MEC-FAB INC.

1401 GRAHAM BELL, BOUCHERVILLE, QUÉBEC, CANADA J4B 6A1
TÉL.: (514) 655-7910 • FAX: (514) 655-5189

QUOTATION No. 9776

August 18, 1994

Appleton Papers Inc.
100 Paper Mill Road
Roaring Springs, PA 16673
USA

Attention: Mr. Mark Taylor

C.c.: Mr. John Michels

Your Ref.: 94-4095-FMEM-001

Project: Appleton Papers Inc.
Paper Machine No.3. Fourdrinier Replacement
Marathon Project No. 94-4095.

Our Ref. 9776

Gentlemen:

Further to your request for pricing for a new fourdrinier replacement for the No.3. paper machine, we are pleased to enclose the following proposal.

We certify that the equipment quoted in this proposal conforms fully in every respect with the specifications, forms and drawings submitted to us in your inquiry dated July 27th/1994.

We trust that this proposal meets with your approval and we look forward to working with you on this project.

Yours very truly,
MEC-FAB Inc.

Richard Sénécal
Sales Representative

RS/am

DESIGN CRITERIA

Grades	Fine paper, Carbonless base paper
Type of Fourdrinier	"C Frame" design
Basis weight variations	30# - 60# / 3,300 sq. ft.
Wire width	87"
Machine speed	1050 FPM
Design speed	1500 FPM
Wire	Horizontal - no incline
Shake	Breast roll will shake. Table does not shake.
Materials	Mild steel with 316L cladding Option in S/S 316L solid. Option in S/S 304L solid.
Top of sole plate to wire	48"
C/L couch - C/L breast roll	31'5" or 377"
Breast roll diameter	18"
Wire tension	Design 25 PLI
Between sole plates	94"
Sole plates	14"
Drainage elements	Re-use

FOURDRINIER

We propose to design and supply to Appleton Paper a "C Frame" design fourdrinier. This fourdrinier will have a horizontal wire with no incline. There will be a shake on the breast roll only.

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The fourdrinier will be designed and built of mild steel plate and cladded with Stainless Steel 316L. This material will withstand high alkaline Ph values of 12 as well as acidic Ph value of 3.5. The journals of all rolls will be high tensile steel. All fabricated members will be stress relieved after welding.

DRAINAGE ELEMENTS

All drainage elements will be re-used. Provision will be made to adapt your existing drainage elements on dovetails which will be welded to the main beams.

MAIN BEAMS

Two (2) box section 316L stainless steel cladded beams will be provided. Each will incorporate a dovetail arrangement for mounting table components. The breast roll end of each main beam will be equipped with pivot brackets for supporting the breast roll arms. Six (6) cross ties in stainless steel 316L will be installed between these beams. The main beams will be fabricated with 3/4" plate to give sufficient rigidity for the 25 pli requipment.

CROSS BEAMS

Two (2) cross machine "C" beams will be provided. Beams will be fabricated with mild steel plate. Necessary brackets to secure main beams with cross beams will be included. Both the top beam and bottom "C" beam will be clad with Stainless Steel 316L.

Two (2) front pull blocks for supporting the open ends of the "C" beams will be provided. These blocks will be made in aluminum. The blocks will have keyways and swing bolts will lock the blocks in place.

The "C" beams will be pre-stressed so that jacks will not be required to remove the pull blocks.

SAVEALL PANS

The savealls will be fabricated in stainless steel 316L. Material will be 11 gage. They will be well supported with minimum deflection.

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There will be a pan under the suction boxes. The pan for the gravity drain foil beams and forming board will drain to one central location between the existing wire foundations. The downleg will return all white water to the wire pit. The downleg will be fabricated with 11 gage stainless steel 316L.

The welds on all savealls and pans will be ground smooth and polished to 20 micro-inch finish which will easily pass a "cotton ball" test.

WIRE ROLLS, STRETCHER ROLL, GUIDE ROLL

OPTION. Rolls are priced separately.

Mec-Fab Inc. will supply one (1) guide roll, one (1) stretcher roll and three (3) wire rolls. Each roll will be 6" pipe and have 92" face for your 87" wire. Each roll will be balanced dynamically for 1500 FPM. All rolls will be completely interchangeable.

All rolls will be rubber covered with a 0.250" rubber cover. They will have a hardness of 0 - 1 P&J.

All rolls will be designed for a 25 PLI tension rating at 1500 FPM.

Bearing housings and bearings will be supplied. Bearing housings will be supplied in 316S/S.

The spherical roller bearings and needle bearings on each roll will be grease lubricated. All required bracketing for the rolls will be supplied.

All journals of wire rolls will be made of high tensile steel to increase life of rolls.

AUTOMATIC WIRE GUIDE AND HAND GUIDE

A Thune automatic wire guide will be supplied and installed on the tending side of the guide roll. The guide will be supplied with bearing housing type arrangement for guide roll mounting. A controller will be supplied with a palm in either stainless steel 316 or ceramic coated.

A Thune hand guide will be furnished on tending side of the machine. Either a ratchet or wheel can be supplied.

FABRIC STRETCHER ASSEMBLY

The fabric stretcher assembly will be furnished with an air motor on the drive side and two (2) screw operated jacks. The stretcher will be designed for a maximum 25 PLI fabric tension.

Fabricated stainless steel stretcher arms are attached to a pipe type cross shaft. The pivot bearings are bronze bushings installed in stainless steel housings. A stop bracket is supplied for installation on the fourdrinier base plates.

The stretcher will be a push type of stretcher similar to drawing supplied. The cylinders will push the wire roll to achieve greater force for your 25 PLI wire tension.

BREAST ROLL LOWERING UNIT AND SHAKING BREAST ROLL ARRANGEMENT

Roll will be retracted for fabric installation by means of air motor operated cross shaft connected jacks located on the front and back sides of the fourdrinier.

Two (2) 5 ton Benzler precision anti-backlash, self locking jacks will be supplied to control the retraction and raising movements of the breast roll. These
jacks will be attached to the tending and drive side main fourdrinier beams by means of stainless steel pivot brackets and pivot pins.

A solid S/S cross shaft will be coupled to the front and back jacks to synchronize the movement of both sides of this retraction and raising mechanism. On the tending side, a hand wheel will be mounted and keyed to the jack worm screw for the machine tender's use.

Rubber boots will be supplied to protect the jack threaded spindles. The ends of the tending and drive side jack spindles will be equipped with stainless steel eyes which are pinned to each jack spindle. These eyes are attached to the breast roll arms by means of stainless steel pivot pins.

Stainless steel lock stands will be installed on the tending and drive side base plates of headbox apron beam to secure the breast roll and arm assembly in the raised position by means of a bracket arrangement suitable for weight of breast roll and PLI of 25 under dynamic conditions.

Mec-Fab Inc. will supply bracket arrangement from shake unit to breast roll. As an option, Duff Norton jacks can be supplied.

OSHA

The "C Frame" fourdrinier will conform to and meet all Osha regulations.

DOCTORS

Mec-Fab Inc. will supply a breast roll doctor. This doctor will be mounted to main swing arm with set of brackets. This doctor will be spring loaded with a polyethylene blade and a Thermo-AES holder.

All doctors will be re-used. New bracketing fabricated in Stainless steel 316L will be supplied for all doctors.

FASTENERS

All fasteners and anchor bolts will be supplied in stainless steel Type 18 - 8 or better as is appropriate for the function.

BRACKETS

All brackets and stands for mounting wire rolls, doctors, showers, etc. will be supplied. These will be made in stainless steel 316L.

The frame will be drilled as required for dandy. This will be determined when designs are finalized and if you take the option of a new dandy.

CORROSION PROTECTION

All fabricated stainless steel components will be treated with a passivating solution, glass beaded as required after all welding, grinding and drilling work completed to remove contaminants and create a clean surface.

ENGINEERING

Mec-Fab Inc. will do all required engineering and all necessary arrangement and mounting drawings. All dimensions will be verified at mill by Mec-Fab Inc. We will need machine stoppage of at least one (1) day to take required dimensions.

Required sets of drawings will be sent to Appleton Paper and Marathon before work commences. As time is limited, Mec-Fab Inc. would expect briefest delay before work commences after drawings have been sent for approval.

All drawings will be made using Auto-Cad version 12. Required sepias and drawings will be sent to mill as well as Marathon. Diskettes of 3½" will also be supplied.

INSPECTION

The fourdrinier will be fully assembled on our shop floor. All items provided by others such as showers and doctors will be installed on the fourdrinier and all supplied equipment from buyer will be made compatible before fourdrinier is shipped.

Mec-Fab Inc. invites the buyer at any time during the course of this contract to view the fourdrinier.
Parts will be photographed and parts match-marked for installation by the contractor. A drawing will be supplied for wire run and the length will be measured by tape after it is erected on floor.

The fourdrinier will be ready for shipment within 6 months after receipt of order.

MANUALS

Mec-Fab Inc. will provide nine (9) manuals with six (6) sets of prints, sepias of the fourdrinier and its individual parts, rolls, bearings, frame details, swing arm assembly, stretcher assembly.

The manuals will contain all information required regarding wire guides, jacks, etc. Manuals will detail source and part numbers of all pertinent parts required for operation. Part numbers and drawings of fabricated items will be supplied.

Drawings and plans of the fourdrinier will be supplied giving all details such as material, quantity, type, supplier, grades, materials, etc. and where these items go.

PERFORMANCE GUARANTEE

Mec-Fab Inc. guarantees that the "C Frame" fourdrinier will operate within the parameters set forth in the fourdrinier design data in this proposal. We also guarantee parts against defects in material and workmanship for a period of one (1) year from date of acceptance.

ERECTION AT MILL

You are invited at any time to view our progress and you can rest assured that this fourdrinier will be delivered on time with superior workmanship.

The erection of the "C Frame" fourdrinier at the mill is the responsibility of the mill.

Mec-Fab Inc. will send to the mill a supervisor at the time of installation to facilitate erection process. This will be for erection and start up. This is included in the cost.

A fee of $ 700.00 U.S. per day plus expenses would only be charged if we must be at the mill while contractor is delayed or project is put off through no fault of Mec-Fab Inc.

FOURDRINIER FABRIC INSTALLATION

The following general steps will be taken in the replacement of the fabric on this fourdrinier:

1' Retract the breast roll assembly
2' Remove "C" beam pull blocks
3' Lower stretch roll assembly
4' Cantilever couch roll
5' Cantilever catwalk
6' Remove old fabric
7' Reverse procedure 1 - 5 and lock up breast roll arms. This procedure should take about one hour.

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COUCH ROLL

The existing couch roll will remain as is and will not interfere with the mounting of the fourdrinier.

GENERAL NOTES IN REFERENCE TO YOUR RFQ

1) The fourdrinier supplied will maintain existing distance between centerline of couch to center line of breast roll.

2) The wire height will remain the same as existing.

3) The fourdrinier that is supplied will be capable of using in future multiple layer fabrics.

4) The forming board will be re-used. It will be positioned on the swing arms of the breast roll and will not have to removed during wire change.

5) The Huyck vacuum foils will be re-used.

6) The Huyck suction boxes will be re-used.

7) Space will be provided for the four flatboxes on the fourdrinier and they will be properly mounted under wire.

8) Separate pricing is given with this proposal for a dandy roll which will be of J.J. Plank design.

9) The deckle will be re-used. Pricing for PSI hydro flow will follow as option.

10) Your existing cantilevered couch will be re-used.

11) Your existing doctors will be re-used. New brackets will be supplied for your existing doctors and this is included in base price.

12) The Thune automatic guide is included in the base price. Please advise if pillow block type or bearing housing is preferred.

13) The Thune hand guide is included in the base price. Please advise if ratchet or wheel is preferred.

14) The breast roll doctor will be supplied new and is included in base price. The breast roll doctor will have face of 91" with a blade type polyflex - .25" x 3" x 91" long. The blade holder will be Accumate type

and material will be Stainless Steel 316. The doctor back will be supplied in Stainless Steel 316L. The journals will be 1-3/4" diameter. Loading will be by pressure rig. The mounting brackets will be supplied in Stainless 316L.

15) For your particular application, we do not feel it would be necessary to put in a wire turning roll. This would be used principally for a higher speed machine. The second reason would be for sheet transfer or sheet pick up.

16) The wire return rolls are not included in the base bid. However, new Stainless Steel bearing housings are included as well as the bearings. All doctors for wire rolls will be re-used. New Stainless Steel brackets will be designed and supplied. We have quoted new rolls as an option. All new rolls supplied would be interchangeable. The new rolls have been priced both with and without bearing housings and bearings. All rolls supplied would be balanced dynamically both before rubber covering and after rubber covering for a maximum speed of 1,500 FPM.

17) The knock-off and wire roll showers would be- re-used. New brackets would be supplied as required. In the list of options, pricing for new knock-off and wire roll showers are provided. A price for a new automatic tail cutter is also supplied in list of options.

Purgable knock-off and cleaning showers used with white water are also included in list of options. These showers will be suitable for double layer wire.

18) The breast roll only will shake. The existing shake unit will be re-used. A bracket arrangement will be designed and supplied to connect your existing shake to the breast roll.

19) The existing slice and couch platform will be re-used. A new platform will be supplied for the couch. This walkway will be supplied in Stainless Steel. This walkway will be cantilevered for ease of wire change. These platforms will meet all Osha requirements.

20) New savealls will be supplied for complete fourdrinier. All savealls will be fabricated in Stainless Steel 316L.

21) A new stretcher will be supplied. This stretcher will be air operated with mechanical operated jacks. Actuators will be Benzler type and will be suitable for 25 PLI operation. Duff Norton jacks can be supplied as an option. Both jacks would be operated simultaneously using a cross shaft.

22) The sole plates will be re-used. It will not be necessary to make modifications as bottom "C" beams will be made to suit. The wire height of 48" is not a problem using our design.

PRICE

Above described "C Frame" fourdrinier. Mild steel construction with cladding in Stainless Steel 316L. Savealls made with Stainless Steel 316L.

PRICE.....$ 249,792.00 U.S.

OPTION 1

Above described fourdrinier built entirely in Stainless Steel 304L - No cladding supplied. Savealls would be in Stainless Steel 316L.

PRICE.....$ 262,792.00 U.S.

OPTION 11

Above described fourdrinier built entirely in Stainless Steel 316L including savealls.

PRICE.....$ 264,792.00 U.S.

OPTIONS

Five (5) wire rolls consisting of stretcher roll, guide roll and three (3) wire rolls. These rolls include Stainless Steel bearing housing as well as Thimkin bearings. Easch roll will be rubber covered ¼" thick 0 - 1 P & J and balanced for 1,500 FPM.

PRICE.....$ 6,850.00 U.S. EA ROLL

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PLEASE NOTE: The base price of the fourdrinier includes new bearing housings and bearings for each roll. It does not include price of new rolls.

Price for new rolls only without bearing housings in Stainless Steel 316 and bearings is:

PRICE.....$ 4,750.00 U.S. EA ROLL

THERMO AES WET END TAIL CUTTER

Wire coverage: Width: 87" and machine speed is 1,500 FPM

Construction: Support beam in type 316 Stainless Steel, complete with:

- A Stainless Steel trolley and nozzle which traverses the beam.
- A high pressure hose and flexible track assembly.
- Stainless Steel drive chain and sprockets.
- A D.C. Drive motor and gear reducer.

A rubber apron covering the slotted opening to prevent stock build up inside the beam.

Nozzle: .040"/.020" high pressure, Stainless Steel, is supplied.

Controls: Controls mounted on the tail cutter beam include the following:

- Three (3) proximity switches,
- A failsafe sensor that indicates stoppage of oscillation.

Micro-processor control panel is supplied.

PRICE.....$ 32,244.00 U.S.

DANDY ROLL

OPTIONS

MEC-FAB INC.

30" DIAMETER JOURNAL STYLE DANDY ROLL ASSEMBLY

1- Set of 30" diameter, journal, custom-designed heavy-duty dandy roll mountings for 18" diameter bearings and housings, including swing bolts and pilot pins for quick removal and realignment of the dandy roll, Firestone airstrokes, and Duff Norton stainless steel actuators with hand wheels for fine wire contact adjustment. These mountings would be constructed of cast brass.

PRICE.....$ 18,537.50 U.S

1- Integral pivot jack shaft base with 316 stainless steel cross shaft, built-in slide adjustments for ease in moving base to obtain alignment of pulley and belt tension. This unit will maintain these adjustments when dandy roll contact is changed or when roll is pnewmatically raised or lowered.

PRICE.....$ 6,362.50 U.S.

1- Rockwell 58 WB Universal drive shaft, 3-1/2" O.D. center assembly, specially modified for dandy roll use including stainless steel: companion flange, cross key and swing bolts for quick disconnect.

PRICE.....$ 6,067.50 U.S.

1- 93" face x 30" diameter triangulated stainless steel, rectangular membered, fabricated dandy roll truss including heavy-duty journal heads, HTD drive provisions, stainless steel rectangular winding wire, stainless steel spiral back and symmetrical weave surfaced face wire, dynamic balancing, and reinforced boxing.

PRICE.....$ 20,643.75 U.S.

1- Set of special 18" inside diameter Plank designed bearings (L10 life = 80 years) with Plank designed special labyrinth seal housings (no mechanical seals) including flingers and troughs to redirect water away from bearings. Tending side designed for flotation to allow for roll expansion and contraction. Drive side has held four (4) point contact ball bearing.

PRICE.....$ 17,916.25 U.S.

1- AES 316 stainless steel type 2051 self-aligning shower. Shower is double tube construction with brush arrangement provided to maintain nozzle cleanliness. Nozzles are #66 drill needle jet on 1-1/2" centers with 3" electro-mechanical oscillation from Model EMO111SP oscillator. The double tube arrangement allows easy slide-out inner pipe removal for maintenance.

PRICE.....$ 15,521.25 U.S.

MEC-FAB INC.

1- AES water shower strainer with gauges and blow down valve.

PRICE.....$ 1,375.00 U.S.

1- Crowned internal save-all pan with double drains and custom brackets. Constructed of type 316 stainless steel.

PRICE.....$ 4,200.00 U.S.

1- 316 stainless steel extended header steam shower which aids in cleaning the roll and reducing water throw at outgoing nip of dandy roll. This shower also acts as a steam heated drip dissipation tube to eliminate water drops from internal save-all pan.

PRICE.....$ 2,012.50 U.S.

1- External save-all pan integral with mounts including dual lips, steam heated bottom chamber, lifting rings and custom brackets. This will include swing bolts and pilot alignment pins for independent removal, and screw type adjustments for ease in adjusting the pan in relationship to the dandy roll. Constructe of type 316 stainless stee.

PRICE.....$ 11,496.25 U.S.

1- Complete 7-1/2 h.p. Reliance DC variable speed dandy roll drive unit. (Specifications furnished upon request).

PRICE.....$ 24,750.00 U.S.

So that you would have a completely interchangeable dandy roll unit ready to be installed on the paper machine, we recommend the following spare equipment: (Specifications identical to above descriptions)

1- 93" face x 30" diameter dandy roll.

PRICE.....$ 20,643.75 U.S.

1- Set of 18" diameter bearings and housings.

PRICE.....$ 17,916.25 U.S.

1- Water shower.

PRICE.....$ 14,365.00 U.S.

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1- Internal save-all pan.

PRICE.....$ 4,200.00 U.S.

1- Steam shower.

PRICE.....$ 2,012.50 U.S.

30" DIAMETER TRUNNION STYLE DANDY ROLL ASSEMBLY

1- Complete set of 30" diameter trunnion dandy roll mountings with Firestone air strokes, controls, Duff Norton wheel actuator for fine wire contact adjustment, indicator gauges, nylon lower and guide trunnions. Constructed of cast brass.

PRICE.....$ 10,131.25 U.S.

1- Integral Jack shaft pivot base, including pillow blocks, stainless steel cross shaft and slide adjustment.

PRICE.....$ 6362.50 U.S.

1- Rockwell 58 WB Universal drive shaft specially modified, including stainless steel companion flange and swing bolts.

PRICE.....$ 6,067.50 U.S.

1- 93" face x 30" diameter stainless steel fabricated trunnion dandy roll with stainless steel winding wire, stainless steel spiral covers, dynamic balancing and reinforced boxing.

PRICE.....$ 15,763.75 U.S.

1- 316 stainless steel type 2051 self-aligning shower. Shower is double is double tube construction with brush arrangement provided to maintain nozzle cleanliness. Nozzles are #66 drill needle jet on 1-1/2" centers with 3" electro-mechanical oscillation from Model EMO111SP oscillator. The double tube arrangement allows easy slide-out inner pipe removal for maintenance.

PRICE.....$ 15,521.25 U.S.

1- Water shower strainer.

PRICE.....$ 1,375.00 U.S.

MEC-FAB INC

1- Internal save-all pan and custom brackets. Constructed of type 316 stainless steel.

PRICE.....$ 4,200.00 U.S.

1- Extended header stainless steel steam shower.

PRICE.....$ 2,012.50 U.S.

1- External save-all pan with steam heated bottom chamber, lifting rings and custom brackets. This will include swing bolts and pilot pins for quick removal and a screw type adjustment for ease in adjusting the pan in relationship to the dandy roll. Constructed of type 316 stainless steel.

PRICE.....$ 11496.25 U.S.

1- Complete 7-1/2 h.p. Reliance DC variable speed dandy roll drive unit. (Specifications furnished upon request).

PRICE.....$ 24,750.00 U.S.

Note: This price includes one motor pulley and one belt.

So that you would have a completely interchangeable dandy roll unit ready to be installed on the paper machine, we recommend the following spare equipment:

1- 93" face x 30" diameter dandy roll.

PRICE.....$ 15,763.75 U.S.

1- Water shower.

PRICE.....$ 14,365.00 U.S.

1- Internal save-all pan. Constructed of type 316 stainless steel.

PRICE.....$ 4,200.00 U.S.

1- Steam shower.

PRICE.....$ 2,012.50 U.S.

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SHOWERS

Please note: The base price does not include price for showers. This is priced as option.

1- Type S29 Thermo AES Stationary shower.
Application: Wire roll lubricating shower.
Design coverage: 87 inches.
Construction: 2" schedule 10 type 316L stainless steel pipe.
Nozzles (8): #2149-2 (.125" orifice) 90 degree fan spray on approx. 12" centers.
Support brackets: 316L stainless steel.
Rated flow: 19 USGPM at 40 PSI.

PRICE.....$ 2,384.00 U.S.

Option

1- Type S29 Thermo AES Stationary System.
same as item 1 except with self cleaning nozzles.

PRICE.....$ 2,688.00 U.S.

1- Type B29 thermo AES Stationary Shower.
Application: Standard Knock-off shower.
Design coverage: 87 inches.
Construction: 3" schedule 10 type 316L stainless steel pipe.
Nozzles (30): #2149-2 (.156" orifice) 30 degree fan spray on approx. 3" centers.
Support brackets: 316L stainless steel.
Rated flow: 173 USGPM at 120 PSI.

Option

1- Type S29 Thermo AES Stationary System.
same as item 1 except with self cleaning nozzles.

PRICE.....$ 4,350.00 U.S.

1- Type 2000 Thermo AES Oscillating Fresh Water Shower.
Application: High pressure wire cleaning.
Design coverage: 87" inches.
Construction: 2" schedule 10 type 316L stainless steel inner pipe mounted in a 3" schedule 10 outer pipe.

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Nozzles (28):	# 123HS (.040" orifice) jet on approx. 3" centers.
Oscillatior:	880-4, 6" stroke.
Rated flow:	19 USGPM at 350 PSI.
Control panel:	Safety shut-off relay and oscillator motion detector with terminals to accept customer supplied connections (115V/1P/60C) to shut down water supply in the event of oscillator failure or machine drive stoppage.

PRICE.....$ 6,531.00 U.S.

Option

1- Flexible hose: High pressure 1" dia. x 5 feet lg.

PRICE.....$ 369.00 U.S.

Option

1- Type 2000 Thermo AES Oscillating Fresh Water Shower. Same as item 3 except with self cleaning nozzles.

PRICE.....$ 6,531.00 U.S.

1- Termo AES Trim Squirt Shower.

PRICE.....$ 500.00 U.S.

APPLETON FOURDRINIER FLOWCHART
PROJECT SCHEDULE

Approval drawings	3 weeks
Certified drawings	2 weeks
Pre-delivery inspection	18 weeks
Full erection on our shop floor	22 weeks
Delivery to mill	6 months after order

MEC-FAB INC

Delivery	6 months
F.O.B.	Mill site Take out price for fourdrinier delivery $ 4,500.00 U.S.
Duty	Not applicable under Tariff Item 8439.20
Brokerage	Included in price
Taxes	Extra, if applicable
Terms	10% - with order 15% - 30 days - Approval drawing 15% - 60 days - Detail Drawing complete 20% - With proof of material purchased 15% - After inspection of fabrication 15% - On delivery 10% - Balance Net 30 days after start-up not exceed 60 days after delivery.

Total 26 weeks from order date.

The payments will be tied to a mile stone chart that is described under flowchart project schedule.

Yours very truly,
MEC-FAB inc.

Richard Sénécal
Sales Representative

RS/am

MEC-FAB INC

MEC-FAB INC.

1401 GRAHAM BELL, BOUCHERVILLE, QUÉBEC, CANADA J4B 6A1
TÉL.: (514) 655-7910 • FAX: (514) 655-5189

ADDENDUM - Reference Page 12

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DANDY

Option

Please note that this proposal does not include the vacuum box pricing nor the dandy roll vacuum control system consisting of separator, control valve, vacuum controller, gauge, vacuum hose and vacuum generator.

Prices for this equipment will follow.

Richard Sénécal
Sales Representative

RS/am

INTERNAL PURCHASE ORDER

AN43090-10 = $8,380.00

added Time Wire 3/3 x #4 ✓

PO0196533
SUPPLEMENT: 001
P.O. PAGE: 1
PRINT DATE: 04/12/95
OPEN DATE: 12/05/94

V: MEC-FAB INC.
E: 1401 GRAHAM BELL RD.
N: BOUCHERVILLE
D: QUEBEC CA J4B6A-1
O:
R:

S: APPLETON PAPERS INC.
H: SPRING MILL
I: 100 PAPER MILL ROAD
P: ROARING SPRING PA 16673
T:
O:

TERMS: NET 30
CARRIER: TRUCK
FGT TRMS: ALLOWED
F.O.B.: ORIGIN
DUE DATE: 03/24/95
LIMIT AMT: $.00

B: APPLETON PAPERS INC.
I: SPRING MILL
L: 100 PAPER MILL ROAD
L: ROARING SPRING PA 16673
T:
O:

CONFIRMING TO: RICHARD 11/15/94

NOT SUBJECT TO STATE SALES TAX

LINE	QUANTITY	UOM	EST	PRICE	UOM	FACTOR	TOTAL
DUE DATE	PART #			DESCRIPTION			
001	1.00	EA		317,450.0000	EA		$317,450.00

NO. 3 P.M. FOURDRINIER ASSEMBLY AND ACCESSORIES
PER MEC-FAB INC. PROPOSAL NO. 9776-REV5 AND APPLETON PAPERS INC. "EQUIPMENT PROCUREMENT CONTRACT" FOR NO. 3 P.M. FOURDRINIER, GENERALLY INCLUDING THE FOLLOWING:

- C-FRAME DESIGN FOURDRINIER FRAMING CONSTRUCTED OF SOLID 316L STAINLESS STEEL.
- SAVEALL PANS AND DOWNLEG, CONSTRUCTED OF 316L STAINLESS STEEL.
- (5) WIRE RETURN ROLLS 9-1/8" OD X 92" FACE RUBBER COVERED, CENTRIFUGALLY CAST SHELL. 17-4PH SS JOURNALS, INCLUDING BEARINGS AND SS BEARING HOUSINGS, DYNAMICALLY BALANCED FOR 1500 FPM.
- (2) SPARE WIRE RETURN ROLLS WITH BEARINGS AND SS BEARING HOUSINGS, SAME AS ABOVE.
- THUNE AUTOMATIC WIRE GUIDE AND HAND GUIDE.
- WIRE STRETCHER ASSEMBLY WITH CONTROLS. AIR MOTOR AND SCREW JACK ACTUATED WITH MANUAL BACK-UP.
- BREAST ROLL LOWERING ASSEMBLY AND SHAKING BREAST ROLL ARRANGEMENT. AIR MOTOR AND SCREW JACK ACTUATED WITH MANUAL BACK-UP.
- BEARINGS AND SS BEARING HOUSINGS FOR EXISTING BREAST ROLL AND SPARE BREAST ROLL.
- BREAST ROLL DOCTOR ASSEMBLY. THERMO-ELECTRON DST STYLE WITH POLYETHYLENE BLADE AND NECESSARY CONTROLS.
- CANTILEVERED CROSSWALK AT FLATBOX AREA WITH ACCESS PLATFORM ON TENDING SIDE. FABRICATED FROM 316L SS.
- ALL REQUIRED GUARDING TO MEET OSHA REGULATIONS.
- ALL BRACKETS AND STANDS NECESSARY FOR MOUNTING NEW AND RE-USED EQUIPMENT, FABRICATED IN 316L SS.

*** CONTINUED ***

RECEIVED
APR 17 1995
IS

4/17 JF

INTERNAL PURCHASE ORDER

P00196533
SUPPLEMENT: 001
P.O. PAGE: 2
PRINT DATE: 04/12/95
OPEN DATE: 12/05/94

- ALL FASTENERS SHALL BE SUPPLIED IN STAINLESS STELL AND SHALL BE UNITED STATES STANDARD, NO METRICS.
- EQUIPMENT DESIGN ENGINEERING AND DOCUMENTATION.
- INSTALLATION AND START-UP SUPERVISION, 24 HR/DAY COVERAGE FOR THE DURATION OF THE FOURDRINIER INSTALLATION.

CREATED FROM REQ NUMBER: REQ202522 001
REQUESTOR: CSPA119 TAYLOR,MARK
REQ APPROVER: CSPA142 BAREFOOT,RICHARD
REQ APPROVER: CSPA080 ZITZLSPERGER,FRANK

ORG/ACCT/CTR/SL: 030 164000 0000043090490
PROJECT NUMBER: AN43090
RECEIVAL STATION: 10

LINE	QUANTITY	UOM	EST	PRICE	UOM	FACTOR	TOTAL
DUE DATE	PART #			DESCRIPTION			
002	1.00	EA		10,050.0000	EA		$10,050.00

SPARE PARTS PACKAGE FOR NO. 3 P.M. FOURDRINIER ASSY.
INCLUDING THE FOLLOWING:

- (1) COMPLETE SET OF SCOTCH PLY SPRINGS FOR BREAST ROLL SHAKE ASSEMBLY. $ 550.00/SET
- (1) SCREW JACK AND AIR MOTOR SET CONSISTING OF: $9,500.00/SET
  (2) BENZLER SCREW JACKS
  (1) AIR MOTOR

CREATED FROM REQ NUMBER: REQ202522 002
REQUESTOR: CSPA119 TAYLOR,MARK
REQ APPROVER: CSPA142 BAREFOOT,RICHARD
REQ APPROVER: CSPA080 ZITZLSPERGER,FRANK

ORG/ACCT/CTR/SL: 030 129000 0000043490490
PROJECT NUMBER: SB43490
RECEIVAL STATION: 195

003	1.00	EA		7,780.0000	EA		$7,780.00

CHANGE ORDER NO. 1 MODIFICATIONS TO MAIN BEAM
PROVIDE ADDITIONAL ENGINEERING AND MATERIALS TO ACCOMMODATE THE FUTURE INSTALLATION OF A SINCLAIR BOX FOR THE FUTURE DANDY ROLL AND TO PROVIDE ADJUSTABILITY IN THE POSITION OF THE DANDY ROLL IN THE MACHINE DIRECTION, AS REQUESTED BY API.

CREATED FROM REQ NUMBER: REQ202522 003
REQUESTOR: CSPA119 TAYLOR,MARK
REQ APPROVER: CSPA142 BAREFOOT,RICHARD
REQ APPROVER: CSPA080 ZITZLSPERGER,FRANK

**** CONTINUED ****

INTERNAL PURCHASE ORDER

P00196533

SUPPLEMENT: 001
P.O. PAGE: 3
PRINT DATE: 04/12/95
OPEN DATE: 12/05/94

ORG/ACCT/CTR/SL: 030 164000 0000043090490
PROJECT NUMBER: AN43090
RECEIVAL STATION: 10

LINE	QUANTITY	UOM	EST	PRICE	UOM	FACTOR	TOTAL
DUE DATE	PART #			DESCRIPTION			
004	1.00	EA		600.0000	EA		$600.00

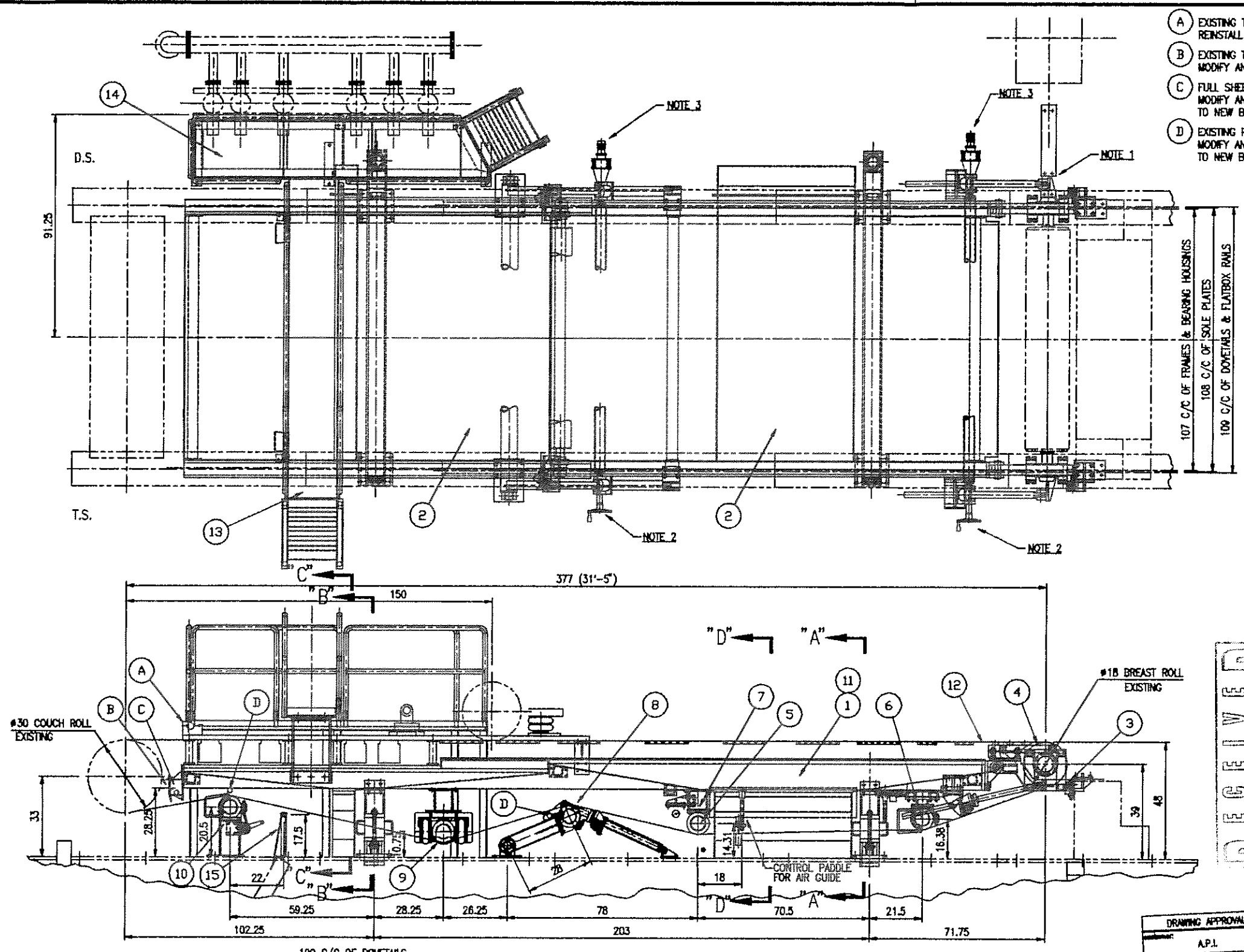
CHANGE ORDER NO. 1 ADDITIONAL FREIGHT CHARGE
FOR TRAILER RENTAL TO STORE EQUIPMENT UNTIL SHUTDOWN. TRAILER TO BE
USED FOR STORAGE FROM 4/12/95 UNTIL APPROXIMATELY 4/26/95.

CREATED FROM REQ NUMBER: REQ202522 004
REQUESTOR: CSPA119 TAYLOR,MARK
REQ APPROVER: CSPA142 BAREFOOT,RICHARD
REQ APPROVER: CSPA080 ZITZLSPERGER,FRANK

ORG/ACCT/CTR/SL: 030 164000 0000043090490
PROJECT NUMBER: AN43090
RECEIVAL STATION: 10

ORDER TOTAL $335,890.00

BUYER: SP4 MILLER,DEAN
APPROVER(S): CSPA077 MILLER,DEAN



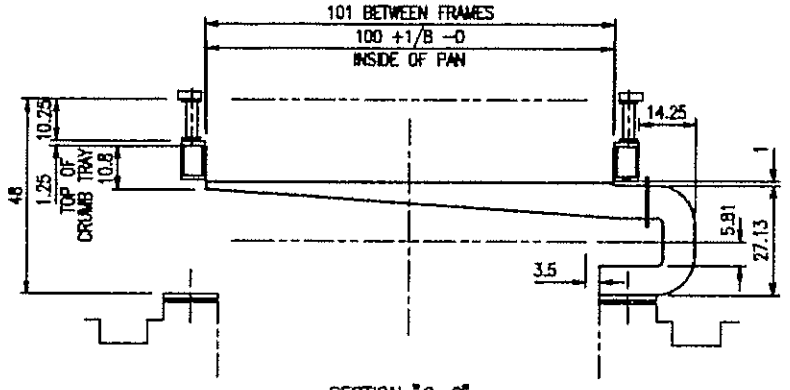
(A) EXISTING TAIL CUTTER AND TRIM SQUIRTS MOUNTING BLOCKS REINSTALL BY MILL AT D.S. AND T.S.

(B) EXISTING TRIM KNOCK DOWN SHOWER AND BRACKETS MODIFY AND REINSTALL BY MILL AT D.S. AND T.S.

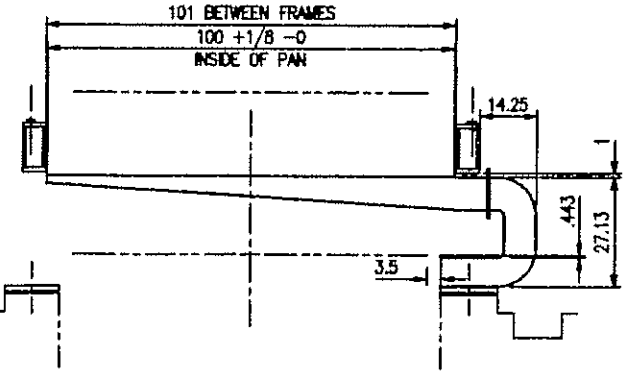
(C) FULL SHEET KNOCK DOWN SHOWER AND BRACKETS MODIFY AND REINSTALL BY MILL AT D.S. AND T.S. TO NEW BOLTING SURFACE SUPPLIED BY MEC-FAB INC.

(D) EXISTING ROLL LUBRICATION SHOWER AND BRACKETS MODIFY AND REINSTALL BY MILL AT D.S. AND T.S. TO NEW BOLTING SURFACE SUPPLIED BY MEC-FAB INC.

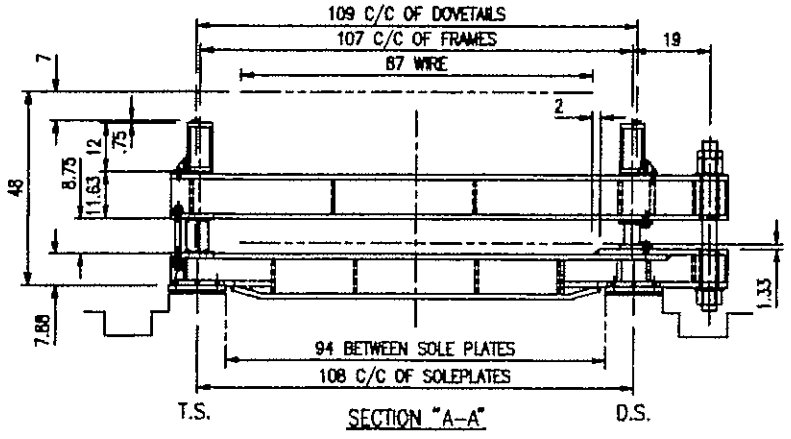
ITEM	QTY	DESCRIPTION	REFERENCE	MATERIAL	REV.
1	1	FRAMING ASSEMBLY	6962-002-02	ST.ST. 316L	
2	1	SAVEALL ARRANGEMENT	6962-004-02	ST.ST. 316L	
3	1	BREAST ROLL RETRACTION MECHANISM	6962-005-02	VARIES	
4	1	BREAST ROLL ASSEMBLY	6962-006-02	VARIES	
5	7	WIRE RETURN ROLL ASSEMBLY	6962-007-02	VARIES	
6	1	5th WIRE RETURN ROLL ASSEMBLY	6962-008-02	VARIES	
7	1	4th WIRE RETURN ROLL ASSEMBLY	6962-009-02	VARIES	
8	1	STRETCHER ASSEMBLY	6962-010-02	VARIES	
9	1	2nd WIRE RETURN ROLL ASSEMBLY	6962-011-02	VARIES	
10	1	1st WIRE RETURN ROLL ASSEMBLY	6962-012-02	VARIES	
11	1	FOURDRINIER LOADING	6962-013-25		
12	1	WIRE RUN	6962-014-25		
13	1	CROSSWALK ASSEMBLY	6962-015-02	ST.ST. 316L	
14	1	D.S. PLATFORM ASSEMBLY	6962-016-02	ST.ST. 316L	
15	1	KNOCK-OFF DEFLECTOR ASSEMBLY	6962-018-02	ST.ST. 316L	



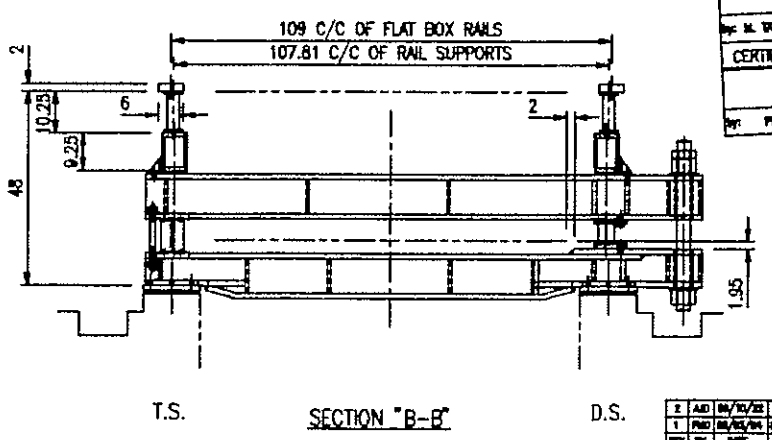
SECTION "C-C"



SECTION "D-D"



SECTION "A-A"



SECTION "B-B"

RECEIVED
DEC - 4 1996
A P I ENGINEERING

DRAWING APPROVAL	
customer: A.P.I.	
Rpr. M. TAYLOR	date: 95/12/06
CERTIFIED FOR FABRICATION	
MEC-FAB Inc.	
By: PMO	date: 95/12/06

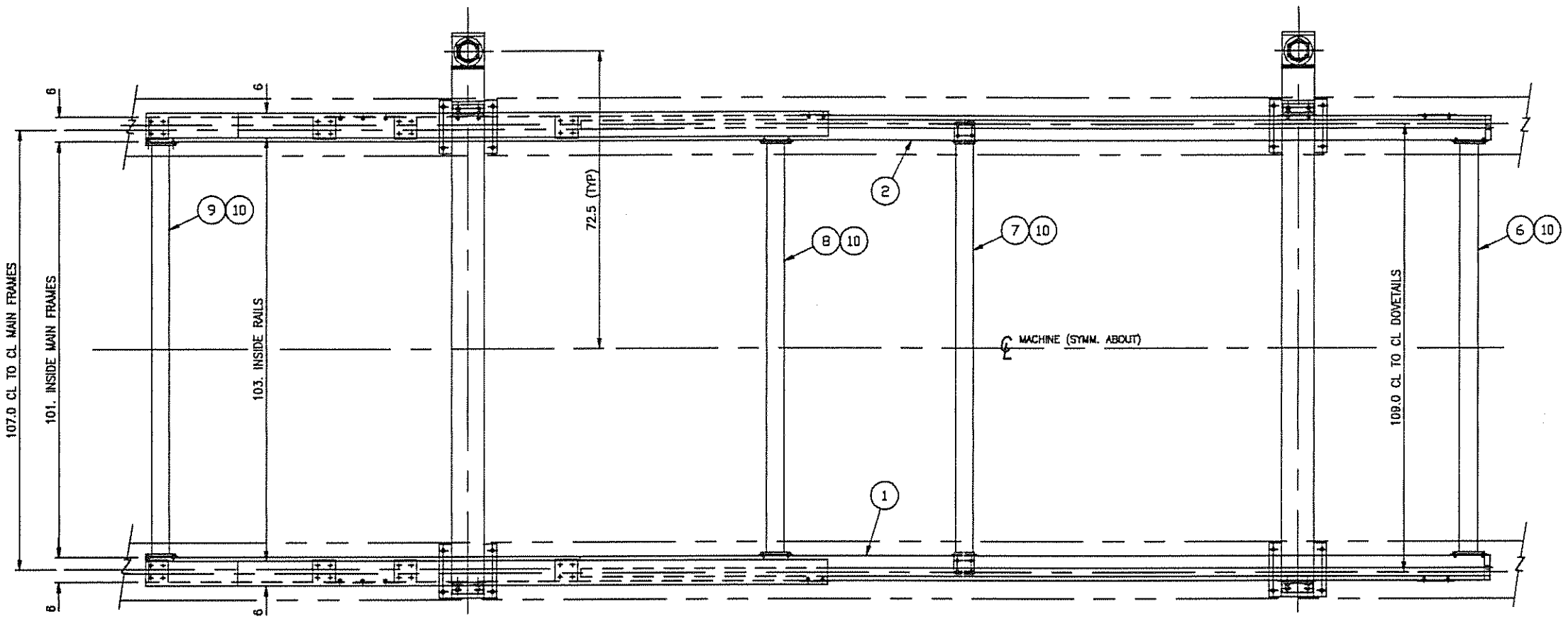
NOTES:
1- MILL TO LENGTHEN SCOTCHPLY CONNECTION BETWEEN SHAKE UNIT AND BEARING HOUSING BY 8.5625"
2- HANDWHEEL COMES WITH SPRING ACTION COUPLING TO PREVENT HANDWHEEL FROM TURNING WHEN AIR MOTOR IS IN USE.
3- AIR MOTOR/GEAR UNIT ASSEMBLY COMES COMPLETE WITH CONTROLS;
- FOR SWING ARM AIR CONTROL DIAGRAM SEE DWG # 6962-144-25
- FOR STRETCHER AIR CONTROL DIAGRAM SEE DWG # 6962-145-25

REV	BY	DATE	REMARKS
2	AJD	96/10/22	REVISED AS PER SWIFT MARK-UP
1	PMO	95/05/04	REVISED AS PER A.P.I. COMMENTS
REV	BY	DATE	REMARKS

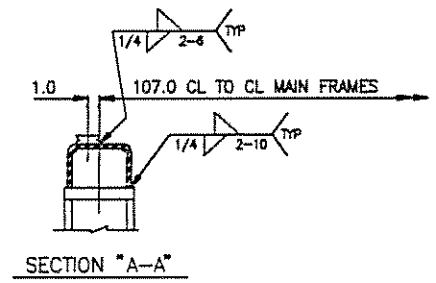
MEC-FAB Inc.
1401 GRAHAM BELL
BOUCHERVILLE
QUEBEC, CANADA
TEL: 655-7910

GENERAL TOLERANCES	
X.	± .040
X.XX	± .020
X.XX	± .010
X.XXX	± .005
FRACTION	± 1/32
DEGREE	± 1°

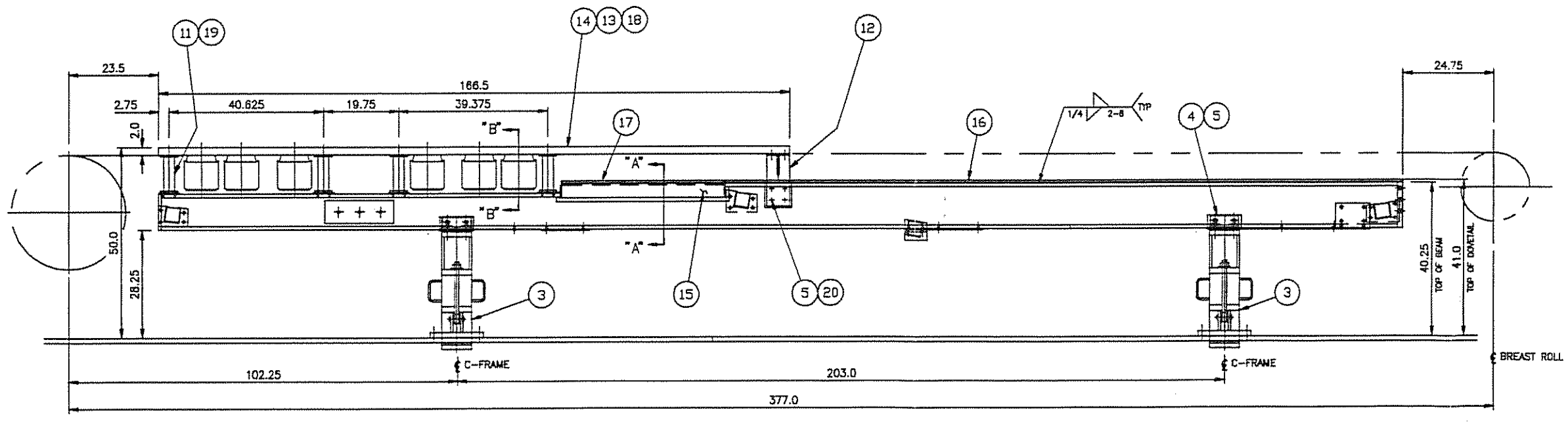
DRAWN BY: PMO	DATE: 95/02/02	SCALE: 1=24	TITLE: FOURDRINIER GENERAL ASSEMBLY
CHECKED BY: HDM	DATE: 95/02/08	USED ON: 6962-000-02	DRAWING NO: 6962-001-02
APPROVED BY: RML	DATE: 95/02/08		REV: 2

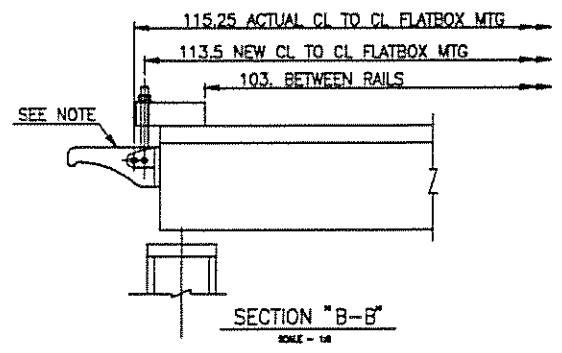


ITEM	QTY	DESCRIPTION	REFERENCE	MATERIAL	REV.
1	1	MAIN FRAME (TENDING SIDE)	6962-022-03	STST 316L	-
2	1	MAIN FRAME (DRIVE SIDE)	6962-029-03	STST 316L	-
3	2	C-FRAME ASSY	6962-003-02	STST 316L	-
4	4	BEAM ATTACH. BRACKET	6962-117-03	STST 316L	-
5	24	CAPSCR, HEX HD 3/4-10NC X 1.5 LG		STST 18-8	-
6	1	FDURD. CROSS-TIE	6962-118-03	STST 316L	-
7	1	FDURD. CROSS-TIE	6962-119-03	STST 316L	-
8	1	FDURD. CROSS-TIE	6962-120-03	STST 316L	-
9	1	FDURD. CROSS-TIE	6962-121-03	STST 316L	-
10	32	CAPSCR, HEX. HD 5/8-11NC X 1.5 LG		STST 18-8	-
11	8	POST FLAT BOX RAIL	6962-122-03	STST 316L	-
12	2	BRACKET FLAT BOX RAIL	6962-123-03	STST 316L	-
13	1	FLAT BOX RAIL (DS.)	6962-124-03	STST 316L	-
14	1	FLAT BOX RAIL (T.S.)	6962-125-03	STST 316L	-
15	2	FORMED CHANNEL SPACER	6962-126-03	STST 316L	-
16	2	DOVETAIL BAR	6962-127-03	STST 316L	-
17	2	DOVETAIL BAR	6962-128-03	STST 316L	-
18	40	CAPSCR, HEX. HD 1/2-13NC X 1.25 LG		STST 18-8	-
19	32	CAPSCR, HEX. HD 1/2-13NC X 1.5 LG		STST 18-8	-
20	8	FLAT WASHER, 3/4 DIA.		STST 18-8	-



SECTION "A-A"





SECTION "B-B"

NOTE:
FLATBOX MTG BRACKETS TO BE REWORKED BY CUSTOMER
TO ACHIEVE 113.5 CL TO CL MTG DISTANCE AS SHOWN ON SECT. "B:B".

DRAWING APPROVAL	
customer: A.P.I.	
by: M. TAYLOR	date: 95-02-17
CERTIFIED FOR FABRICATION	
MEC-FAB inc.	
by: PMO	date: 95-03-06

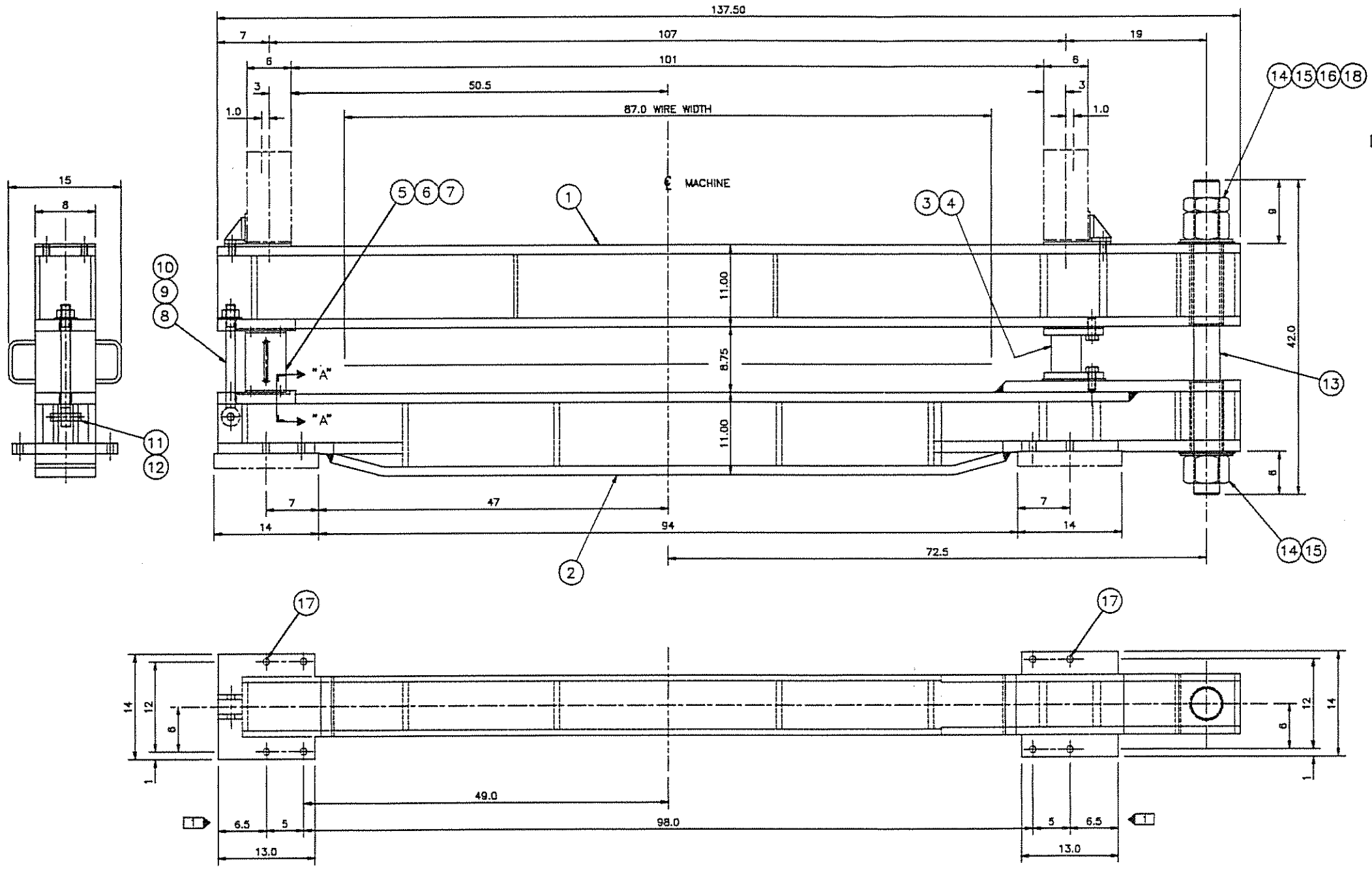
REV	DESCRIPTION	DATE	BY	APP
1	IT (14) QTY 1 WAS 2, —— IT (18) QTY 8 WAS 20 IT (19) QTY 34 WAS 16 —— IT (12) QTY 2 WAS 1 BECK. ("A-A") AND ("B-B") ADDED. PLAN VIEW REDRAWN TO SCALE.	95-03-02	HDN	

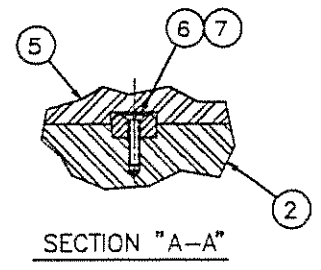
GENERAL TOLERANCES
X. ± .040
X.X ± .020
X.XX ± .010
X.XXX ± .005
FRACTION ± 1/32
DEGREE ± 1°

MEC-FAB inc.
1401 GRAHAM BELL
BOUCHERVILLE
QUEBEC, CANADA
TEL: 655-7910

DRAWN BY: HDN	DATE: 95-02-02	SCALE: 1:16	TITLE: FRAMING ASSY	REV: 1
CHECKED BY: —	DATE: —	USED ON: 6962-001-02	DRAWING NO: 6962-002-02	
APPROVED BY: —	DATE: —			

ITEM	QTY	DESCRIPTION	REF	MATERIAL
1	1	C–FRAME, TOP BEAM	6962–020–03	STST316L
2	1	C–FRAME, BOTTOM BEAM	6962–021–03	STST316L
3	1	SUPPORT BLOCK	6962–024–03	STST316L
4	4	CAPSCR, HEX– 1.0–8NC X 2.25 LG		STST18–8
5	1	REMOVABLE BLOCK	6962–023–03	STST316L
6	2	KEY	6962–062–03	SI. BRZ
7	4	MACH SCR, FL HD– 1/4–20NC X 1.0 LG		STST18–8
8	1	EYE BOLT, 1 1/4 X 15.0 LG	6962–058–03	STST316L
9	1	HVY HEX NUT– 1 1/4–7NC		SI BRZ
10	1	HVY WASHER FL– 1 1/4		STST18–8
11	1	PIN	6962–059–03	STST316L
12	2	COTTER PIN– 1/8 X 1.25 LG		STST18–8
13	1	CANTILEVER ROD– 3.5 DIA.	6962–061–03	STST316L
14	2	SPECIAL WASHER –3.5 DIA	6962–063–03	STST18–8
15	2	HVY HEX NUT– 3.5	6962–060–03	MANG. BRZ
16	1	JAM NUT, HEX– 3.5		
17	8	CAPSCR, HEX– 3/4–10NC X 2.25 LG		STST18–8
18	1	SPECIAL 3.5" OPEN END WRENCH		M.S.





SECTION "A–A"

2–REQUIRED

DRAWING APPROVAL	
customer: A.P.I.	
by: M. TAYLOR	date: 95–02–17
CERTIFIED FOR FABRICATION	
MEC–FAB inc.	
by: PMO	date: 95–03–06

ECV	DESCRIPTION	DATE	BY	APP
1	–ITEM #8a WAS "L STST 316L WAS ALUM. –ITEM #17: QTY (8) WAS (12) –(1) ROW OF HOLD DOWN BOLTS REMOVED. (1.5 & 0.5) AND DIM. 6.5 ADDED	95–02–20	HDN	

MEC–FAB inc.

1401 GRAHAM BELL
BOUCHERVILLE
QUEBEC, CANADA
TEL: 655–7910

X. ± .040	DRAWN BY: HDN	DATE: 94–12–20	SCALE: 1:8	TITLE: "C" FRAME, ARRG'T
X.X ± .020	CHECKED BY:	DATE:		REV: 1
X.XX ± .010	APPROVED BY:	DATE:	DRAWING NO: 6962–003–02	USED ON: 6962–002–02
X.XXX ± .005				
FRACTIONS ± 1/32				

ITEM	QTY	DESCRIPTION	REFERENCE	MATERIAL
1	1	SAVEALL #1	6962-034-03	ST'ST 316L
2	1	SAVEALL #2	6962-035-03	ST'ST 316L
3	1	SAVEALL #3	6962-036-03	ST'ST 316L
4	1	SAVEALL #4	6962-111-03	ST'ST 316L
5	1	SAVEALL #5	6962-112-03	ST'ST 316L
6	1	DRAIN OUTLET (WET END)	6962-113-03	ST'ST 316L
7	1	DRAIN OUTLET (DRY END)	6962-114-03	ST'ST 316L
8	1	GASKET	6962-115-03	RUBBER
9	1	GASKET	6962-116-03	RUBBER
10	28	HEX HEAD CAP SCREW 3/8-16NC x 1.75 LG	PURCHASING	18-8
11	62	HEX HEAD CAP SCREW 3/8-16NC x .75 LG	PURCHASING	18-8
12	28	HEX NUT 3/8-16NC	PURCHASING	18-8
13	56	FLAT WASHER 3/8"	PURCHASING	18-8

DETAIL 3

DETAIL 2

DETAIL 1

DRAWING APPROVAL	
CUSTOMER: A.P.L.	
by: M. TAYLOR	date: 95/02/17
CERTIFIED FOR FABRICATION	
MEC-FAB inc.	
by: PMO	date: 95/03/08

SECTION "A-A"

SECTION "B-B"

SECTION "C-C"

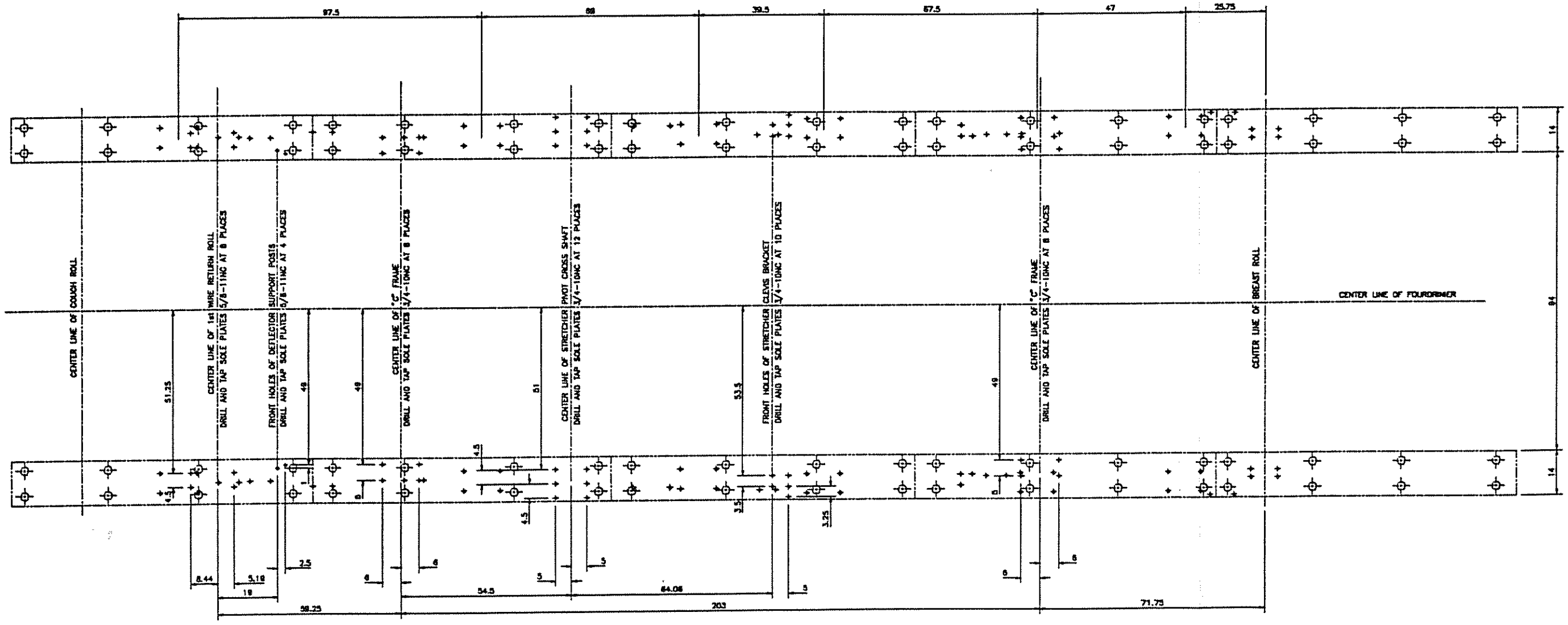
REV	DESCRIPTION	DATE	APP'D
1	PMO 95/03/08 MAN/ZIER HALF COUPLING ADDED		

GENERAL TOLERANCES		DRAWN BY	DATE	APPROVED BY	DATE
X. ± .040	ANGULAR ± 1°	PMO	95/02/03	RML	95/02/08
X.XX ± .020		CHECKED BY	DATE		
X.XXX ± .010		HDM	95/02/08		
FRACTION ± 1/32					
DEGREE ± 1°					

SCALE	DATE	USED ONE	DRAWING NO.
1=16	95/02/03	6962-001-02	6962-004-02

REV.	TITLE	SCALE	DATE	USED ONE	DRAWING NO.
1	SAVEALL ARRANGEMENT	1=16	95/02/03	6962-001-02	6962-004-02

1401 GRAHAM BELL
BOUCHERVILLE
QUEBEC, CANADA
TEL: 655-7910
MEC-FAB INC.



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MEC-FAB INC.

1401 GRAHAM BELL
BOUCHERVILLE
QUEBEC, CANADA
TEL: 655-7910

GENERAL TOLERANCES
X. ± .040
X.X ± .020
X.XX ± .010
X.XXX ± .005
FRACTION ± 1/32
DEGREE ± 1°

DRAWN BY: PMO	DATE: 95/03/08	SCALE: 1-16	TITLE: SOLE PLATE DRILL AND TAP LAYOUT	REV:
CHECKED BY: HDM	DATE: 95/03/08			
APPROVED BY: RML	DATE: 95/03/08	USED ON: 6962-000-02	DRAWING NO: 6962-147-25	SIZE: D

APPLETON PAPERS A DWG No. 03C-2032.21