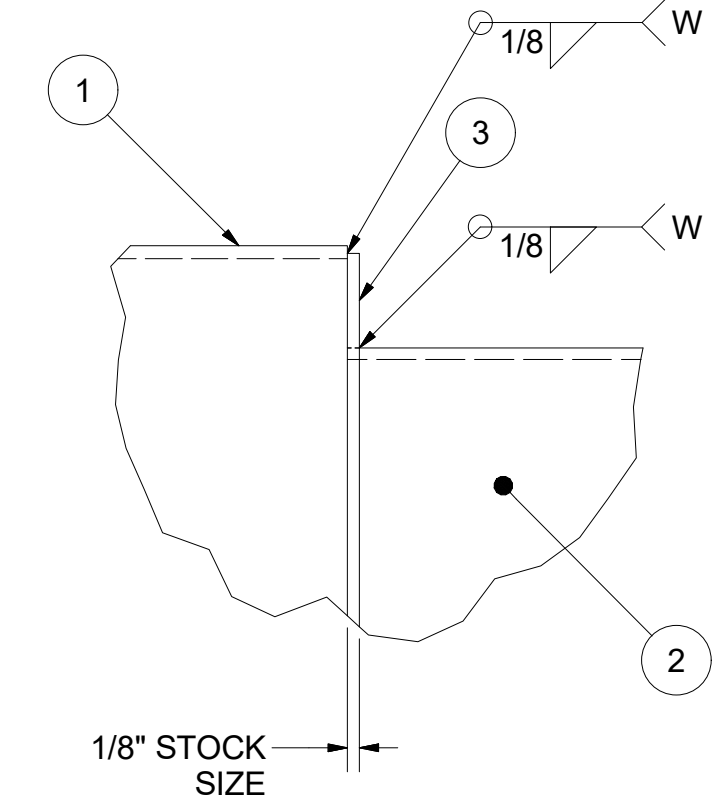
Valmet

STOCK LIST - 006735N02-SEE TABLE				
QTY	PART NUMBER	DESCRIPTION	MATERIAL	ITEM
1		6" SCH. 10 PIPE (0.134" WALL) X "M" LG.	SEE TABLE	1
2		4" SCH. 40 PIPE (0.237" WALL) X "S" LG.	SEE TABLE	2
2		1/8" X 4 1/2" I.D. X 6 15/32" O.D.	SEE TABLE	3
"T"	SEE TABLE	UFM SHOWER LIP		4



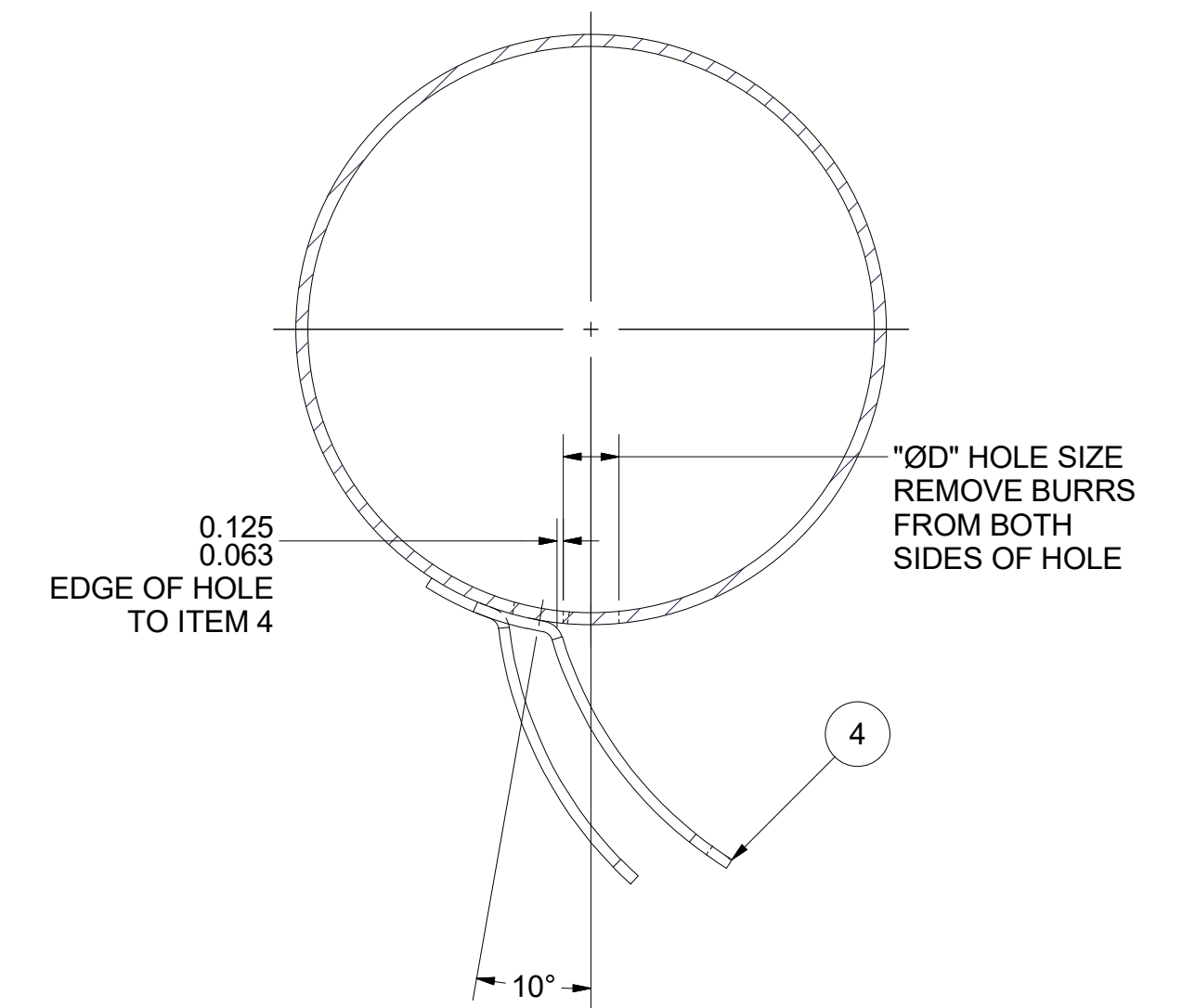
4" - 8 NPT MALE THREAD BOTH ENDS

MARK COMPLETE PART NO. & REVISION LETTER HERE
MARK ORIFICE SIZE



DETAIL Y
(TYP BOTH ENDS)

PART NUMBER	PART NUMBER ITEM 4	MATERIAL ITEMS 1, 2 & 3	"D"	"L"	"M"	"P"	"Q"	"R"	"S"	"T"	ADDED BY
006735N02-10	001456N02-03	S1343-1	7/16"	23'-0"	20'-0"	18"	28	224"	18"	29	
006735N02-11	001456N02-03	S1343-1	5/8"	23'-0"	20'-0"	18"	28	224"	18"	29	
006735N02-12	001456N02-03	S1343-1	3/4"	23'-0"	20'-0"	18"	28	224"	18"	29	
006735N02-13	001456N02-03	S1343-1	7/16"	26'-8"	22'-0"	28"	31	248"	28"	32	POB 12/01/2021
006735N02-14	001456N02-03	S1343-1	9/16"	26'-8"	22'-0"	28"	31	248"	28"	32	POB 12/01/2021
006735N02-15	001456N02-03	S1343-1	5/8"	26'-8"	22'-0"	28"	31	248"	28"	32	POB 12/01/2021
006735N02-16	001456N02-03	S1343-1	11/16"	26'-8"	22'-0"	28"	31	248"	28"	32	POB 12/01/2021
006735N02-17	001456N02-03	S1343-1	13/16"	26'-8"	22'-0"	28"	31	248"	28"	32	POB 12/01/2021
006735N02-18	001456N02-03	S1343-1	9/16"	20'-2"	16'-0"	25"	22	176"	25"	23	POB 05/04/2023
006735N02-19	001456N02-03	S1343-1	11/16"	20'-2"	16'-0"	25"	22	176"	25"	23	POB 05/04/2023
006735N02-20	001456N02-03	S1343-1	7/8"	20'-2"	16'-0"	25"	22	176"	25"	23	POB 05/04/2023
006735N02-21	001456N02-03	S1343-1	3/8"	23'-0"	20'-0"	18"	28	224"	18"	29	POB 02/21/2024



SECTION Z-Z
HOLES TO BE STAGGERED
10 DEGREES AS SHOWN

CERTIFIED CORRECT
CUSTOMER: GEORGIA-PACIFIC LLC - CEDAR SPRINGS, GA
P.O. NO.: 02113681
SERIAL NO. 23H9676
EQUIPMENT NO. M15-6510
S.O. NO. N209282
TOP LINER 1ST STAGE WASHER
DATE: 28-MAY-2024 BY: M.KUBA

CUSTOMER SIGNATURE
 APPROVED _____ PRINT NAME
 APPROVED AS NOTED _____ SIGNATURE DATE

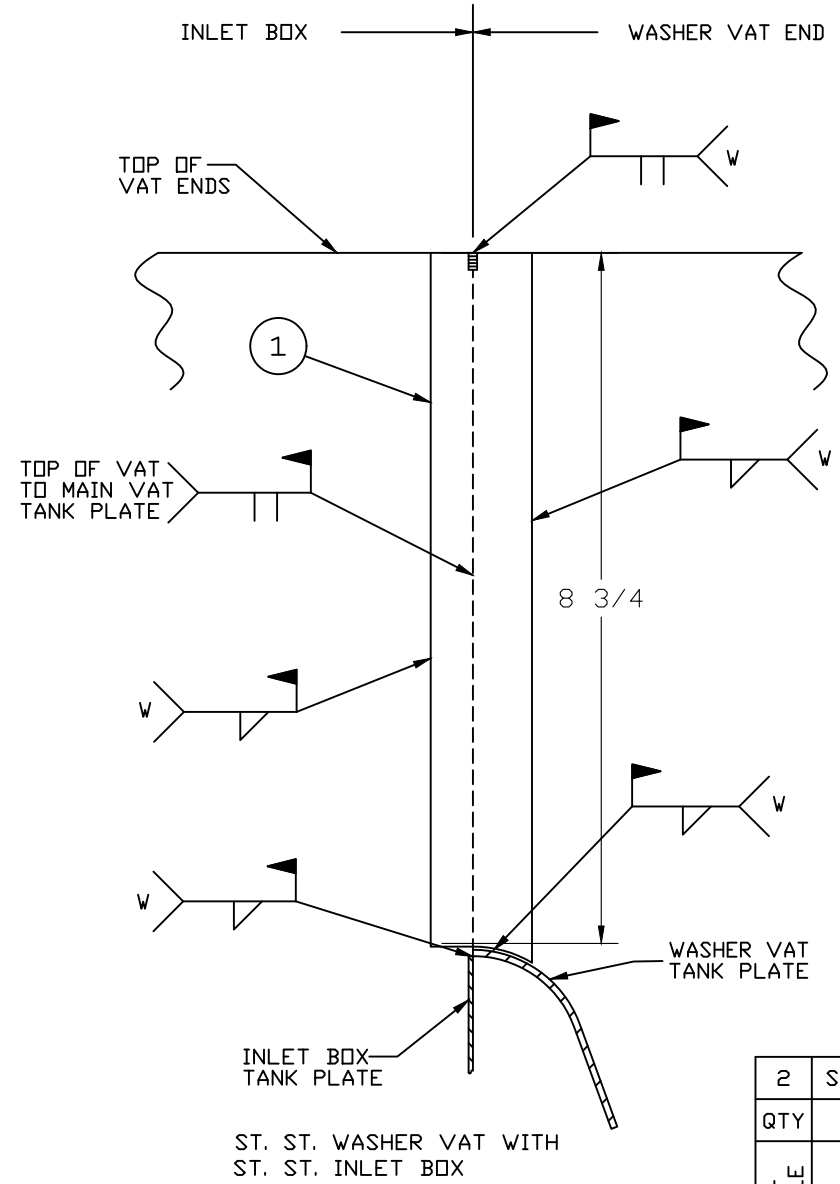
REV	DESCRIPTION	DATE	DRAWN	CHECKED	APPROVED
0	INITIAL RELEASE.	08-NOV-2021	P.O'BRIEN	P.O'BRIEN	P.O'BRIEN
1	TYPE "F" CHANGE: ADDED -13 THRU -17.	01-DEC-2021	P.O'BRIEN	P.O'BRIEN	P.O'BRIEN
2	TYPE "F" CHANGE: ADDED -18 THRU -20.	04-MAY-2023	P.O'BRIEN	P.O'BRIEN	P.O'BRIEN

Title Information		REVISION HISTORY	
Project Number	N191216	REMOVE BURRS & BREAK ALL SHARP EDGES	
All project Number		Reason for Issue	RELEASED FOR MANUFACTURE
Next Assembly		Scale	Weight
Reference Drawing	002138N02, 002500N02	NONE	N/A
Sheet	1 of 1	Drawing No	006735N02
Thread	E-825	Revision	0

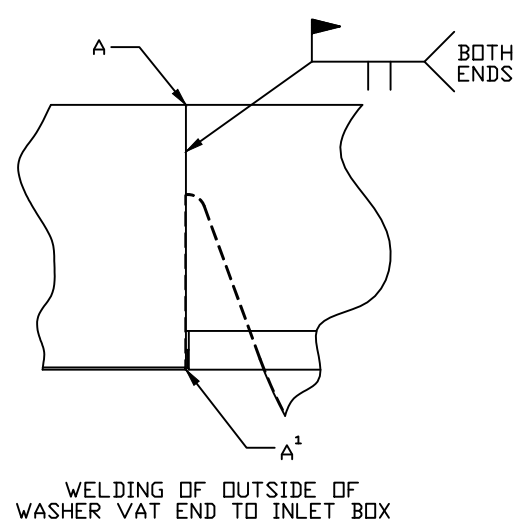
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NOTES:

1. WELDING ELECTRODE TO BE EQUAL TO OR SUPERIOR TO MATERIAL USED FOR CONSTRUCTION OF MACHINE.
2. INDICATES FIELD WELD SYMBOL.
3. INDICATES WATER TIGHT WELD.
4. IMPORTANT-ALL ST. ST. PIECES MUST BE WELDED IN PLACE PRIOR TO INSTALLING CYLINDER IN VAT.
5. WHEN SETTING VAT IN POSITION, CHECK DIMENSIONS AT POINTS A & A BETWEEN VAT ENDS. THESE DIMENSIONS SHOULD BE EQUAL. JACK VAT AS REQUIRED. CHECK DIAGONALS TO ASSURE VAT SQUARENESS. IF DIMENSIONS OF MAIN VAT & INLET BOX ARE NOT EQUAL, BALANCE VATS UNIFORMLY AT EACH END PRIOR TO WELDING.



REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED



PART NO.	MATERIAL	ITEM 1
G010295-180	S1343-1	R010162-13
-181	S1363-1	R010162-15
-182	S1373-1	R010162-16
-184	S1901-1	R010162-19
-185	S1202-1	R010162-41
-186	S1343-1	M012390-02

CERTIFIED CORRECT
 CUSTOMER: GEORGIA-PACIFIC LLC - CEDAR SPRINGS, GA
 P.O. NO.: 02113681
 SERIAL NO. EQUIPMENT NO. S.D. NO.
 23H9676 ORIG. S/N: N209282
 M15-6510
 TOP LINER 1ST STAGE WASHER
 DATE: 28-MAY-2024 BY: M.KUBA

CUSTOMER SIGNATURE
 APPROVED _____
 PRINT NAME
 APPROVED _____
 AS NOTED SIGNATURE DATE

QTY	PART NO.	DESCRIPTION	ITEM
2	SEE TABLE	ST. ST. BRIDGING STRIP	1
(HIGH INLET) STOCK LIST			

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN **INCHES**

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ANSI Y14.5 SYMBOLS		UNLESS OTHERWISE SPECIFIED, THE FOLLOWING STDS. APPLY DIM & TOL - ANSI Y14.5 SURFACE FINISHES-ISO 1302 ALL DIM APPLY TO FINISHED PART		NEXT ASSY.	
SYM	GEOMETRY			REF.DWG.	
	TRUE POSITION	REMOVE ALL BURRS AND SHARP CORNERS AND COUNTERSINK ALL TAPPED HOLES TO MAJOR DIAMETER		L010045	
	FLATNESS			DATE	3-17-98
	PERPENDICULARITY			CHECKED	JAD
	PARALLELISM			DATE	3-20-98
	ANGULARITY			APPROVED	JAD
	RUNDUT			DATE	3-20-98
	PROFILE OF A SURFACE				
	ROUNDNESS				
	STRAIGHTNESS				
	CONCENTRICITY				
	MAX MATL CONDITION				
	CYLINDRICITY				

Valmet

NASHUA N.H.

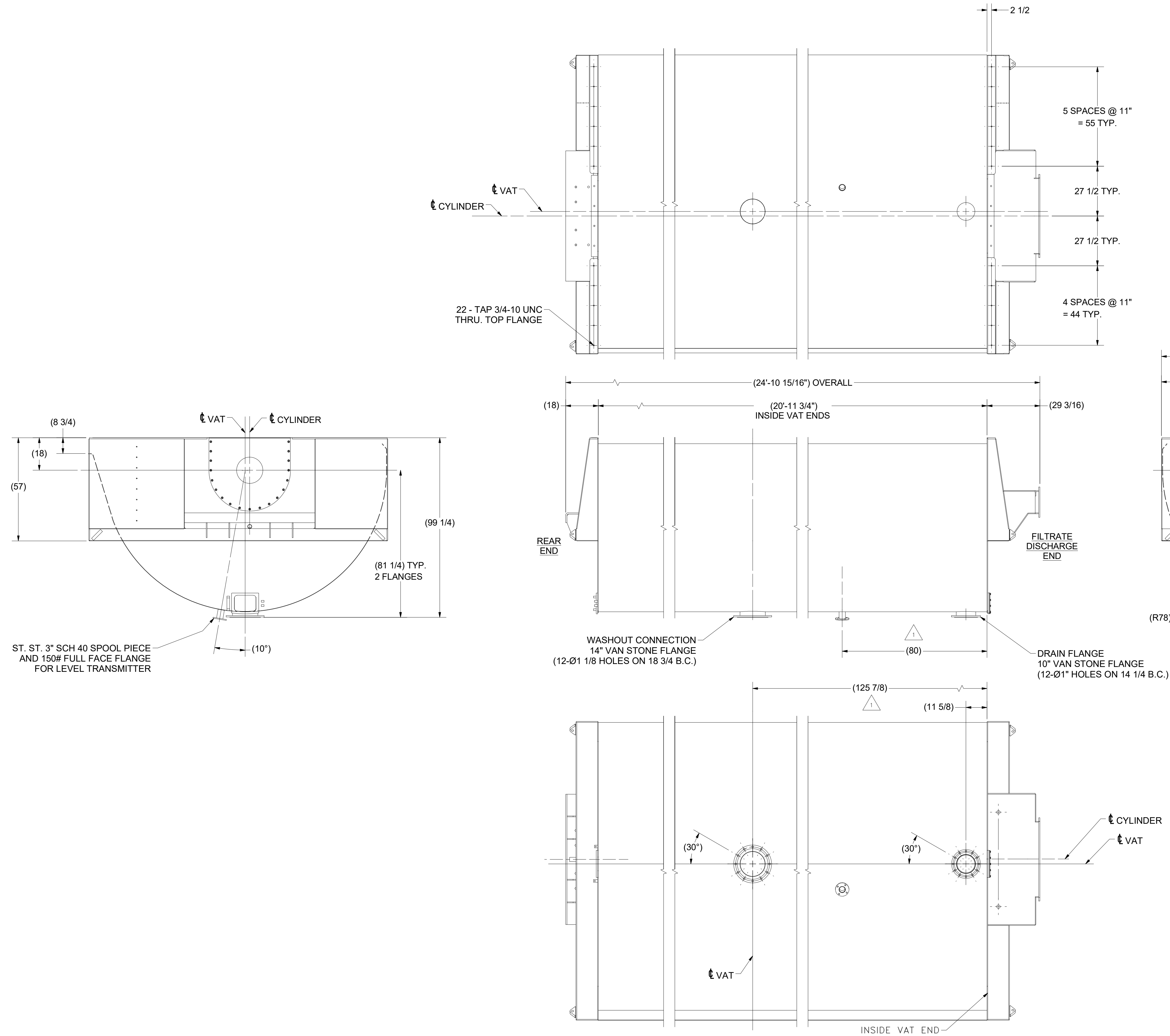
TITLE: VACUUM WASHER FIELD WELDING INSTRUCTIONS

DRAWN GFW DATE 3-17-98
 CHECKED JAD DATE 3-20-98
 APPROVED JAD DATE 3-20-98

SIZE: C THIRD ANGLE PROJECTION DRAWING NO. G010295 REV:

SCALE: NONE COPYRIGHT VALMET INC. SHEET 18 OF

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CERTIFIED CORRECT
 CUSTOMER: GEORGIA-PACIFIC LLC - CEDAR SPRINGS, GA
 P.O. NO.: 02113681
 SERIAL NO. 23H9676 EQUIPMENT NO. M15-6510 S.O. NO. N209282
 TOP LINER 1ST STAGE WASHER
 DATE: 28-MAY-2024 BY: M.KUBA

CUSTOMER SIGNATURE

APPROVED _____ PRINT NAME
 APPROVED _____ SIGNATURE DATE
 AS NOTED

REV	DESCRIPTION	DATE	DRAWN	CHECKED	APPROVED
1	D/P CELL FLANGE MOVED, VIEWS UPDATED. DIMENSION (80) WAS (54). WASHOUT DIMENSION MOVED	24-MAY-2024	M.KUBA	JAD	P.O'BRIEN
0	INITIAL RELEASE	28-MAR-2024	M.KUBA	JAD	P.O'BRIEN

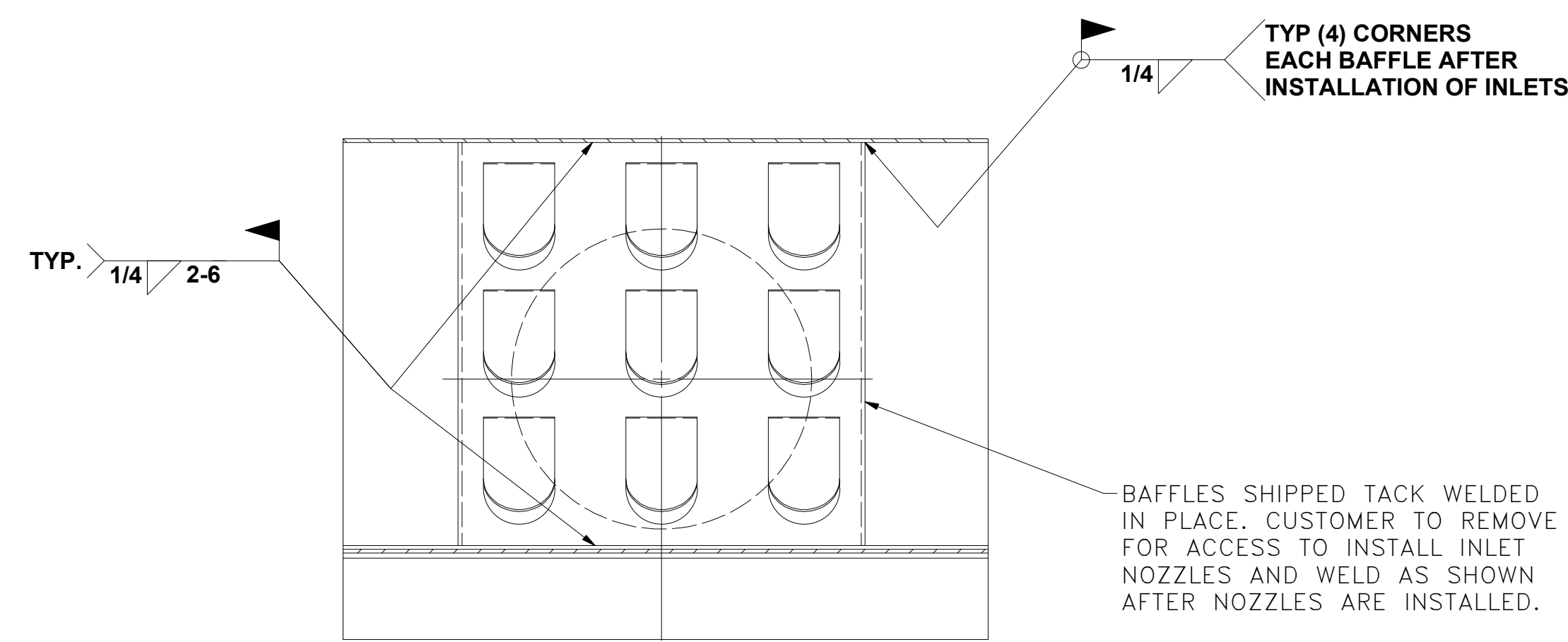
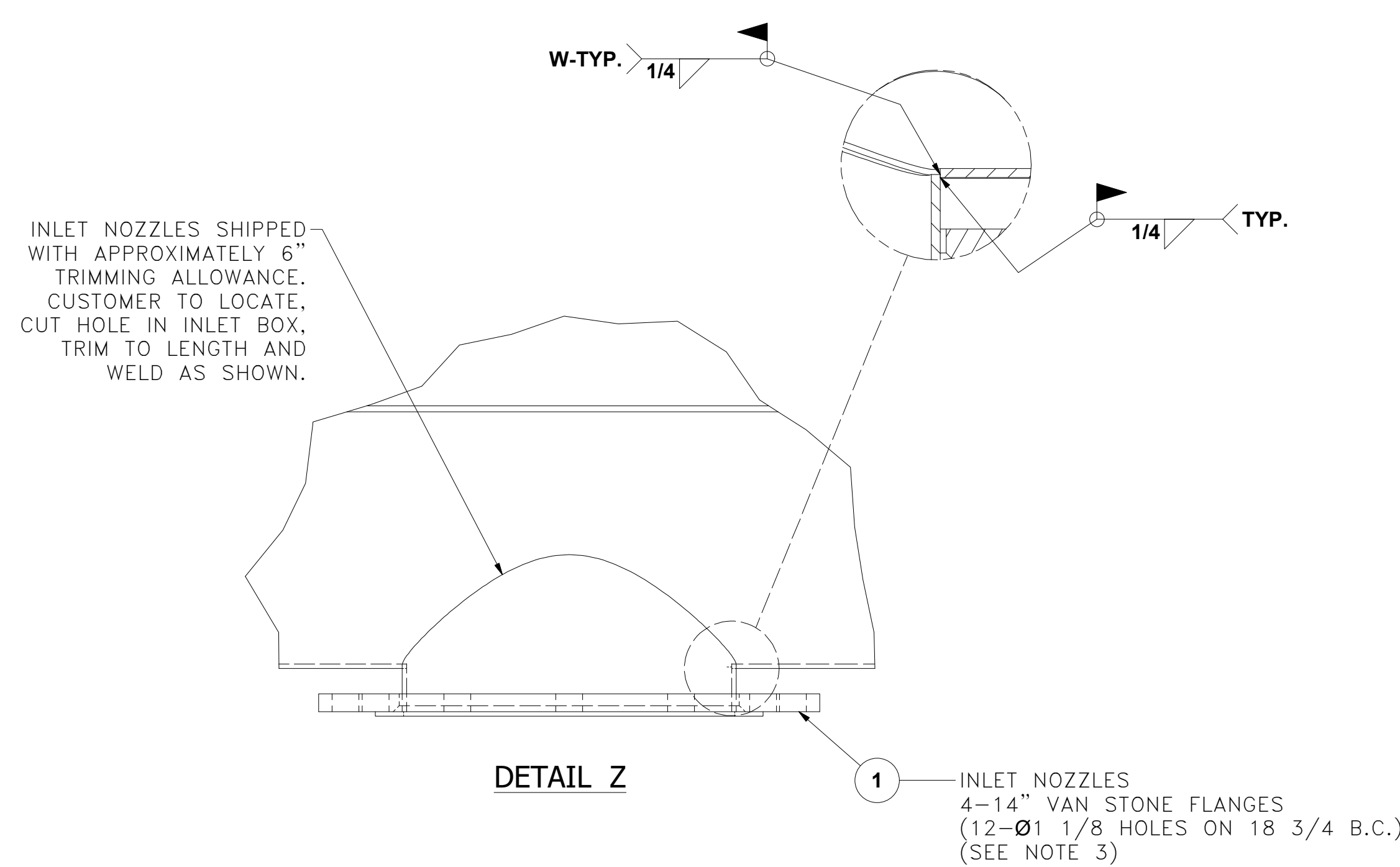
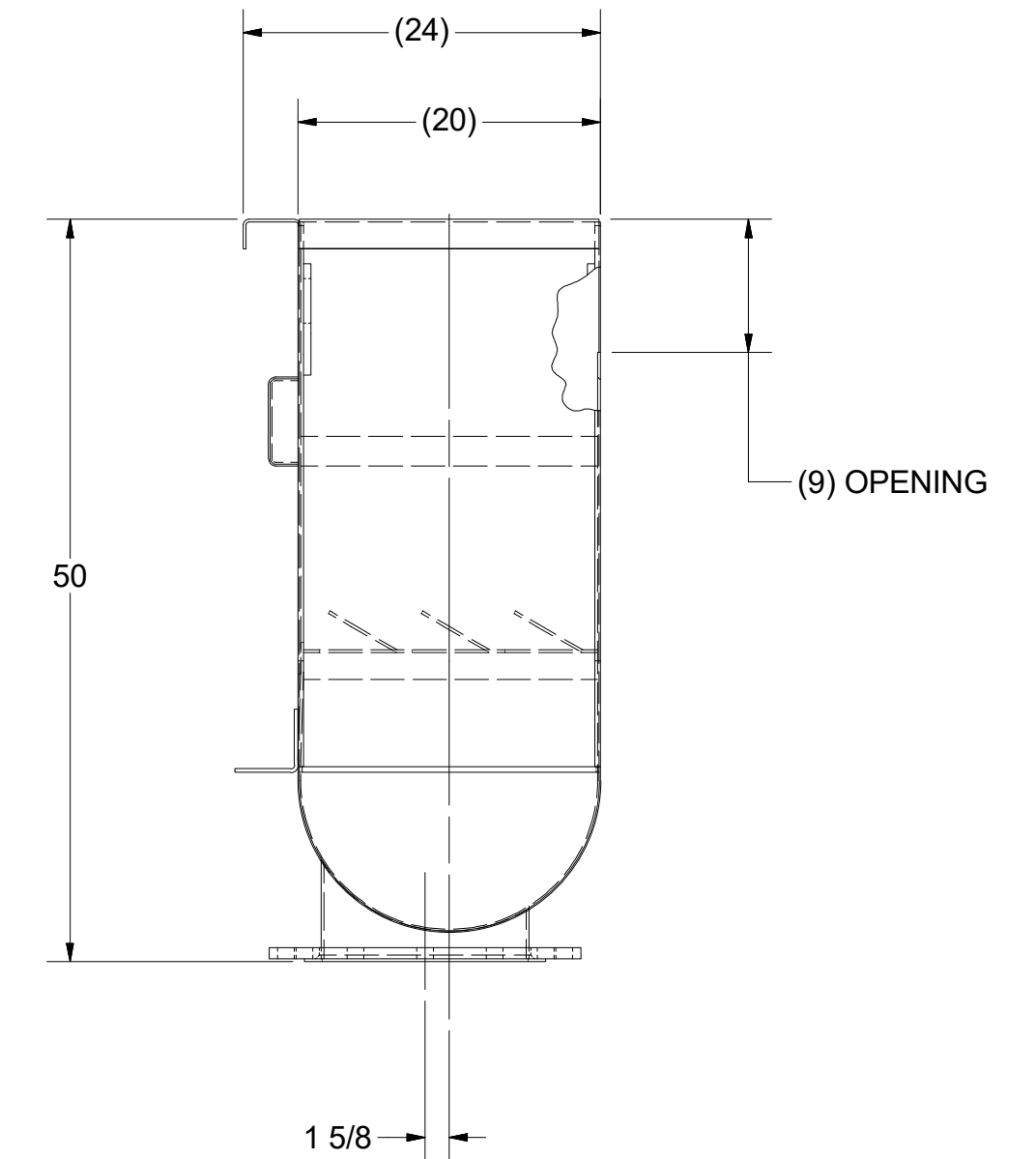
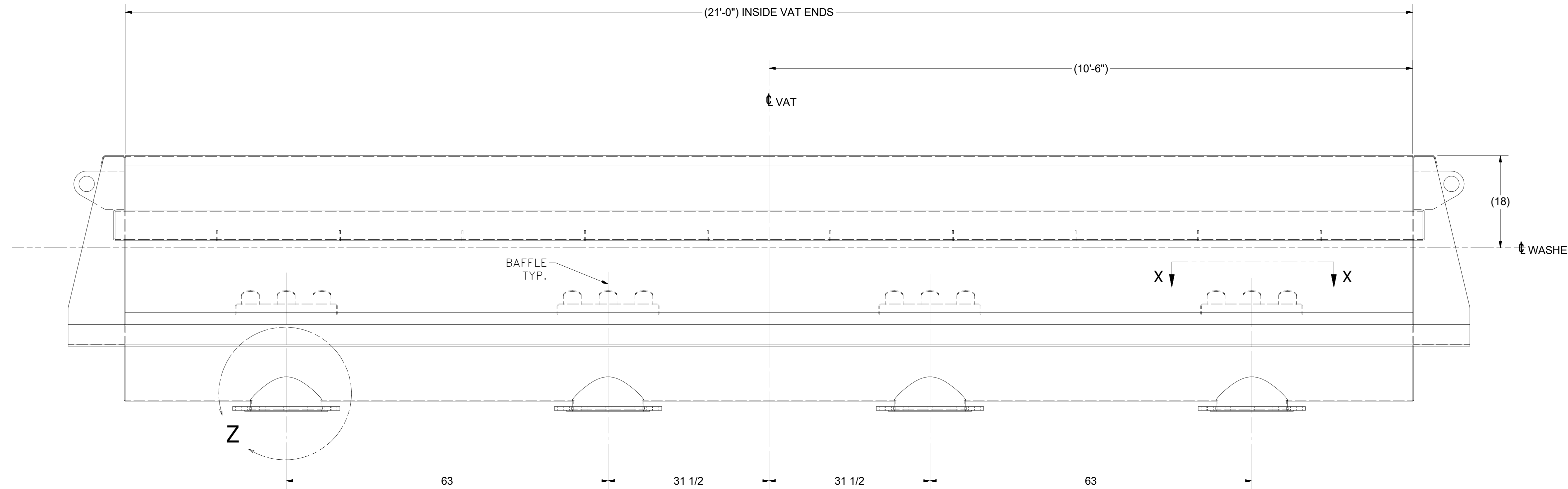
Title Information		Project Number		REMOVE BURRS & BREAK ALL SHARP EDGES
VACUUM WASHER		N209282		
Ø11'-6" X 20' LG. CORU-DEK V		All project Number		Reason for Issue
MAIN VAT GENERAL ARRANGEMENT		Next Assembly		RELEASED FOR MANUFACTURE
DORR-OLIVER REPLACEMENT		Reference Drawing	Scale	Weight
R.H. DISCHARGE		NAS0200210	NONE	11510 lbmass
Sheet		Drawing No		Revision
E-825		1 of 2 NAS0200428		1



STOCK LIST - NAS0200431-10				
QTY	PART NUMBER	DESCRIPTION	MATERIAL	ITEM
4	D548331-70	INLET NOZZLE	S1343-1	1

NOTES:

- INDICATES FIELD WELDING (BY CUSTOMER).
"W" INDICATES A WATERTIGHT WELD.
- WELDING ELECTRODE TO BE EQUAL TO OR SUPERIOR TO MATERIAL OF CONSTRUCTION.
- ALL CUSTOMER'S PIPING MUST BE INDEPENDENTLY SUPPORTED. PIPING MUST NOT IMPOSE A LOAD ON THE MACHINE.
- USE ONLY CERTIFIED DRAWINGS FOR CONSTRUCTION. THE DRAWING IS CERTIFIED FOR THE MECHANICAL EQUIPMENT SUPPLIED BY VALMET ONLY.



CERTIFIED CORRECT
 CUSTOMER: GEORGIA-PACIFIC LLC - CEDAR SPRINGS, GA
 P.O. NO.: 02113681
 SERIAL NO. 23H9676
 EQUIPMENT NO. ORIG. S/N: M15-6510
 S.O. NO. N209282
 TOP LINER 1ST STAGE WASHER
 DATE: 28-MAY-2024 BY: M.KUBA

CUSTOMER SIGNATURE
 APPROVED _____ PRINT NAME
 APPROVED AS NOTED _____ SIGNATURE DATE

REV	DESCRIPTION	DATE	DRAWN	CHECKED	APPROVED
0	INITIAL RELEASE	03-APR-2024	M.KUBA	MAT	P.O'BRIEN

Title Information		REVISION HISTORY	
Units: INCH	Welding: E-4000	Project Number: N209282	REMOVE BURRS & BREAK ALL SHARP EDGES
Tolerances: E-2167	Thread: E-825	All project Number:	Reason for Issue: RELEASED FOR MANUFACTURE
Valmet		Reference Drawing: 004993N02, NAS0200386	Scale: NONE Weight: N/A Sheet size: D
Sheet: 1 of 1		Drawing No: NAS0200431	Revision: 0

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