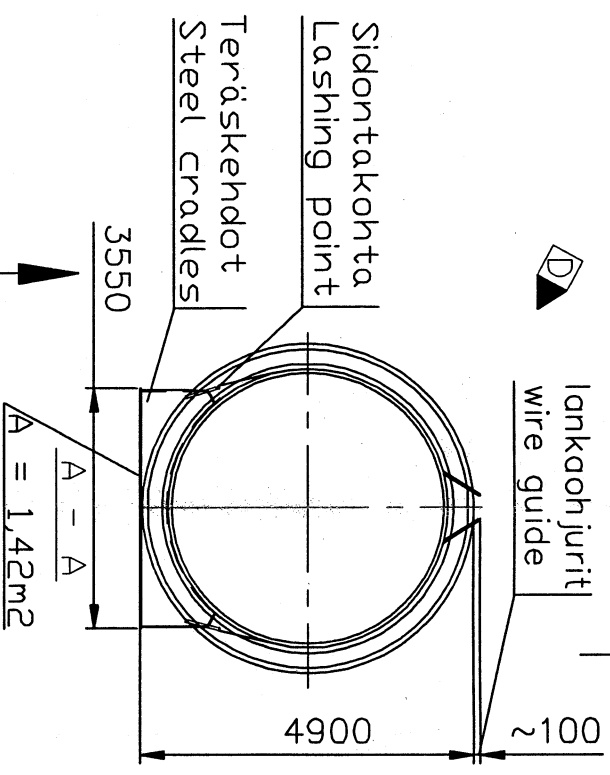


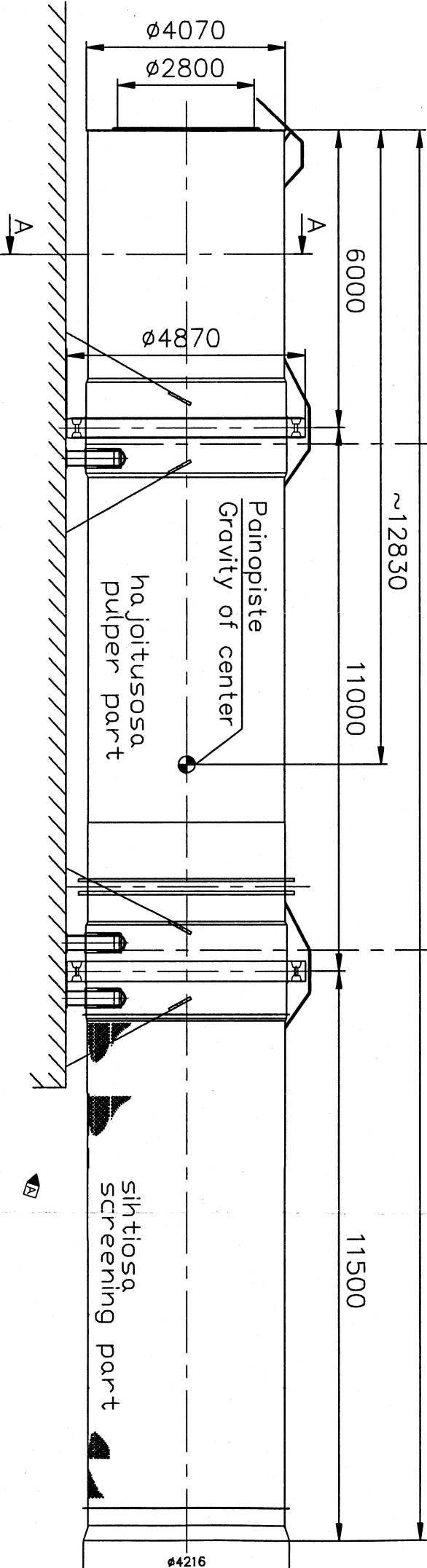
<u>DRAWING NUMBER</u>	<u>DESCRIPTION</u>
SF307354	DRUM LIFTING, FIBREFLOW FF400
1-01413-53	FIBERFLOW 400 DRUM PULPER PARTS DWG.
1-RF069-04-1	FOUNDATION, FIBREFLOW 400; A-LINE
1-RF069-04-2	FOUNDATION, FIBREFLOW 400; B-LINE
1-RF069-09-1	FIBREFLOW 400 DRUM PULPER; A-LINE
1-RF069-09-2	FIBREFLOW 400 DRUM PULPER; B-LINE
1-RF068-09-3	SPRAY LUBRICATION SYSTEM; A-LINE
1-RF068-09-4	SPRAY LUBRICATION SYSTEM; B-LINE
1-RF068-09-5	GREASE LUBRICATION SYSTEM; A-LINE
1-RF068-09-6	GREASE LUBRICATION SYSTEM; B-LINE
2-26009-03	DRUM TRAVEL ADJUSTMENT INSTRUCTIONS
1-26009-18	FIBREFLOW DRUM BAFFLE ORIENTATION
1-26009-19	BOTTOM VAT, FIBREFLOW 400; A-LINE
1-26009-20	BOTTOM VAT, FIBREFLOW 400; B-LINE
1-26011-367	DRIVE ASSEMBLY, FIBREFLOW 400
1-26011-368	DRIVE ASSEMBLY, WITH PONY DRIVE FIBREFLOW 400
3-26012-84	SLOPE GAUGE, FIBERFLOW DRUM

● = Painopiste
= Center of gravity

⊕ = Nostokohdat
= Lifting points



DESCRIPTION				NO.	REV.
DATE D/M/Y	DES'D	APP'D			
21.09.98	VILK		Tark. mittakaava		B
26.10.98	VILK		Tarkistettu kok.paino ja painopisteen paikka		C
27.07.00	VILK		Lisätty lankaohjurit		D
VARIANT DESCRIPTION				MATERIAL	NET WGT. KG VAR.
				S355J2G3/SS	104000 K1



Kokonaispaino ~106 400kg
Total weight ~106 400kg

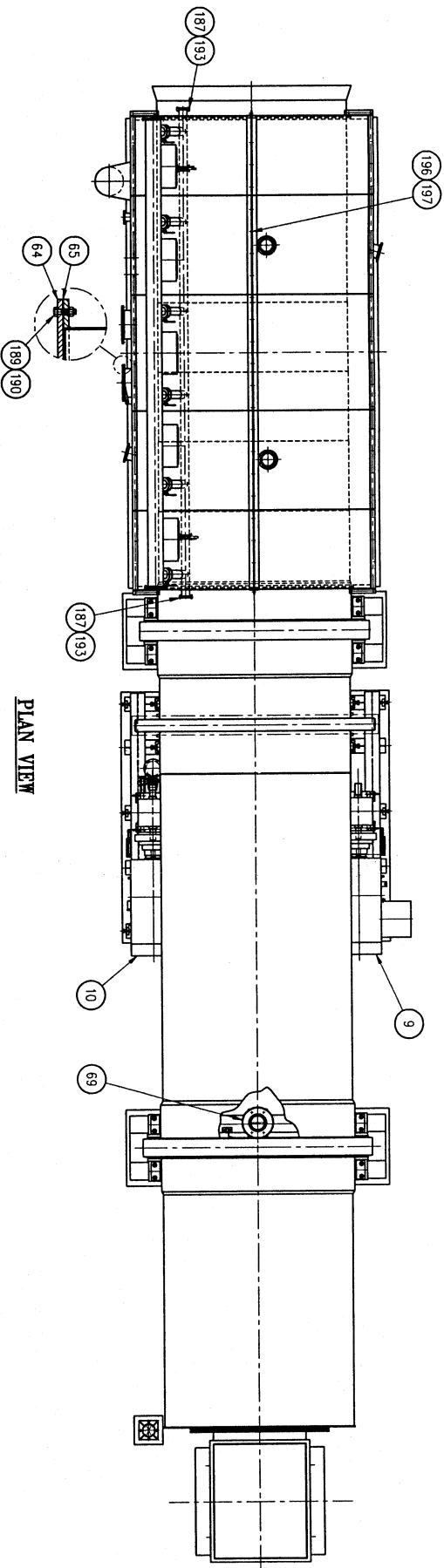
Surface roughness	ISO 1302-Ra	General tolerances:	Kokonaispaino ~11 500kg
Welding symbols	ISO 2553	- Machining	ISO 12068-1
Tolerancing	ISO 8015	- Welded constr.	EN 33920-BG
Geom. tolerances	ISO 1101	- Flame cutting	SFS 4077-B
GENERAL TOLERANCES		Normal measure	>0,5 >6 >30 >120 >400 >1000 >2000 >4000 >8000 >12000 >16000 >20000
Welded constr.	EN 33920-1	Precision class	B ±1 ±1 ±2 ±2 ±3 ±4 ±4 ±6 ±8 ±10 ±12 ±14 ±16
Machining	ISO 2768-1	Linear dim. tolerance class	m ±0.1 ±0.2 ±0.3 ±0.5 ±0.8 ±1.2 ±2 ±3 ±4 ±5 ±6 -

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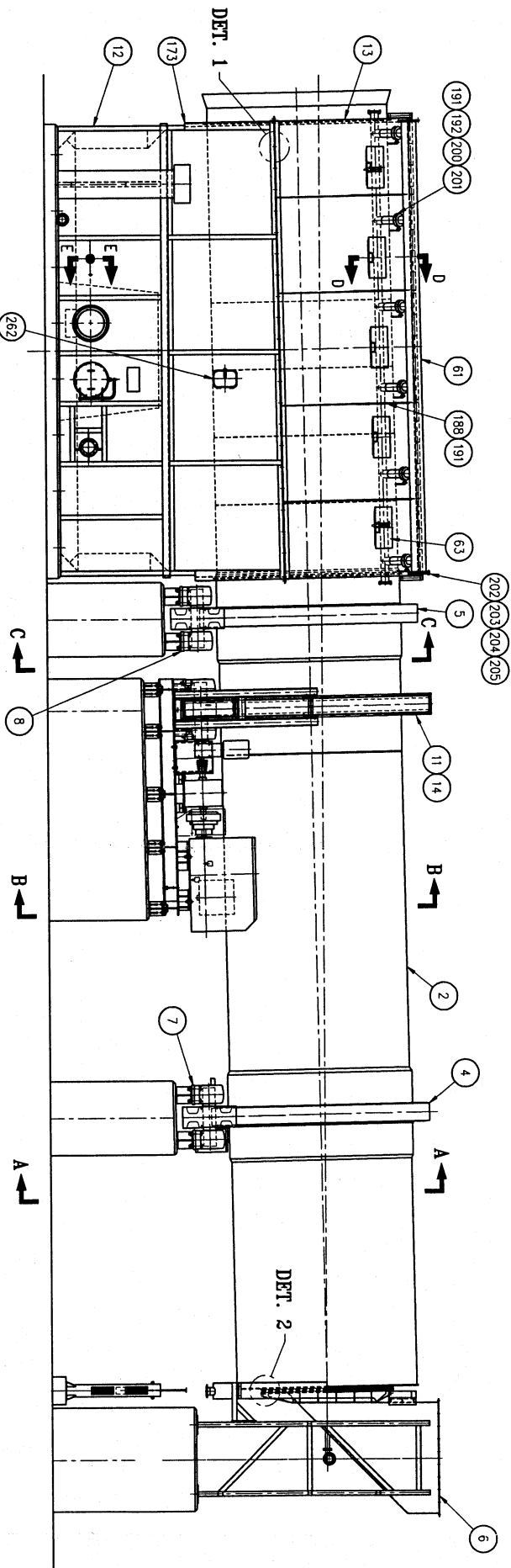
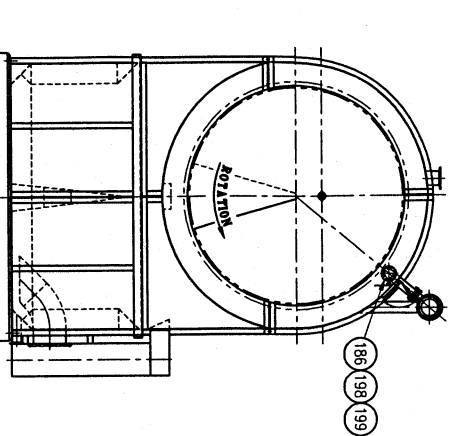
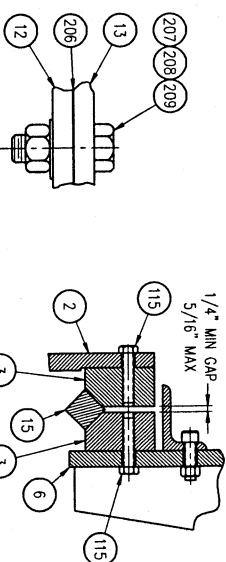


RUMMUN NOSTO			
DRUM LIFT DWG.			
FIBREFLOW FF400			
DESIGNED	DATE D/M/Y	SCALE	MAIN REF. DWG.
VILK	10.01.98	1:100	SF305733
CHECKED			PROJECT NO.
APPROVED			GROUP NO.
DRAWING NO.			12101
SF307354			REV.
D			

REVISIONS			
NO.	DATE	REMARKS	BY
1		SEE SHEET 1	



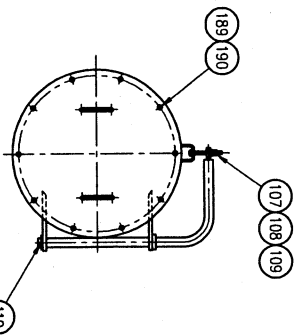
PLAN VIEW



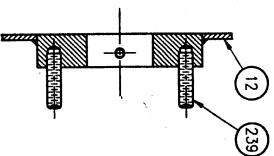
DISCHARGE END

ELEVATION

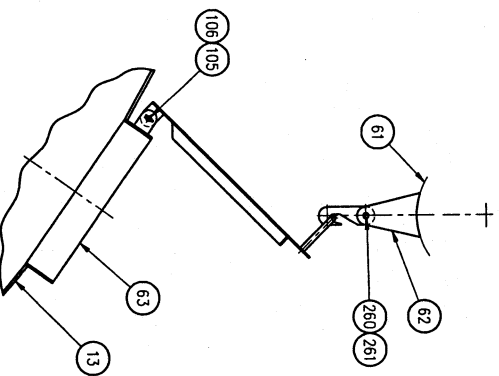
INLET END



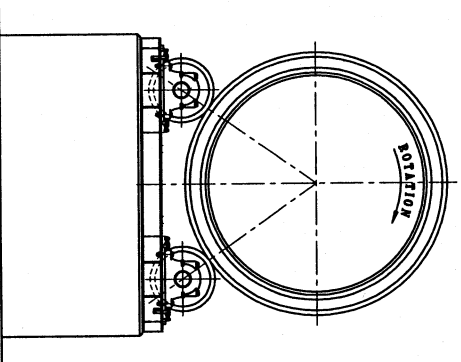
DETAIL ITEM 64



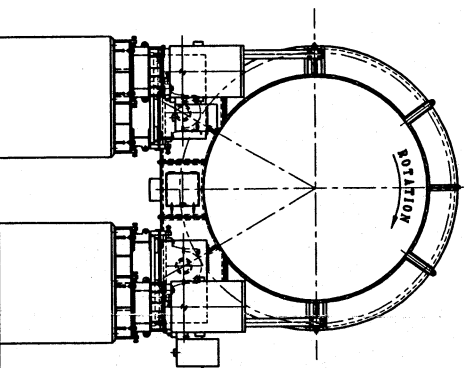
SECTION E-E



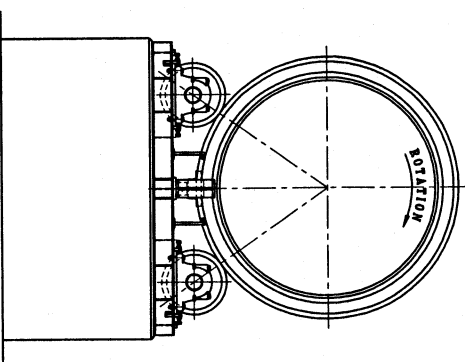
SECTION D-D



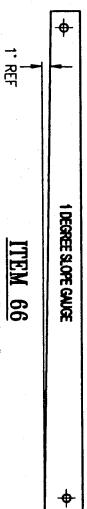
SECTION C-C



SECTION B-B



SECTION A-A



ITEM 66
SCALE: 1-1/2"=1'-0"

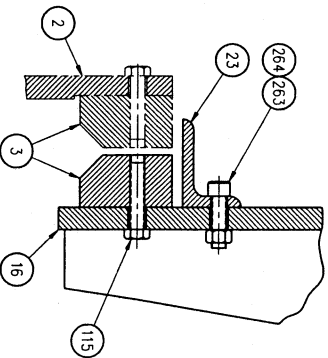
Tolerance, Unless Noted Otherwise
Fractional
under 12" 5/16"
12" to 120" 5/8"
over 120" 1/2"
Decimal
2 places x.xx ±.05"
3 places x.xx ±.010"
Angles ± 1/2°; not to exceed 1/16" per 12"

NOTE: THE DRAWING IS THE PROPERTY OF ARISTARCO. WITHIN THIS DRAWING, ANY PARTS OR COMPONENTS WHICH ARE IDENTICAL TO OR SIMILAR TO THOSE SHOWN IN PREVIOUS DRAWINGS, SHALL BE IDENTIFIED BY A NOTE INDICATING THE PREVIOUS DRAWING NUMBER AND THE DATE OF THE PREVIOUS DRAWING. THE DRAWING IS TO BE USED IN CONJUNCTION WITH THE DRAWING OF THE PREVIOUS DRAWING.

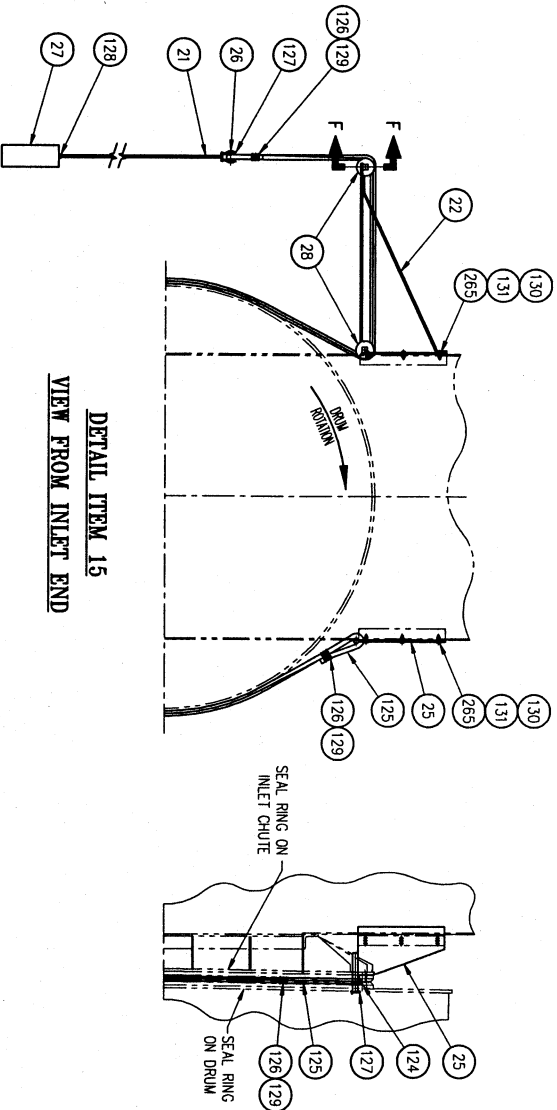
FIBREFLOW 400 DRUM PULPER
PARTS DRAWING
DATE 10/6/00
BY 10/6/00
CHECKED 10/6/00
1-01413-53

ARISTARCO
SHEET 2 of 6
R2

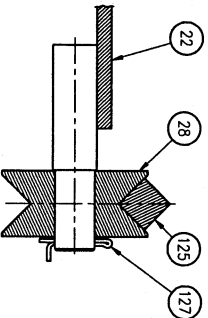
REVISIONS			
NO.	DATE	REMARKS	BY
1		SEE SHEET 1	



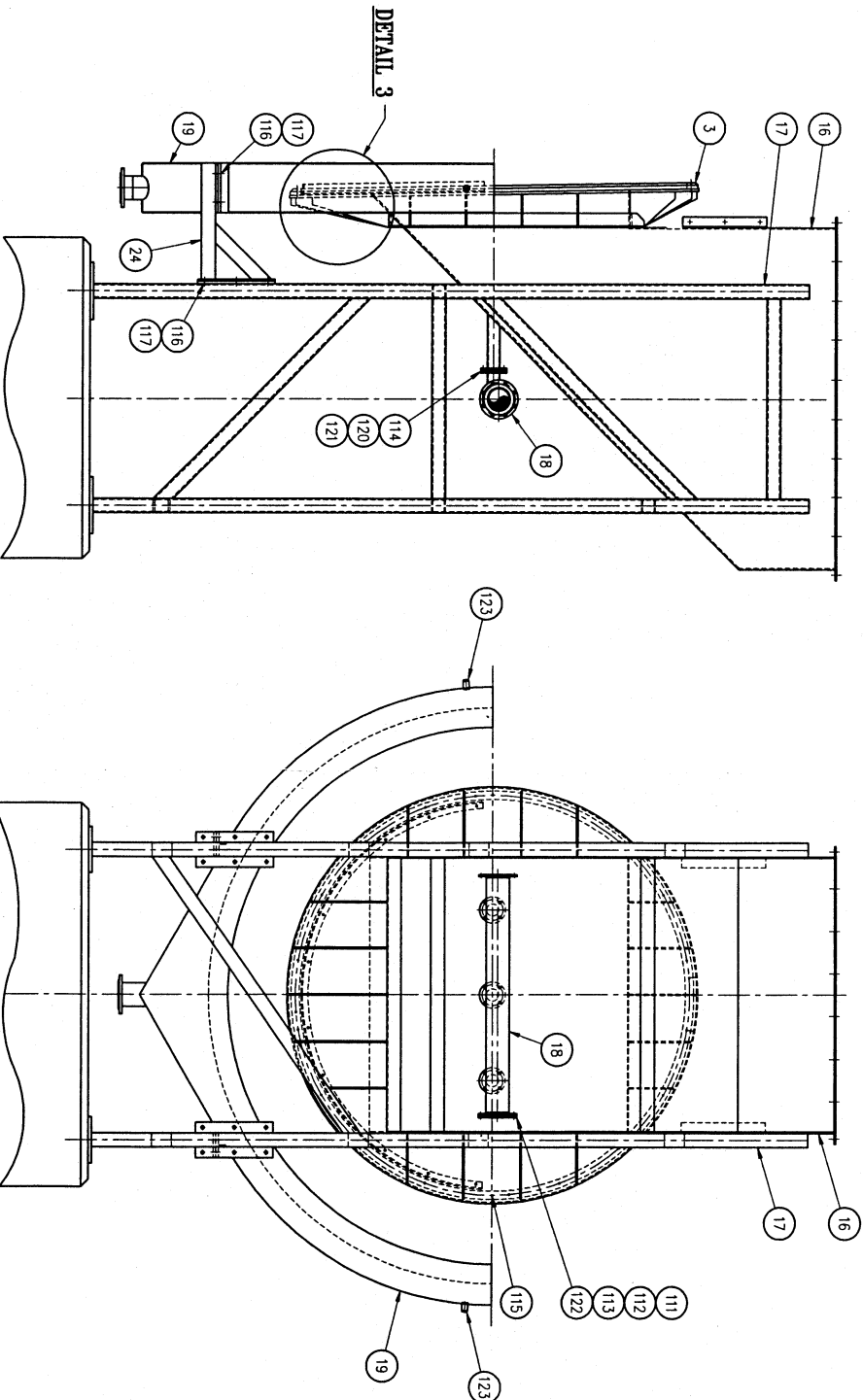
DETAIL 3



DETAIL ITEM 15
VIEW FROM INLET END



SECTION F-F

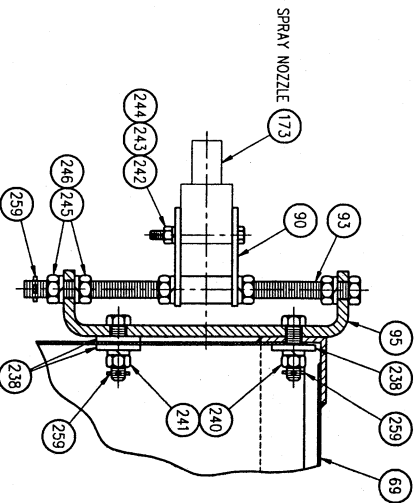
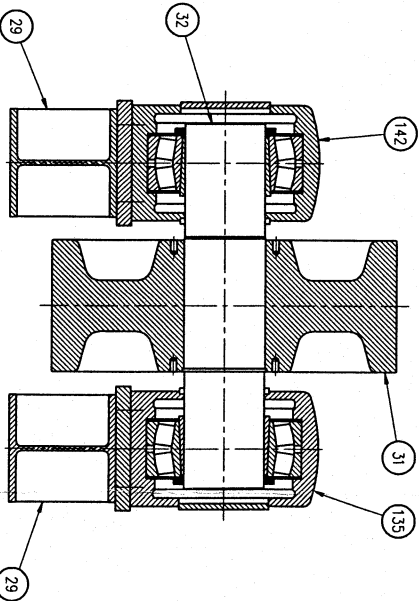
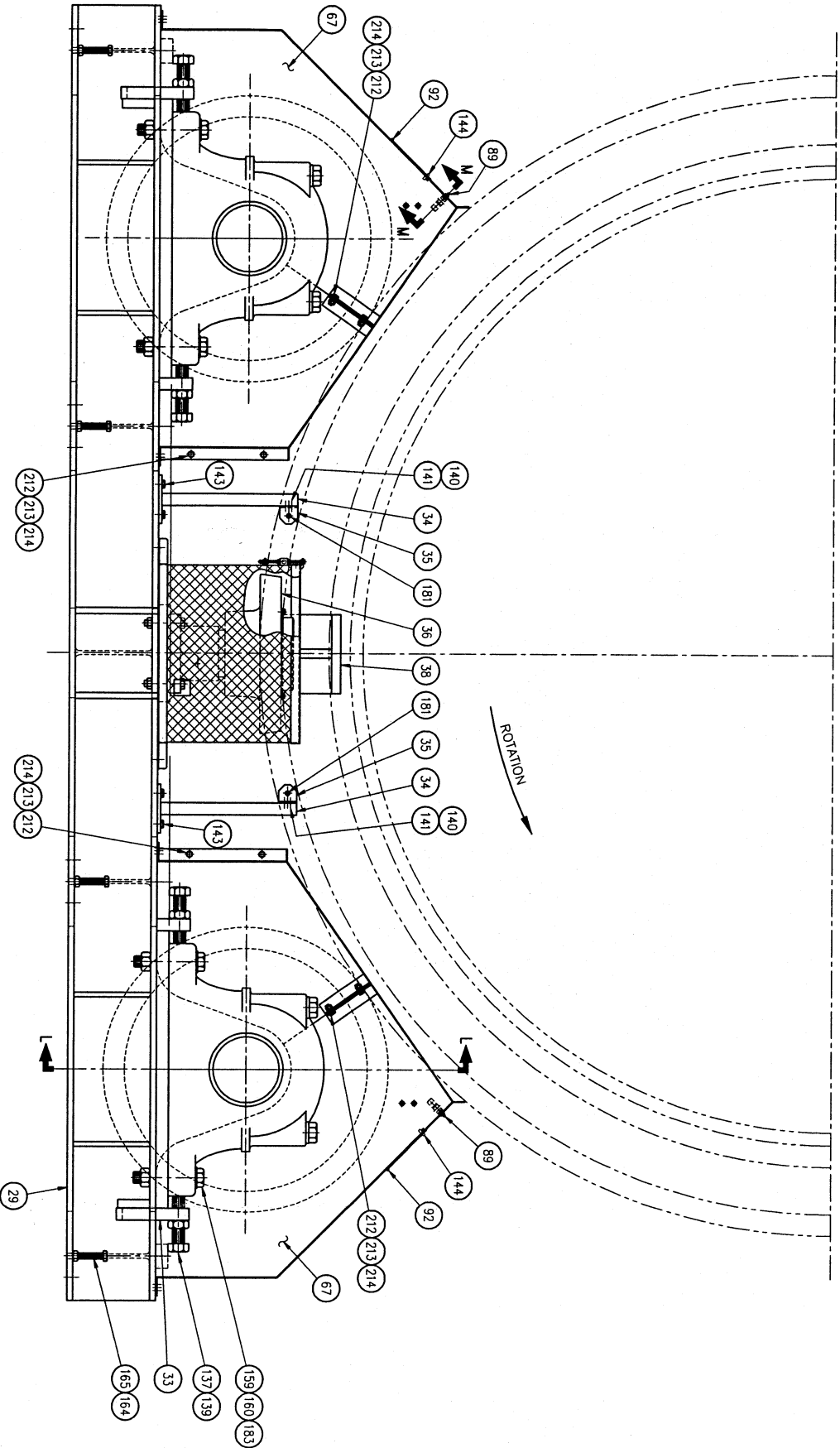
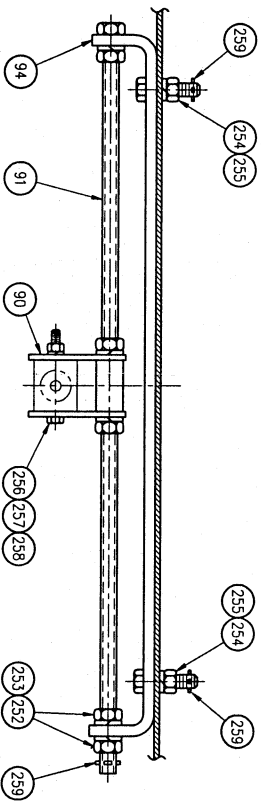
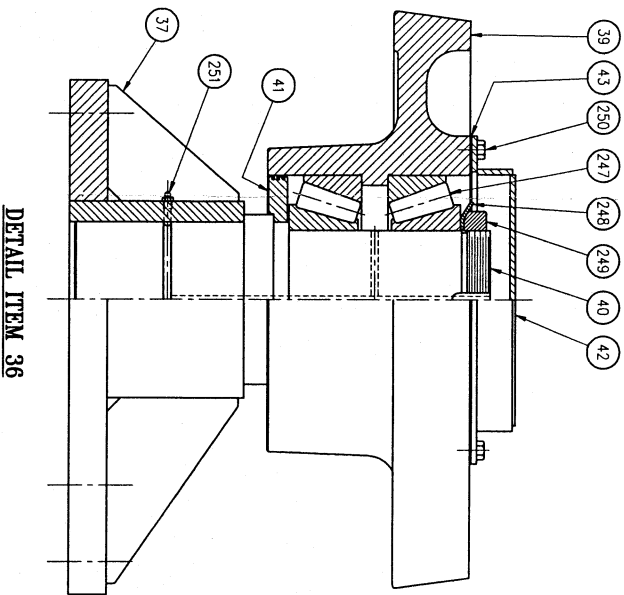
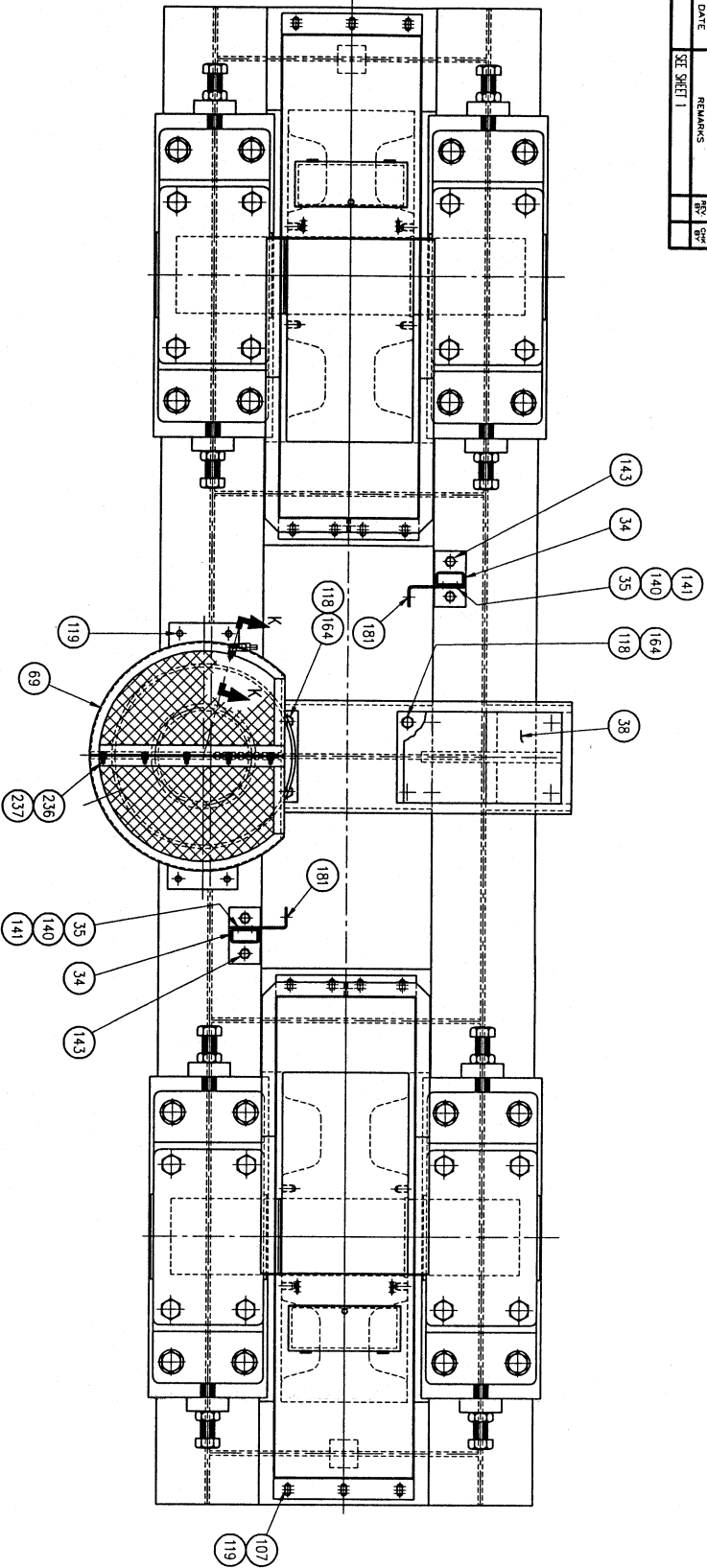


DETAIL ITEM 6

Tolerance, Unless Noted Otherwise
Fractional
under 12" ±1/16"
12" to 120" ±1/8"
over 120" ±1/4"
Deciml
2 places xxx ±.05"
3 places xxx ±.01"
Rounding: 1/2, not to exceed 1/16 per 12"

NOTE
THIS DRAWING IS THE PROPERTY OF
FIBREFLOW 400 DRUM PULPER
INC. IT IS TO BE USED FOR THE
MANUFACTURE OF THE PULPER
ONLY. IT IS NOT TO BE REPRODUCED
OR USED FOR ANY OTHER PURPOSE.
ANY VIOLATION OF THIS NOTICE
WILL BE PROSECUTED TO THE FULL
EXTENT OF THE LAW.

REVISIONS			
NO.	DATE	REVISIONS	BY
1		SEE SHEET 1	



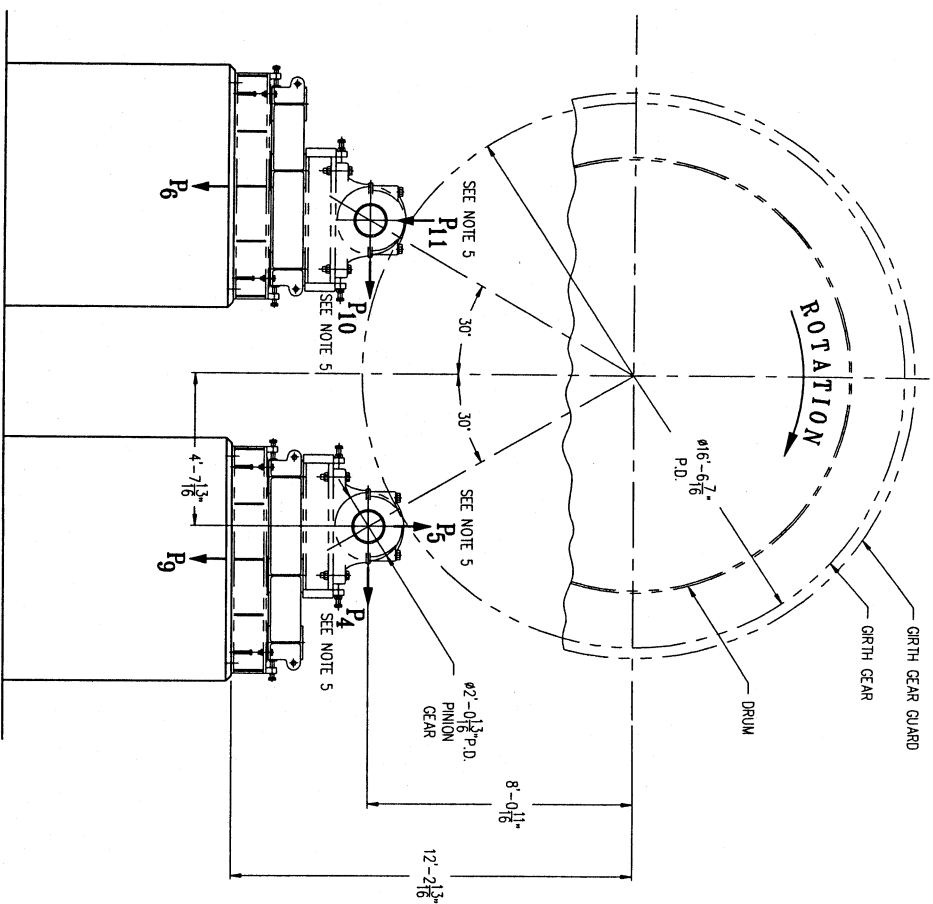
RF069
JOB NO.

ITEM 7 IS SHOWN. ITEM 8 DOES NOT HAVE ITEMS 34, 35, 38, 69, 118, 119, 140, 141, 143, & 181.
ALSO, ITEM 30 IS USED INSTEAD OF ITEM 29.

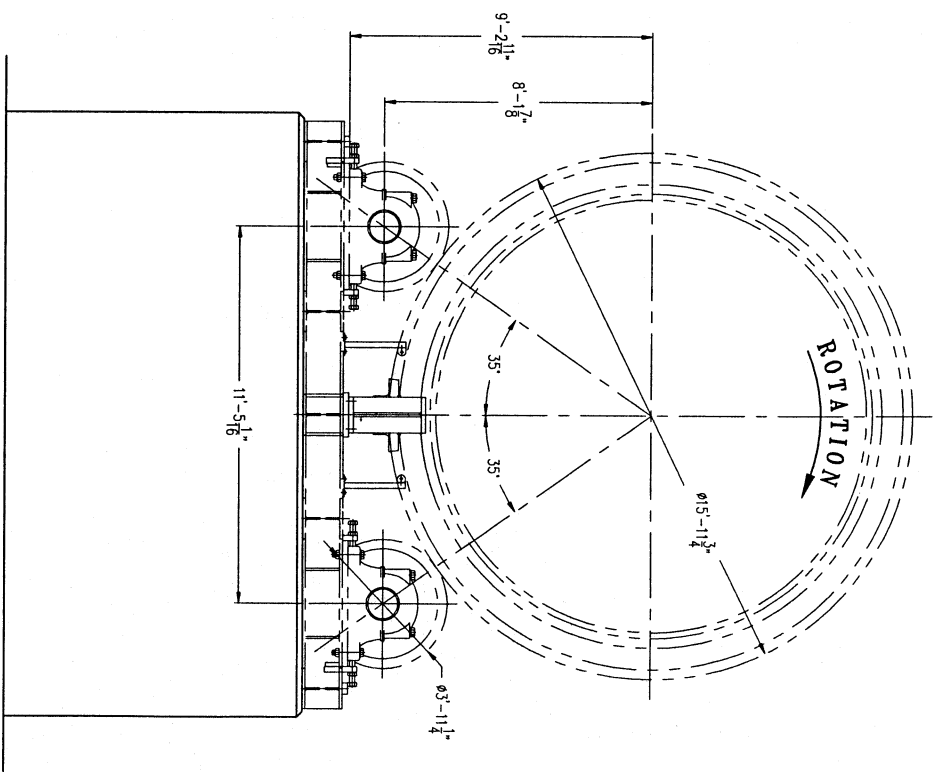
VIEW LOOKING TOWARD INLET
DETAIL ITEMS 7 & 8

Tolerance, Unless Noted Otherwise
Fractional
under 12" 31/16"
12" to 30" 1/8"
30" to 48" 3/16"
48" to 60" 1/4"
60" to 72" 5/16"
72" to 96" 3/8"
96" to 120" 7/16"
120" to 144" 1/2"
144" to 192" 5/8"
192" to 240" 3/4"
240" to 300" 7/8"
300" to 360" 1"
360" to 432" 1 1/8"
432" to 504" 1 1/4"
504" to 576" 1 1/2"
576" to 648" 1 3/4"
648" to 720" 1 7/8"
720" to 792" 2"
792" to 864" 2 1/8"
864" to 936" 2 1/4"
936" to 1008" 2 1/2"
1008" to 1080" 2 3/4"
1080" to 1152" 2 7/8"
1152" to 1224" 3"
1224" to 1296" 3 1/8"
1296" to 1368" 3 1/4"
1368" to 1440" 3 1/2"
1440" to 1512" 3 3/4"
1512" to 1584" 3 7/8"
1584" to 1656" 4"
1656" to 1728" 4 1/8"
1728" to 1800" 4 1/4"
1800" to 1872" 4 1/2"
1872" to 1944" 4 3/4"
1944" to 2016" 4 7/8"
2016" to 2088" 5"
2088" to 2160" 5 1/8"
2160" to 2232" 5 1/4"
2232" to 2304" 5 1/2"
2304" to 2376" 5 3/4"
2376" to 2448" 5 7/8"
2448" to 2520" 6"
2520" to 2592" 6 1/8"
2592" to 2664" 6 1/4"
2664" to 2736" 6 1/2"
2736" to 2808" 6 3/4"
2808" to 2880" 6 7/8"
2880" to 2952" 7"
2952" to 3024" 7 1/8"
3024" to 3096" 7 1/4"
3096" to 3168" 7 1/2"
3168" to 3240" 7 3/4"
3240" to 3312" 7 7/8"
3312" to 3384" 8"
3384" to 3456" 8 1/8"
3456" to 3528" 8 1/4"
3528" to 3600" 8 1/2"
3600" to 3672" 8 3/4"
3672" to 3744" 8 7/8"
3744" to 3816" 9"
3816" to 3888" 9 1/8"
3888" to 3960" 9 1/4"
3960" to 4032" 9 1/2"
4032" to 4104" 9 3/4"
4104" to 4176" 9 7/8"
4176" to 4248" 10"
4248" to 4320" 10 1/8"
4320" to 4392" 10 1/4"
4392" to 4464" 10 1/2"
4464" to 4536" 10 3/4"
4536" to 4608" 10 7/8"
4608" to 4680" 11"
4680" to 4752" 11 1/8"
4752" to 4824" 11 1/4"
4824" to 4896" 11 1/2"
4896" to 4968" 11 3/4"
4968" to 5040" 11 7/8"
5040" to 5112" 12"
5112" to 5184" 12 1/8"
5184" to 5256" 12 1/4"
5256" to 5328" 12 1/2"
5328" to 5400" 12 3/4"
5400" to 5472" 12 7/8"
5472" to 5544" 13"
5544" to 5616" 13 1/8"
5616" to 5688" 13 1/4"
5688" to 5760" 13 1/2"
5760" to 5832" 13 3/4"
5832" to 5904" 13 7/8"
5904" to 5976" 14"
5976" to 6048" 14 1/8"
6048" to 6120" 14 1/4"
6120" to 6192" 14 1/2"
6192" to 6264" 14 3/4"
6264" to 6336" 14 7/8"
6336" to 6408" 15"
6408" to 6480" 15 1/8"
6480" to 6552" 15 1/4"
6552" to 6624" 15 1/2"
6624" to 6696" 15 3/4"
6696" to 6768" 15 7/8"
6768" to 6840" 16"
6840" to 6912" 16 1/8"
6912" to 6984" 16 1/4"
6984" to 7056" 16 1/2"
7056" to 7128" 16 3/4"
7128" to 7200" 16 7/8"
7200" to 7272" 17"
7272" to 7344" 17 1/8"
7344" to 7416" 17 1/4"
7416" to 7488" 17 1/2"
7488" to 7560" 17 3/4"
7560" to 7632" 17 7/8"
7632" to 7704" 18"
7704" to 7776" 18 1/8"
7776" to 7848" 18 1/4"
7848" to 7920" 18 1/2"
7920" to 7992" 18 3/4"
7992" to 8064" 18 7/8"
8064" to 8136" 19"
8136" to 8208" 19 1/8"
8208" to 8280" 19 1/4"
8280" to 8352" 19 1/2"
8352" to 8424" 19 3/4"
8424" to 8496" 19 7/8"
8496" to 8568" 20"
8568" to 8640" 20 1/8"
8640" to 8712" 20 1/4"
8712" to 8784" 20 1/2"
8784" to 8856" 20 3/4"
8856" to 8928" 20 7/8"
8928" to 9000" 21"
9000" to 9072" 21 1/8"
9072" to 9144" 21 1/4"
9144" to 9216" 21 1/2"
9216" to 9288" 21 3/4"
9288" to 9360" 21 7/8"
9360" to 9432" 22"
9432" to 9504" 22 1/8"
9504" to 9576" 22 1/4"
9576" to 9648" 22 1/2"
9648" to 9720" 22 3/4"
9720" to 9792" 22 7/8"
9792" to 9864" 23"
9864" to 9936" 23 1/8"
9936" to 10008" 23 1/4"
10008" to 10080" 23 1/2"
10080" to 10152" 23 3/4"
10152" to 10224" 23 7/8"
10224" to 10296" 24"
10296" to 10368" 24 1/8"
10368" to 10440" 24 1/4"
10440" to 10512" 24 1/2"
10512" to 10584" 24 3/4"
10584" to 10656" 24 7/8"
10656" to 10728" 25"
10728" to 10800" 25 1/8"
10800" to 10872" 25 1/4"
10872" to 10944" 25 1/2"
10944" to 11016" 25 3/4"
11016" to 11088" 25 7/8"
11088" to 11160" 26"
11160" to 11232" 26 1/8"
11232" to 11304" 26 1/4"
11304" to 11376" 26 1/2"
11376" to 11448" 26 3/4"
11448" to 11520" 26 7/8"
11520" to 11592" 27"
11592" to 11664" 27 1/8"
11664" to 11736" 27 1/4"
11736" to 11808" 27 1/2"
11808" to 11880" 27 3/4"
11880" to 11952" 27 7/8"
11952" to 12024" 28"
12024" to 12096" 28 1/8"
12096" to 12168" 28 1/4"
12168" to 12240" 28 1/2"
12240" to 12312" 28 3/4"
12312" to 12384" 28 7/8"
12384" to 12456" 29"
12456" to 12528" 29 1/8"
12528" to 12600" 29 1/4"
12600" to 12672" 29 1/2"
12672" to 12744" 29 3/4"
12744" to 12816" 29 7/8"
12816" to 12888" 30"
12888" to 12960" 30 1/8"
12960" to 13032" 30 1/4"
13032" to 13104" 30 1/2"
13104" to 13176" 30 3/4"
13176" to 13248" 30 7/8"
13248" to 13320" 31"
13320" to 13392" 31 1/8"
13392" to 13464" 31 1/4"
13464" to 13536" 31 1/2"
13536" to 13608" 31 3/4"
13608" to 13680" 31 7/8"
13680" to 13752" 32"
13752" to 13824" 32 1/8"
13824" to 13896" 32 1/4"
13896" to 13968" 32 1/2"
13968" to 14040" 32 3/4"
14040" to 14112" 32 7/8"
14112" to 14184" 33"
14184" to 14256" 33 1/8"
14256" to 14328" 33 1/4"
14328" to 14400" 33 1/2"
14400" to 14472" 33 3/4"
14472" to 14544" 33 7/8"
14544" to 14616" 34"
14616" to 14688" 34 1/8"
14688" to 14760" 34 1/4"
14760" to 14832" 34 1/2"
14832" to 14904" 34 3/4"
14904" to 14976" 34 7/8"
14976" to 15048" 35"
15048" to 15120" 35 1/8"
15120" to 15192" 35 1/4"
15192" to 15264" 35 1/2"
15264" to 15336" 35 3/4"
15336" to 15408" 35 7/8"
15408" to 15480" 36"
15480" to 15552" 36 1/8"
15552" to 15624" 36 1/4"
15624" to 15696" 36 1/2"
15696" to 15768" 36 3/4"
15768" to 15840" 36 7/8"
15840" to 15912" 37"
15912" to 15984" 37 1/8"
15984" to 16056" 37 1/4"
16056" to 16128" 37 1/2"
16128" to 16200" 37 3/4"
16200" to 16272" 37 7/8"
16272" to 16344" 38"
16344" to 16416" 38 1/8"
16416" to 16488" 38 1/4"
16488" to 16560" 38 1/2"
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16632" to 16704" 38 7/8"
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17064" to 17136" 39 7/8"
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17280" to 17352" 40 1/4"
17352" to 17424" 40 1/2"
17424" to 17496" 40 3/4"
17496" to 17568" 40 7/8"
17568" to 17640" 41"
17640" to 17712" 41 1/8"
17712" to 17784" 41 1/4"
17784" to 17856" 41 1/2"
17856" to 17928" 41 3/4"
17928" to 18000" 41 7/8"
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18216" to 18288" 42 1/2"
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18360" to 18432" 42 7/8"
18432" to 18504" 43"
18504" to 18576" 43 1/8"
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18648" to 18720" 43 1/2"
18720" to 18792" 43 3/4"
18792" to 18864" 43 7/8"
18864" to 18936" 44"
18936" to 19008" 44 1/8"
19008" to 19080" 44 1/4"
19080" to 19152" 44 1/2"
19152" to 19224" 44 3/4"
19224" to 19296" 44 7/8"
19296" to 19368" 45"
19368" to 19440" 45 1/8"
19440" to 19512" 45 1/4"
19512" to 19584" 45 1/2"
19584" to 19656" 45 3/4"
19656" to 19728" 45 7/8"
19728" to 19800" 46"
19800" to 19872" 46 1/8"
19872" to 19944" 46 1/4"
19944" to 20016" 46 1/2"
20016" to 20088" 46 3/4"
20088" to 20160" 46 7/8"
20160" to 20232" 47"
20232" to 20304" 47 1/8"
20304" to 20376" 47 1/4"
20376" to 20448" 47 1/2"
20448" to 20520" 47 3/4"
20520" to 20592" 47 7/8"
20592" to 20664" 48"
20664" to 20736" 48 1/8"
20736" to 20808" 48 1/4"
20808" to 20880" 48 1/2"
20880" to 20952" 48 3/4"
20952" to 21024" 48 7/8"
21024" to 21096" 49"
21096" to 21168" 49 1/8"
21168" to 21240" 49 1/4"
21240" to 21312" 49 1/2"
21312" to 21384" 49 3/4"
21384" to 21456" 49 7/8"
21456" to 21528" 50"
21528" to 21600" 50 1/8"
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21816" to 21888" 50 7/8"
21888" to 21960" 51"
21960" to 22032" 51 1/8"
22032" to 22104" 51 1/4"
22104" to 22176" 51 1/2"
22176" to 22248" 51 3/4"
22248" to 22320" 51 7/8"
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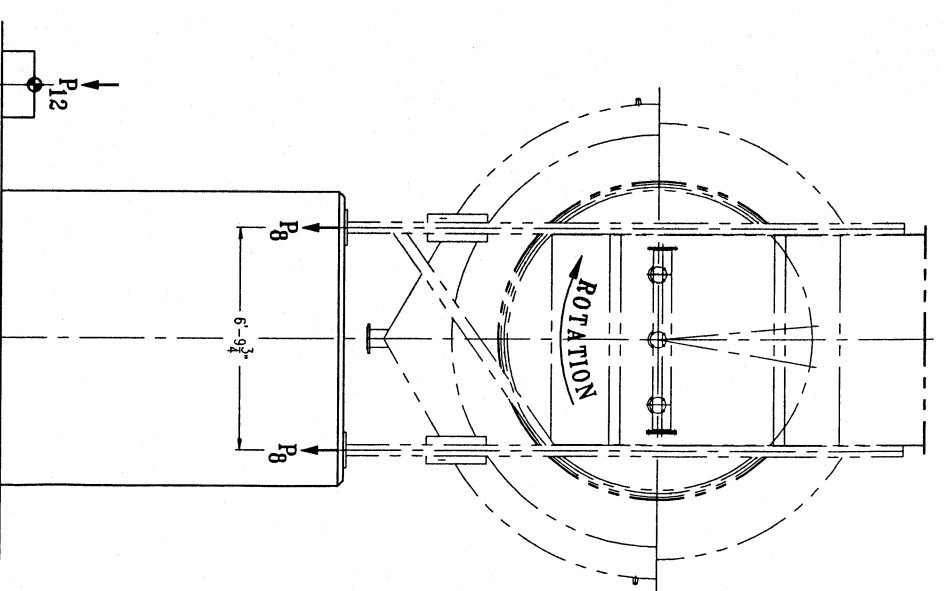
REVISIONS			
NO.	DATE	REVISIONS	BY



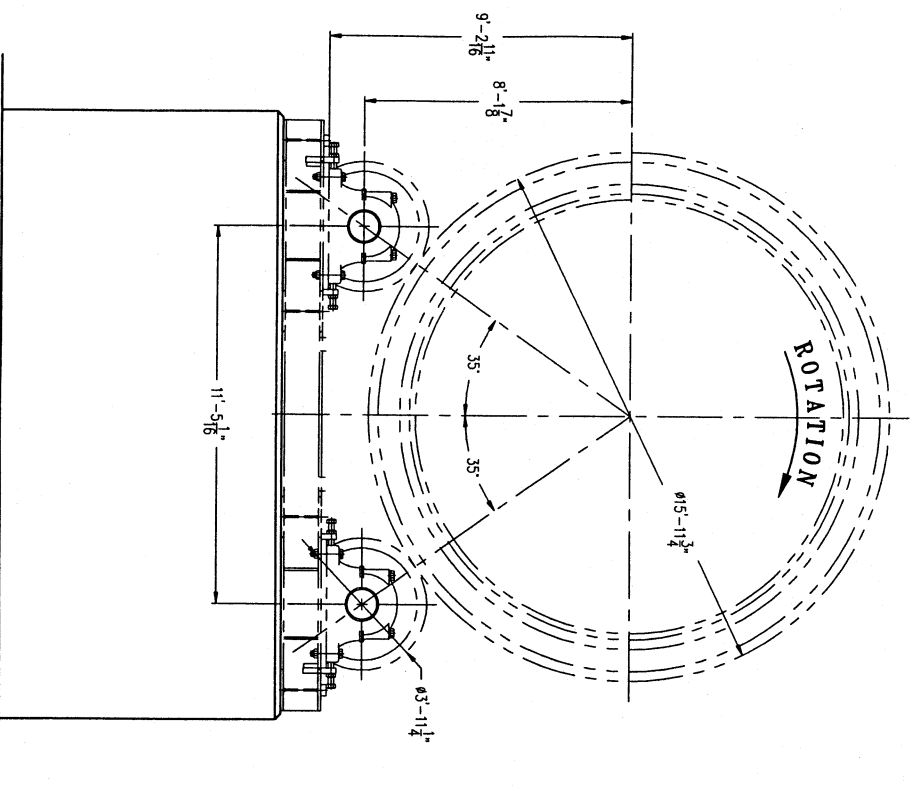
SECTION C-C



SECTION B-B



VIEW A-A



SECTION D-D

RF069
JOB NO.

Tolerance, Unless Noted Otherwise
Fractional
under 12" 3/16"
12" to 30" 1/8"
over 30" 1/4"
Decimal
2 places x .001
3 places x .010
4 places x .100
Angles: 31/32" not to exceed 1/16" per 12"

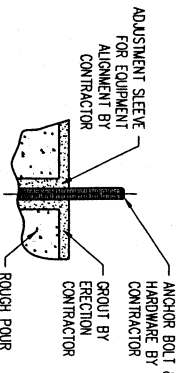
NOTES
1. THIS DRAWING IS THE PROPERTY OF ALLIANCE. IT IS TO BE USED ONLY FOR THE PROJECT AND NOT BE LOANED, REPRODUCED, COPIED, OR IN ANY MANNER DISSEMINATED OUTSIDE THE PROJECT. IT IS TO BE RETURNED TO ALLIANCE UPON REQUEST.
2. ALL DIMENSIONS ARE TO FACE UNLESS OTHERWISE NOTED.
3. ALL DIMENSIONS ARE TO BE TAKEN FROM THE CENTER OF THE DRUM OR GEAR UNLESS OTHERWISE NOTED.
4. ALL DIMENSIONS ARE TO BE TAKEN FROM THE CENTER OF THE DRUM OR GEAR UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE TO BE TAKEN FROM THE CENTER OF THE DRUM OR GEAR UNLESS OTHERWISE NOTED.

FOUNDATION
FIBERLUM 400
PULPER A-LINE H.C. DRUM
SHEET 2 OF 2
R4

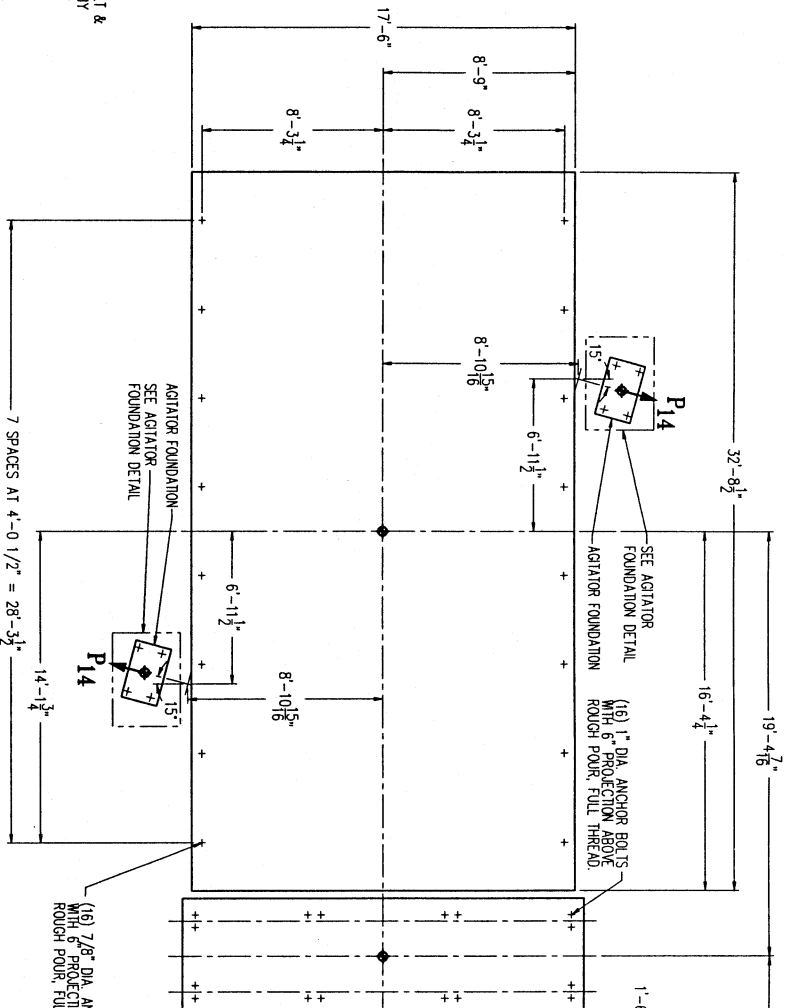
CERTIFIED
11-30-00

RECYCLE FIBER PLANT PROJECT - 1800 BOST/D ACCEPTS
ABIS PROI # ABP-001
ALLIANCE FOREST PRODUCTS U.S. CORP., PROJ. # 60-001
ALLIANCE EQUIPMENT NAME: PULPER, A-LINE H.C. DRUM
ALLIANCE EQUIPMENT # M94002
ALLIANCE DRAWING # CR-94-M-0177

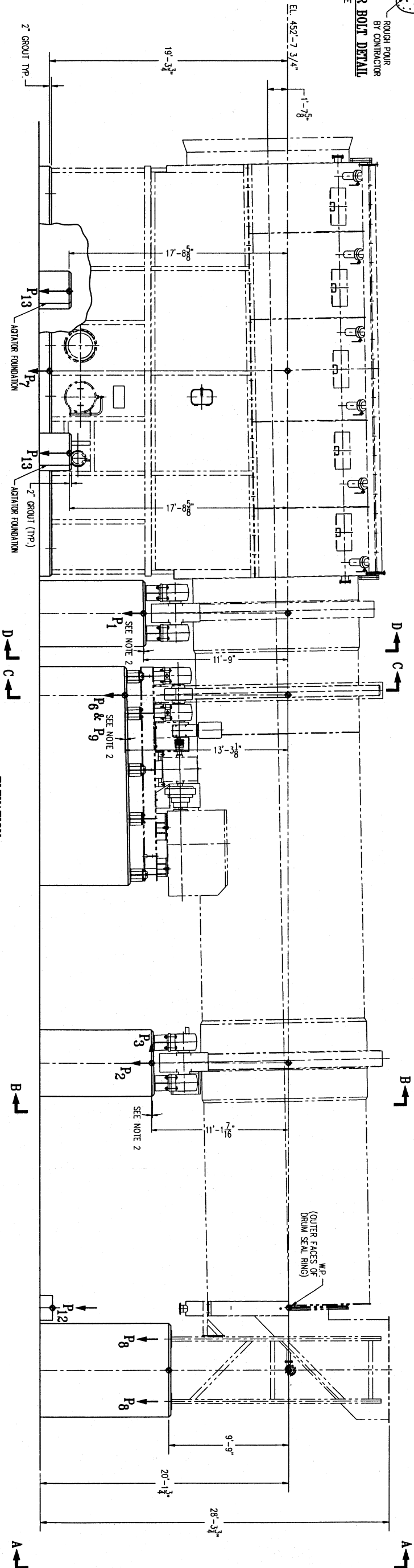
NO.	DATE	REVISIONS	BY	CHK
1	5-31-00	ISSUED		
2	8-10-00	REV FOR CUSTOMER COMMENTS	TPP	DFP
3	9-1-00	ADD DRUM CENTER ELEVATION	TPP	DFP
4	11-30-00	REVISE FOR CENTER MOTOR	TPP	DFP
5	04-17-07	MS 16-1' DIA 4 5/16" MS 3-0" 76 MS		
6	04-09-09	MS 22-26		



RECOMMENDED ANCHOR BOLT DETAIL
NOT TO SCALE



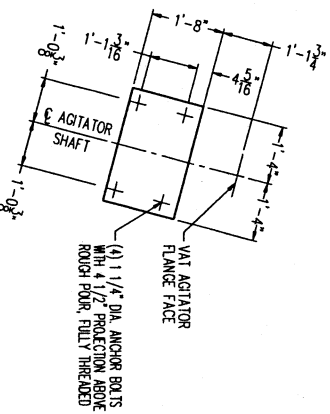
PLAN VIEW



ELEVATION

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. WIND AND SEISMIC LOAD CALCULATIONS ARE THE RESPONSIBILITY OF THE CIVIL CONTRACTOR.
5. GEAR LOADS ARE SHOWN AT CENTER OF PINION GEAR. 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 FLOOR.
6. 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.
7. SETTLEMENT:
 - DIFFERENTIAL SETTLEMENT BETWEEN ROLLER SUPPORT AND DRIVE PADS IS TO BE 0 (ALL ON ONE PAD).
 - TOTAL SETTLEMENT OF ROLLER SUPPORT AND DRIVE PADS 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".
8. ANCHOR BOLTS SHOULD BE INSTALLED WITH ADJUSTMENT SLEEVES.



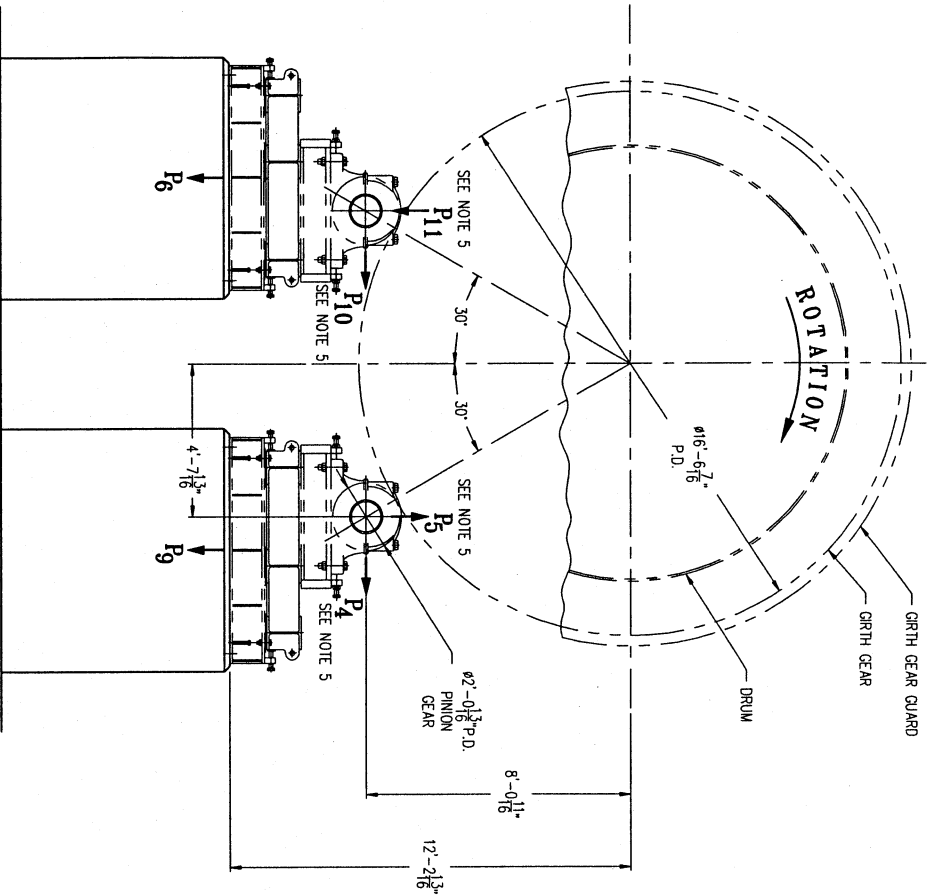
AGITATOR FOUNDATION DETAIL
SCALE: 1/2"=1'-0"

LOAD NO.	EQUIPMENT	WEIGHT (LBS)	DYNAMIC COEFFICIENT	TOTAL LOAD (LBS)	DIRECTION OF LOAD
P1	163,605	134,625	1.7	340,950	VERTICAL DOWN
P2	127,015	112,275	1.3	408,335	VERTICAL DOWN
P3	13,380	16,660	2.0	46,360	HORIZONTAL
P4	-	-	2.0	35,360	HORIZONTAL
P5	36,200	-	-	36,200	VERTICAL UP
P6	35,000	360,000	1.3	415,000	VERTICAL DOWN
P7	3,750	5,240	2.0	6,120	VERTICAL DOWN
P8	36,800	-	-	36,800	VERTICAL DOWN
P9	-	-	2.0	6,120	VERTICAL DOWN
P10	-	-	2.0	35,360	VERTICAL DOWN
P11	250	-	1	250	VERTICAL DOWN
P12	-	-	-	3,700	VERTICAL DOWN
P13	-	-	-	3,700	HORIZONTAL
P14	-	-	-	3,700	HORIZONTAL

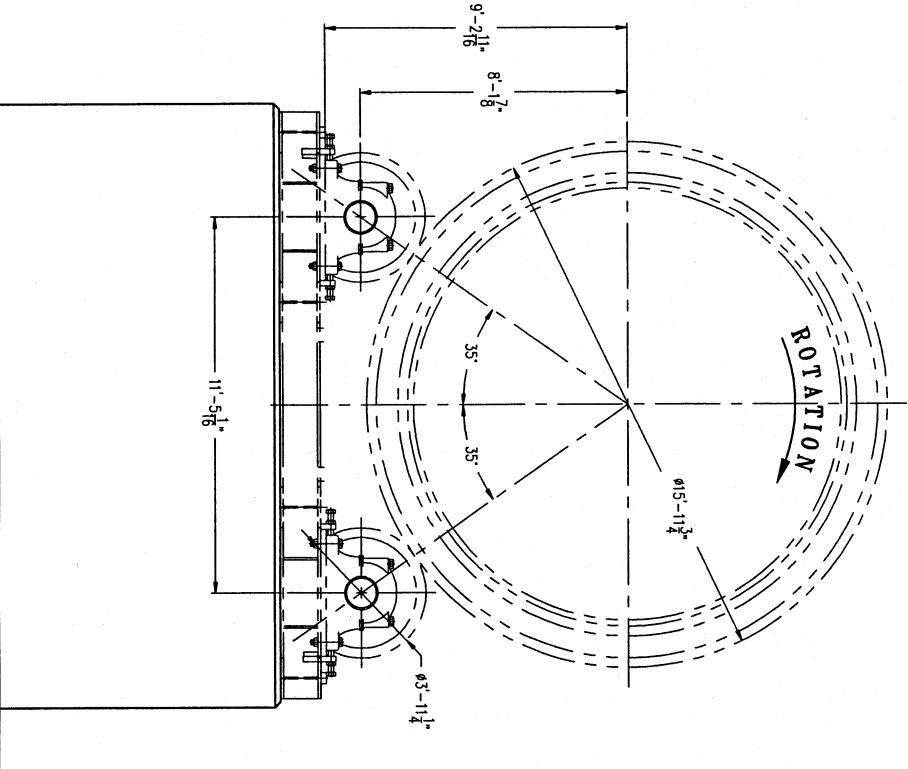
RECYCLE FIBER PLANT PROJECT - 1800 BOST/D ACCEPTS
ABCS PROJ # AFCE-001
ALLIANCE FOREST PRODUCTS U.S. CORP. PROJ # 60-0301
ALLIANCE EQUIPMENT NAME PULPER, B-LINE H.C. DRUM
ALLIANCE DRAWING # 09-94-N-078

CERTIFIED
11-30-00

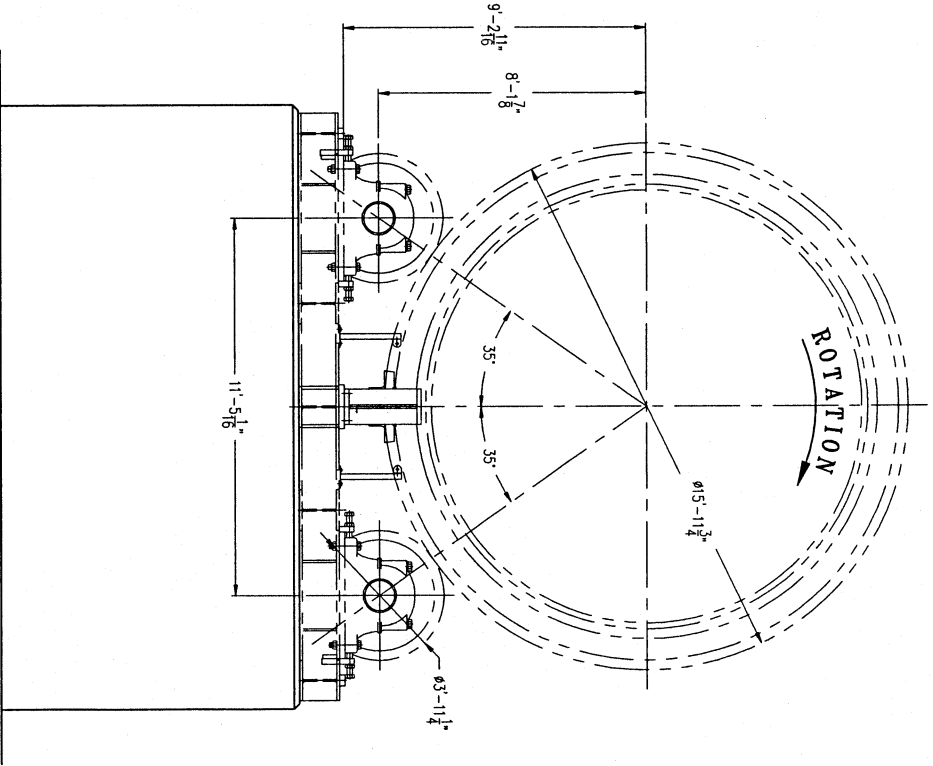
REVISIONS			
NO.	DATE	REMARKS	BY
1		SEE SHEET 1	



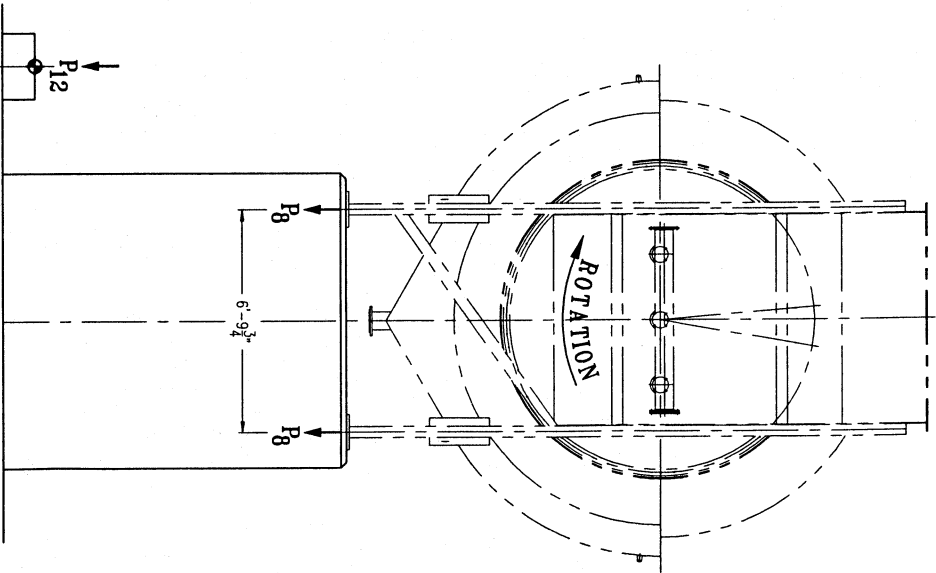
SECTION C-C



SECTION B-B



VIEW A-A



Tolerance, Unless Noted Otherwise
 Fractional
 under 12" ± 1/16"
 12" to 30" ± 1/8"
 over 30" ± 1/4"
 Angular: 31/27, not to exceed 1/16" per 12"

NOTE
 1. ALL DIMENSIONS ARE TO BE TAKEN FROM THE CENTER OF THE DRUM TO THE CENTER OF THE PINION GEAR.
 2. ALL DIMENSIONS ARE TO BE TAKEN FROM THE CENTER OF THE DRUM TO THE CENTER OF THE PINION GEAR.
 3. ALL DIMENSIONS ARE TO BE TAKEN FROM THE CENTER OF THE DRUM TO THE CENTER OF THE PINION GEAR.
 4. ALL DIMENSIONS ARE TO BE TAKEN FROM THE CENTER OF THE DRUM TO THE CENTER OF THE PINION GEAR.

FOUNDATION	FIBERFLOW 400	11-30-00
PULPER, B-LINE H.C. DRUM		
DATE	11-30-00	BY
11-30-00	11-30-00	11-30-00

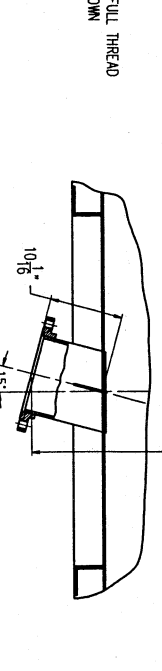
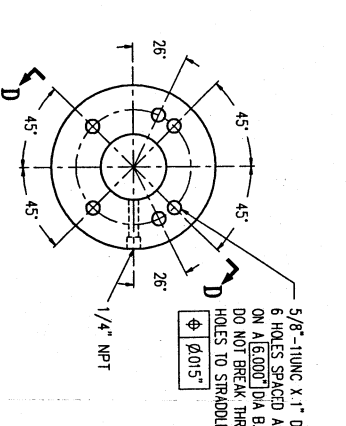
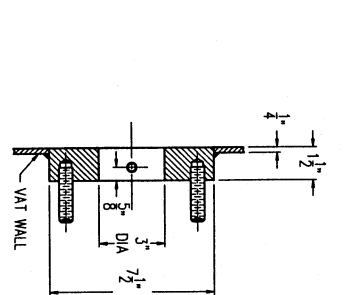
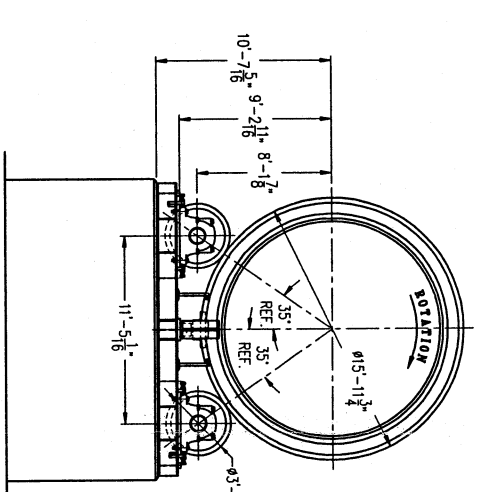
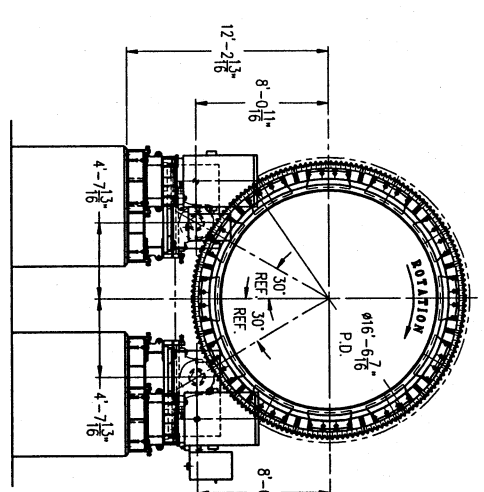
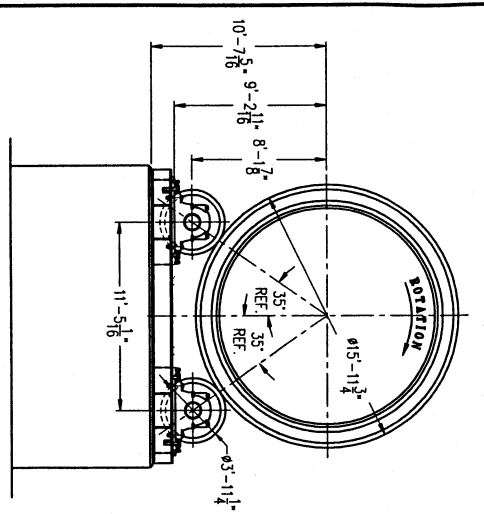
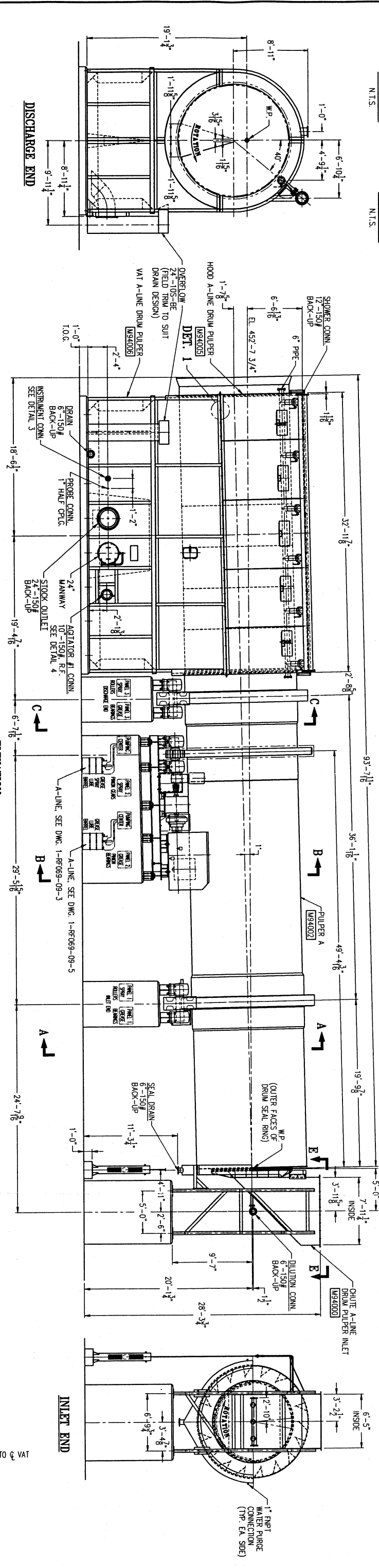
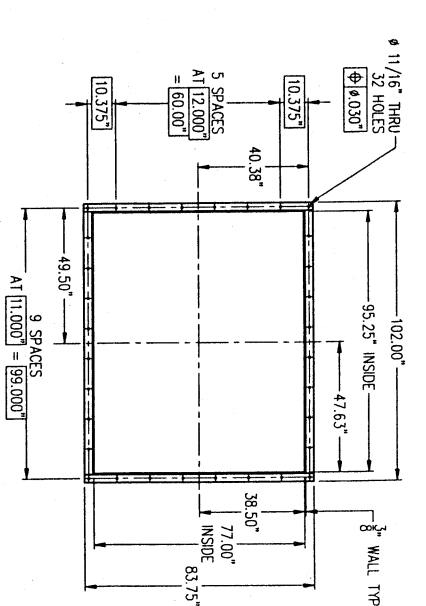
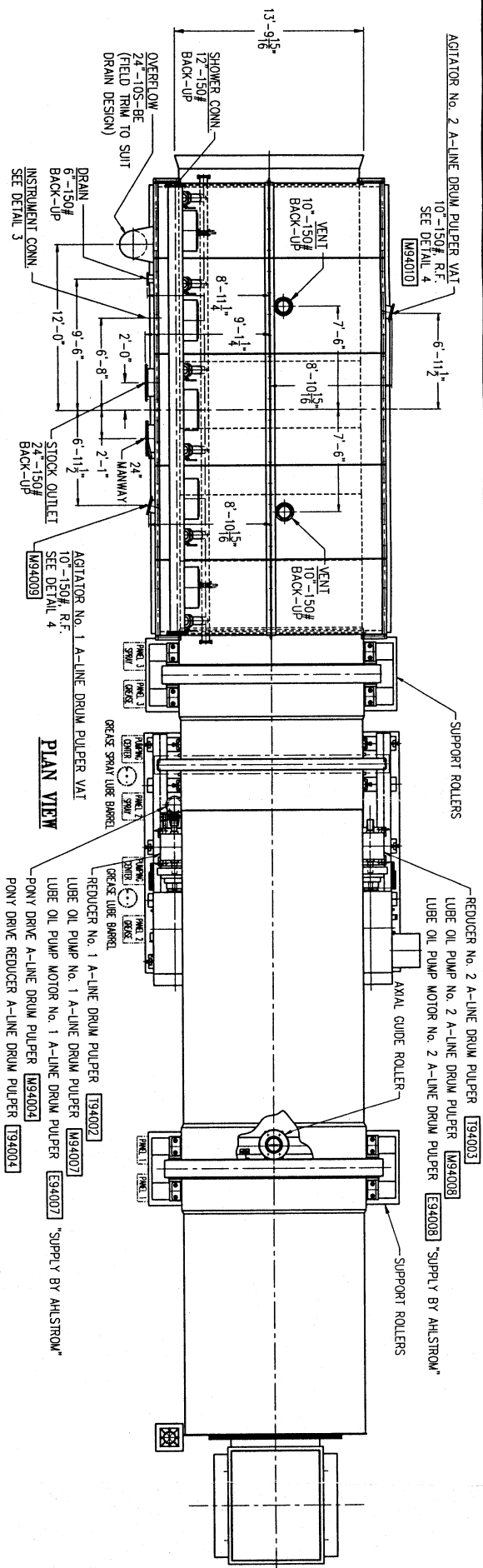
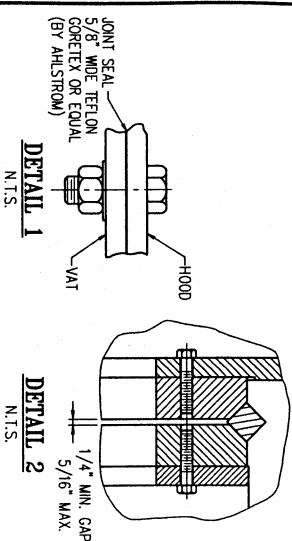
RECOTE FIBER PLANT PROJECT - 1800 BOST/D ACCEPTS
 ARCS PROJ. # AF02-001
 ALLIANCE FOREST PRODUCTS U.S. CORP., PROJ. # 60-0301
 ALLIANCE EQUIPMENT NAME PULPER, B-LINE H.C. DRUM
 ALLIANCE DRAWING # 894022
 ALLIANCE DRAWING # 02-94-M-079

CERTIFIED

REF069
 JOB NO.

SECTION D-D

REVISIONS			
NO.	DATE	REVISIONS	BY
1	5-78-00	ISSUED	-
2	8-10-00	REV PER CUSTOMER COMMENTS	TOP DE
3	9-1-00	ADD PAIR CENTRIFUGAL PUMPS	TOP DE
4	9-18-00	SHAW-WALKER DOWNS AS F-1 WORK	TOP DE
5	10-10-00	MODIFY SPA SPRAY LOCATIONS	TOP DE
6	11-30-00	REVISE PER AGS COMMENTS	TOP DE



NOTES:
1. ALL BACK-UP FLANGES WILL BE HOT DIPPED GALVANIZED.

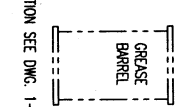
CERTIFIED

RECYCLE FIBER PLANT PROJECT - 1800 BOST/D ACCEPTS
AGS PROJ. # AGC-100
ALLIANCE FOREST PRODUCTS U.S. CORP., PROJ. # 60-0301
ALLIANCE EQUIPMENT NAME: PULPER, A-LINE H.C. DRUM
ALLIANCE DRAWING # 04-94-M-0174

REVISIONS			
NO.	DATE	REVISIONS	BY
1	9-1-00	ISSUED	SP
2	10-10-00	REVISIONS: PUMP, GEAR, VALVE	SP
3	11-2-00	REV. 6 QTY. WAS 4	SP
4	11-30-00	REV. PER AISC COMMENTS	SP

RF069
JOB NO.

FOR LOCATION SEE DWG. 1-RF069-08-1



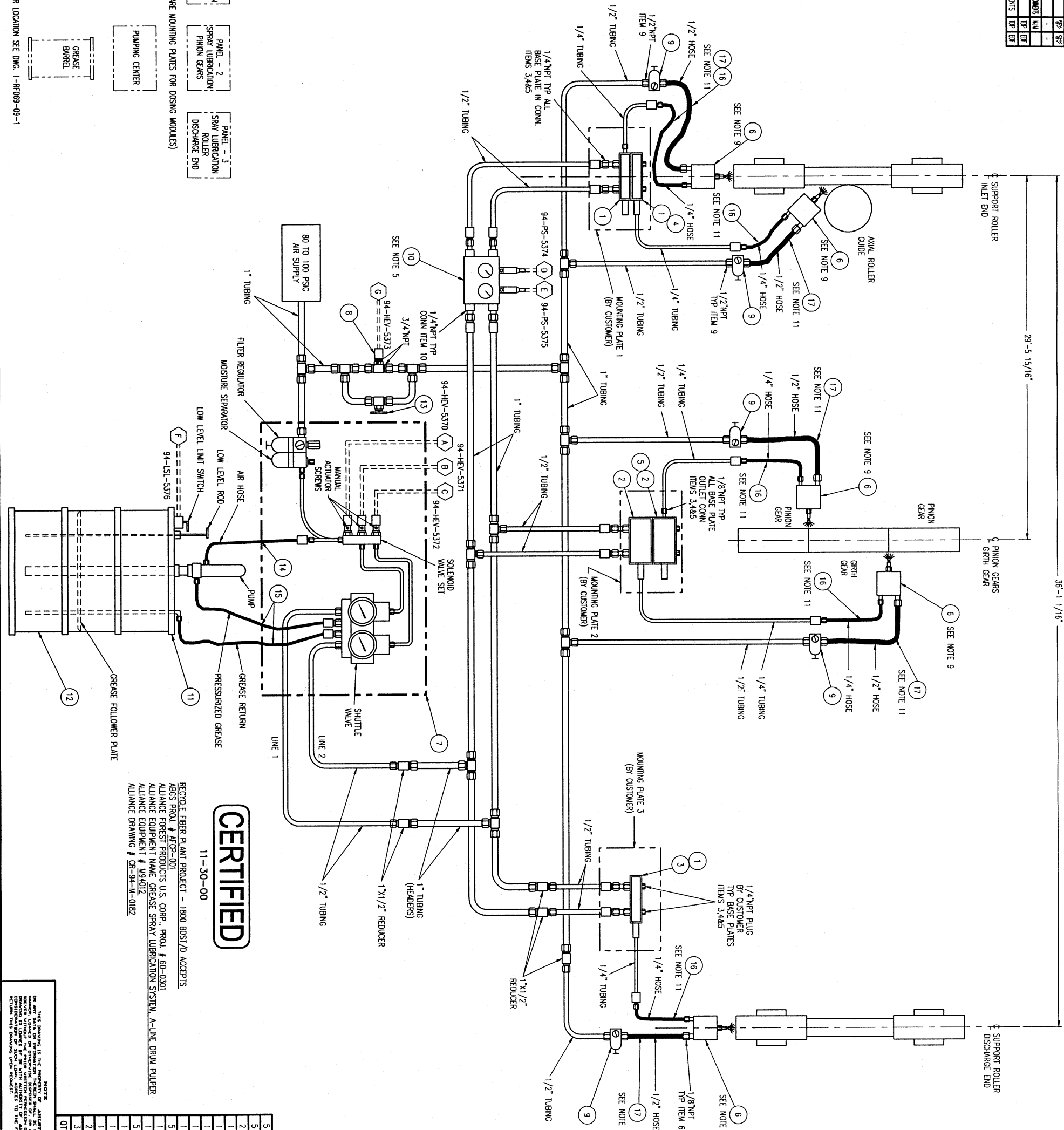
PUMPING CENTER

PANEL - 1
SPRAY LUBRICATION
ROLLERS
INLET END

PANEL - 2
SPRAY LUBRICATION
PINION GEARS

PANEL - 3
SPRAY LUBRICATION
ROLLER
DISCHARGE END

(PANELS ARE MOUNTING PLATES FOR DOSING MODULES)



CERTIFIED
11-30-00

RECYCLE FIBER PUMP PROJECT - 1800 BOSTON ACCEPTS
BOS PROL # 1800-001
ALLIANCE FOREST PRODUCTS U.S. CORP. PROJ. # 00-0301
ALLIANCE EQUIPMENT NAME: GREASE SPRAY LUBRICATION SYSTEM, A-LINE DRY PULPER
ALLIANCE EQUIPMENT # M94012
ALLIANCE DRAWING # CR-94-M-0182

ITEM	DESCRIPTION	MATERIAL	DIMENSIONS	ITEM	DWG. NO.
5	1/2" HOSE			17	BY CUSTOMER
6	1/4" HOSE			18	BY CUSTOMER
7	GREASE HOSE	SAFEMATIC		19	BY AHSSTROM
8	AIR HOSE	SAFEMATIC		20	BY AHSSTROM
9	1/2" GREASE BARREL	S.S.		21	BY AHSSTROM
10	120# GREASE BARREL	SAFEMATIC		22	BY AHSSTROM
11	PUMP AND LD SET	SAFEMATIC		23	BY AHSSTROM
12	BPSC-04 AIR PRESSURE SWITCH	SAFEMATIC		24	BY AHSSTROM
13	AIR REGULATOR 1/2" FNPT	SAFEMATIC		25	BY AHSSTROM
14	1" AIR SOLENOID VALVE (110VAC)	SAFEMATIC		26	BY AHSSTROM
15	SG-2102-U PUMPING CENTER	SAFEMATIC		27	BY AHSSTROM
16	SN-07-B5-U SPRAY NOZZLE	SAFEMATIC		28	BY AHSSTROM
17	BPSC-04 AL BASE PLATE	SAFEMATIC		29	BY AHSSTROM
18	BPSC-02 AL BASE PLATE	SAFEMATIC		30	BY AHSSTROM
19	BPSC-01 AL BASE PLATE	SAFEMATIC		31	BY AHSSTROM
20	SGA-31 ZN DOSING MODULE	SAFEMATIC		32	BY AHSSTROM
21	SGA-31 ZN DOSING MODULE	SAFEMATIC		33	BY AHSSTROM

11. FLEXIBLE HOSES PARKER SAE 100 R1 OR EQUAL. (BY CUSTOMER)
(APPROX. TOTAL LENGTH 25 FT., EACH HOSE SIZE)

10. ALL TUBING AND FITTINGS BY CUSTOMER.
TUBING AND FITTING MATERIAL TO BE 409-TP316
WALL THICKNESS: 1/4" - .085" WALL
1/2" - .092" WALL
1" - .092" WALL

9. MOUNTING BRACKETS FOR SPRAY NOZZLE (ITEM 6) MUST BE FIELD
MOUNTED TO ALLOW ADJUSTMENT 3 TO 5 INCHES FROM THE SURFACE
TO BE SPRAY LUBRICATED. EACH BRACKET INCLUDES ONE 1/4" X 1 3/4"
BOLTS FOR ADJUSTMENT OF THE BRACKET.

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" FNPT TO BE INSTALLED IN THE UNUSED HOLE
IN THE BASEPLATE.

7. EACH BASEPLATE (ITEMS 3&4) INCLUDES TWO 5/16" X 1-1/2" BOLTS
TO USE FOR ATTACHING THE BASEPLATE. NOT INCLUDED, BUT BOLTS MAY
BE USED IN A TAPPED HOLE IF BETTER SUITED.

6. MAIN HEADER SHOULD BE FLUSHED THROUGH BASEPLATES UNTIL CLEAN
GREASE, FREE OF AIR IS SEEN.

5. ALWAYS LOCATE PRESSURE SWITCH JUST BEFORE THE BASEPLATE WHICH
IS FARTHEST FROM THE PUMPING CENTER.

4. TUBING IS TO BE WELL SUPPORTED AND INSTALLED CLOSE TO FRAME
IN A WAY WHICH PROTECTS THE TUBING & FITTINGS AGAINST DAMAGE.

3. HOSES ARE TO BE FILLED WITH GREASE BEFORE INSTALLATION.
2. QUARTER INCH TUBING IS TO BE FILLED WITH GREASE BEFORE CUTTING.
1. ALL TUBING IS TO BE CLEANED BY BLOWING CLEAN DRY AIR PRIOR TO
INSTALLATION AND CAPPED THEREAFTER.

NOTES:
PROGRAM THE GREASE PUMP TO START AT THE DESIRED DOSING 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 DOSING SYSTEM IS A
DUAL LINE TYPE. WHEN THE DOSING MODULE IS FILLING, THE PILOT POSITION POSSES
GREASE OUT TO THE COMPONENT TO BE GREASED. WHEN SHUTTLE VALVE ALTERNATES,
THE DOSING MODULE PILOT POSITION FUNCTIONS IN REVERSE FOR NEXT PUMP RUN.
THE AIR SOLENOID VALVE IS TO BE PROGRAMMED TO START WHEN THE PUMP IS
STARTED AND TO STOP AT LEAST 10 SECONDS AFTER THE PUMP STOPS.

FUNCTIONAL DESCRIPTION FOR SPRAY LUBRICATION SYSTEM

- SIGNAL TO START GREASE PUMP. SIGNAL IS 120 VOLTS AC TO OPEN SOLENOID VALVE.
- SIGNAL TO MOVE SHUTTLE VALVE FOR GREASE FLOW TO GREASE LINE #1. CUSTOMER
SUPPLIES 120 VOLTS AC SIGNAL TO SOLENOID VALVE.
- SIGNAL TO MOVE SHUTTLE VALVE FOR GREASE FLOW TO GREASE LINE #2. CUSTOMER
SUPPLIES 120 VOLTS AC SIGNAL TO SOLENOID VALVE.
- 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.
- 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.
- FEED BACK TO INDICATE WHEN GREASE BARREL IS EMPTY. CUSTOMER TO PROVIDE
120 VOLT AC ELECTRICAL CURRENT TO THE SWITCH.
- SIGNAL TO START AIR FLOW TO GREASE NOZZLES. CUSTOMER SUPPLIES 120 VOLTS
AC SIGNAL TO SOLENOID VALVE.

LOGIC FOR DCS

REVISIONS			
REV	DATE	REVISIONS	BY
1	5-1-00	Issued	-
2	10-10-00	RECD TO DISCARD FROM DRAWING	AW
3	11-2-00	REV 6 DIT, MISC 4	TP
4	11-30-00	REV PER AGOS COMMENTS	TP

RF069
JOB NO.

FOR LOCATION SEE DWG. 1-RF069-09-2

PANEL - 1
SPRAY LUBRICATION,
ROLLERS
INLET END

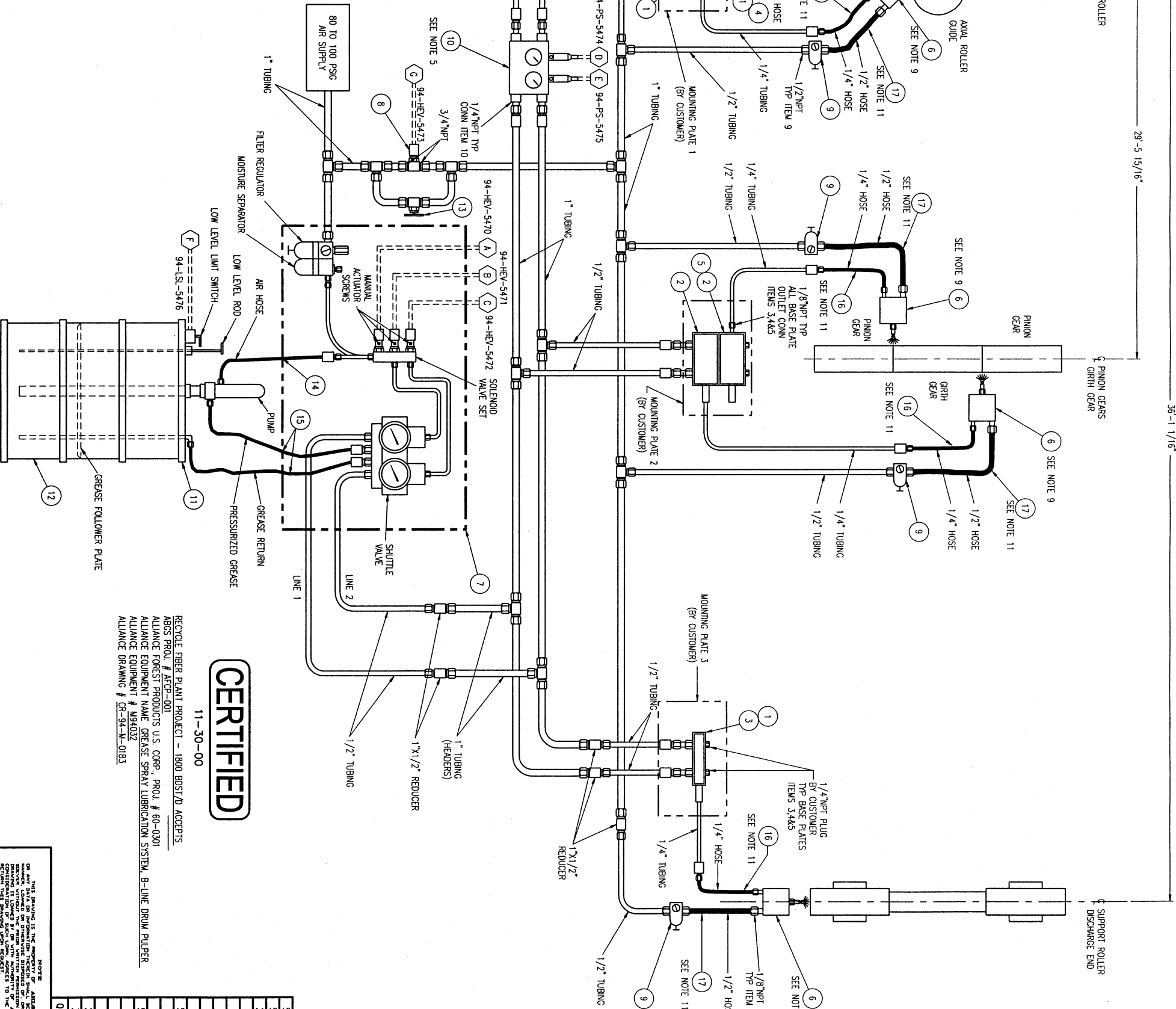
PANEL - 2
SPRAY LUBRICATION,
PINION GEARS

PANEL - 3
SPRAY LUBRICATION,
ROLLER
DISCHARGE END

(PANELS ARE MOUNTING PLATES FOR DOSING MODULES)

PUMPING CENTER

GREASE
BARREL



11-30-00

CERTIFIED

RECYCLE FIBER PLANT PROJECT - 1800 BOST/D ACCEPTS
AGOS PROJ. # ACP-001
ALLIANCE FOREST PRODUCTS U.S. CORP. PROJ. # 60-0301
ALLIANCE EQUIPMENT NAME GREASE SPRAY LUBRICATION SYSTEM, B-LINE DRUM PULPER
ALLIANCE EQUIPMENT # M94032
ALLIANCE DRAWING # CR-94-M-0183

FUNCTIONAL DESCRIPTION FOR SPRAY LUBRICATION SYSTEM

- 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.
- G SIGNAL TO START AIR FLOW TO GREASE NOZZLES. CUSTOMER SUPPLIES 120 VOLTS AC SIGNAL TO SOLENOID VALVE.

LOGIC FOR DCS

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 TUNING, THE PILOT PISTON PUNCHES GREASE OUT TO THE COMPONENT TO BE GREASED. WHEN SHUTTLE VALVE ALTERNATES, THE DOSING MODULE PILOT PISTON FUNCTIONS IN REVERSE FOR NEXT PUMP RUN. THE AIR SOLENOID VALVE IS TO BE PROGRAMMED TO START WHEN THE PUMP IS STARTED AND TO STOP AT LEAST 10 SECONDS AFTER THE PUMP STOPS.

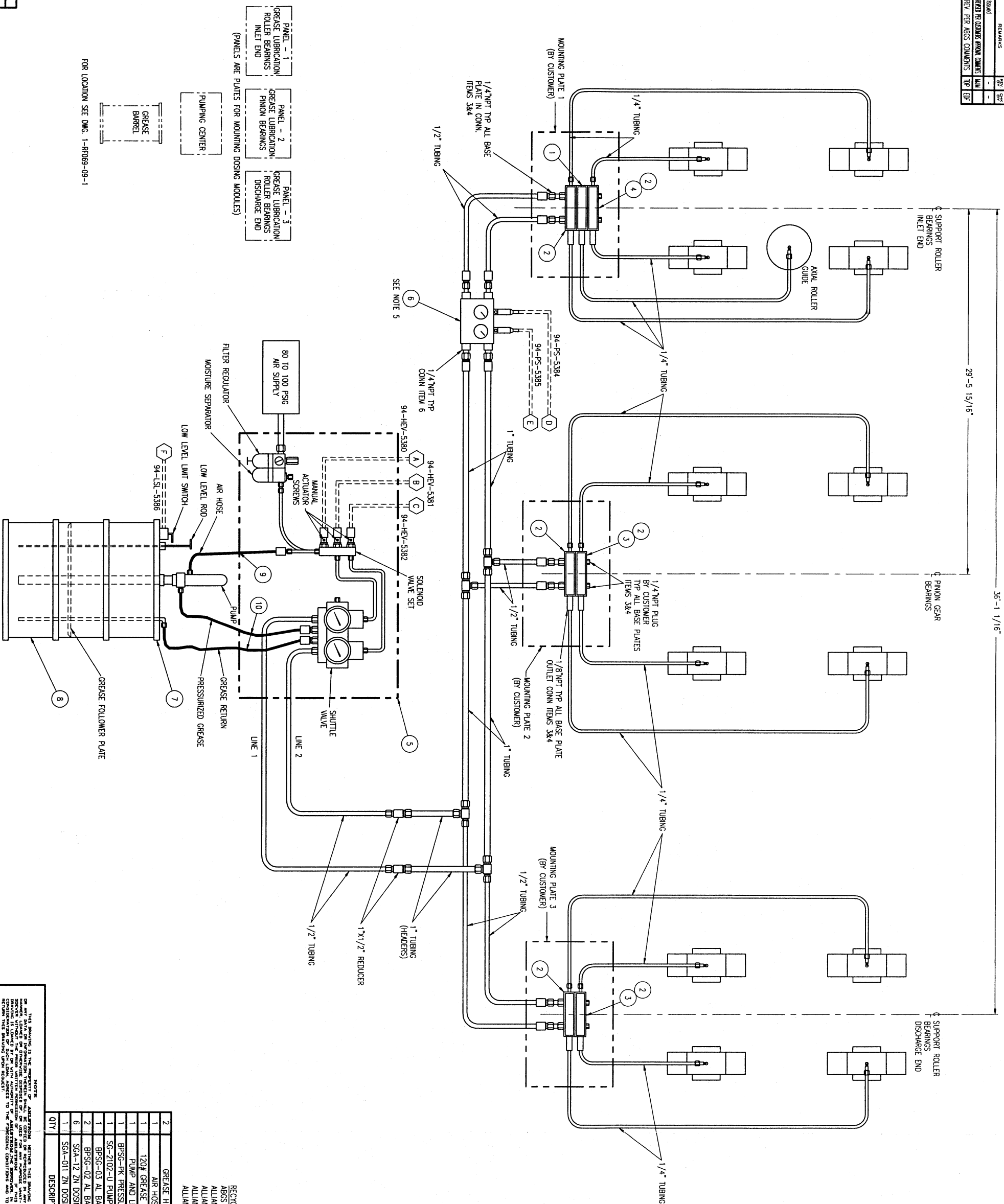
NOTES:

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) 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 IF 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. MOUNTING BRACKETS FOR SPRAY NOZZLE (ITEM 6) MUST BE FIELD MOUNTED TO ALLOW ADJUSTMENT 3 TO 5 INCHES FROM THE SURFACE TO BE SPRAY LUBRICATED. EACH BRACKET INCLUDES ONE 1/4" X 1 3/4" BOLTS FOR ADJUSTMENT OF THE BRACKET.
10. ALL TUBING AND FITTINGS BY CUSTOMER. TUBING AND FITTING MATERIAL TO BE A289-TP316 WALL THICKNESS 1/2" - .035" WALL 1" - .092" WALL
11. FLEXIBLE HOSES PARKER SAE 100 R1 OR EQUAL. (BY CUSTOMER) (APPROX. TOTAL LENGTH 25 FT., EACH HOSE SIZE)

QTY	DESCRIPTION	MATERIAL	DIMENSIONS	ITEM	DWG. NO.
5	1/2" HOSE			17	BY CUSTOMER
5	1/4" HOSE			16	BY CUSTOMER
2	GREASE HOSE	SAFEMATIC		15	BY AHSISTROM
1	AIR HOSE	SAFEMATIC		14	BY AHSISTROM
1	BALL VALVE, 1" NPT	S.S.		13	BY AHSISTROM
1	120# GREASE BARREL	SAFEMATIC		12	BY CUSTOMER
1	PUMP AND LID SET	SAFEMATIC		11	BY AHSISTROM
1	BPSC-PK PRESSURE SWITCH	SAFEMATIC		10	BY AHSISTROM
5	AIR REGULATOR, 1/2" NPT	SAFEMATIC		9	BY AHSISTROM
1	T AIR SOLENOID VALVE (T10VAC)	SAFEMATIC		8	BY AHSISTROM
1	SG-2102-U PUMPING CENTER	SAFEMATIC		7	BY AHSISTROM
5	SN-07-BS-U SPRAY NOZZLE	SAFEMATIC		6	BY AHSISTROM
1	BPSC-04 AL BASE PLATE	SAFEMATIC		5	BY AHSISTROM
1	BPSC-02 AL BASE PLATE	SAFEMATIC		4	BY AHSISTROM
1	BPSC-01 AL BASE PLATE	SAFEMATIC		3	BY AHSISTROM
2	SGA-31 ZN DOSING MODULE	SAFEMATIC		2	BY AHSISTROM
3	SGA-21 ZN DOSING MODULE	SAFEMATIC		1	BY AHSISTROM

GREASE SPRAY LUBRICATION SYSTEM				AHSISTROM	
FIBERFLOW 400				DESIGN CENTER	
B-LINE DRUM PULPER				11-RF069-09-4	
REVISED BY	DATE	REVISED BY	DATE	R4	
1	10/10/00	1	10/10/00		

REVISIONS				
REV NO.	DATE	REMARKS	REV BY	CHK BY
1	9-1-00	Issued	-	-
2	10-10-00	REPLY PER CUSTOMER APPROV. COMMENTS	MAN	
3	11-30-00	REPLY PER AEGIS COMMENTS	TOP	ENR



FUNCTIONAL DESCRIPTION FOR GREASE LUBRICATION SYSTEM

- A. SIGNAL TO START GROSS PUMP. SIGNAL IS 120 VOLTS AC TO OPEN SLOWED VALVE.
- B. SIGNAL TO MOVE SHUTTLE VALVE FOR GROSS FLOW TO GROSS LINE #1. CUSTOMER SUPPLIES 120 VOLTS AC SIGNAL TO SLOWED VALVE.
- C. SIGNAL TO MOVE SHUTTLE VALVE FOR GROSS FLOW TO GROSS LINE #2. CUSTOMER SUPPLIES 120 VOLTS AC SIGNAL TO SLOWED VALVE.
- D. FEEDBACK TO INDICATE THAT GROSS HAS COMPLETED FILLING OF ALL ISOSING MODELS FROM LINE #1. WHEN PRESSURE IS COMPLETE, PRESSURE INDICATORS IN GROSS 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 GROSS HAS COMPLETED FILLING OF ALL ISOSING MODELS FROM LINE #2. WHEN LINE #2 IS COMPLETE, PRESSURE INDICATORS IN GROSS 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 GROSS BEARS A SHUT. CUSTOMER TO PROVIDE 120 VOLT AC ELECTRICAL CURRENT TO THE SWITCH.

LOGIC FOR DCS

PROGRAM THE CHARGE PUMP TO START AT THE DESIRED CHARGING TIME INTERVAL. ALSO PROGRAM LENGTH OF TIME FOR PUMP TO RUN. PUMP RUN TIME IS TO BE LONGER THAN CHARGING TIME. CHARGING TIME IS TO BE LONGER THAN PUMP RUN TIME. CHARGE PUMP TO BE STOPPED AFTER CHARGING TIME. SWITCH CONTACT FOR ALL CHARGING DOMING MODULES TO TIE WITH CHARGE. CHARGE SWITCH CONTACT WILL CLOSE AFTER ALL CHARGING MODULES ARE FILLED WITH PRESSURE. 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 WAVE EXTENDERS ARE TO BE ALTERNATED BETWEEN A & B EACH TIME THE PUMP IS STARTED. THE CHARGING SYSTEM IS TO BE DUAL, I.E. THE WHEN THE CHARGING MODULE IS FILLING, THE PILOT PISTON PORCES CHARGE OUT TO THE COMPARTMENT TO BE CHARGED. WHEN THE WAVE ALTERNATES, THE CHARGING MODULE PILOT PISTON FUNCTIONS IN REVERSE FOR NEXT PUMP RUN.

NOTES:

1. ALL TUBING IS TO BE CLEANED BY BLOWING CLEAN DRY AIR PRIOR TO INSTALLATION AND CAPPED HERMETICALLY.
2. QUARTER NON TUBING IS TO BE FLUED WITH GREESE BEFORE CUTTING.
3. HOSES ARE TO BE FLUED WITH GREESE BEFORE INSTALLATION.
4. TUBING IS TO BE WELL SHIPPED AND INSTALLED CLOSE TO FRAME IN A WAY WHICH PROTECTS THE TUBING & FITTINGS AGAINST DAMAGE.
5. ALWAYS LOCKE PRESSURE SWITCH JUST BEFORE THE BASEPLATE WHICH IS FARTHEST FROM THE PUMPING CENTER.
6. MAIN VIEWS SHOULD BE CUSHED THROUGH BASEPLATES UNTIL CLEAN GREESE, FREE OF AIR IS SEEN.
7. EACH BASEPATE (TUBES 34&5) INCLUDES TWO 1/4"x1-1/2" BOOTS TO BE USED IN PUMPING THE BASEPATE, BUT INCLUDED, BUT BOOTS MAY BE USED IN A PUMPED HOLE IF BETTER SUITED.
8. EACH GROUND WORMIE (TUBES 1&2) INCLUDES TWO BOOTS FOR MOUNTING IT TO THE BASEPATE. THEY MAY BE USED FOR OTHER PURPOSES, ALSO INCLUDED IS ONE 1/4" RIGID 1/8" NPT TO BE INSTALLED IN THE UNUSED HOLE IN THE BASEPATE.
9. ALL TUBING AND FITTINGS AT CUSTOMER, TUBING AND FITTING MATERIAL TO BE A289-87316 WALL THICKNESS: 1/4" - .035" WILL 1/2" - .062" WALL

CERTIFIED
11-30-00

RECJOE FIBER PLANT PROJECT - 1800 BPS/D ACCEPTS.
ABOS PROJ # AECR-001
ALLANCE FOREST PRODUCTS U.S. CORP. PROJ # 60-0301
ALLANCE EQUIPMENT NAME GREASE LUBRICATION SYSTEM, A-LINE DRUM PULPER
ALLANCE EQUIPMENT # M94013
ALLANCE DRAWING # CR-94-M-0184

QTY	DESCRIPTION	MATERIAL	DIMENSIONS	ITEM	DWG. NO.
2	GREASE HOSE	SAFEMATIC	10	BY A41STROM	
1	AIR HOSE	SAFEMATIC	9	BY A41STROM	
1	120# GREASE BARREL		8	BY CUSTOMER	
1	PUMP AND LID SET	SAFEMATIC	7	BY A41STROM	
1	BPSC-PK PRESSURE SWITCH	SAFEMATIC	6	BY A41STROM	
1	SG-2102-U PUMPING CENTER	SAFEMATIC	5	BY A41STROM	
1	BPSC-03 AL BASE PLATE	SAFEMATIC	4	BY A41STROM	
2	BPSC-02 AL BASE PLATE	SAFEMATIC	3	BY A41STROM	
6	SGA-12 ZN DOWNG NOZZLE	SAFEMATIC	2	BY A41STROM	
1	SGA-011 ZN DOWNG MODULE	SAFEMATIC	1	BY A41STROM	

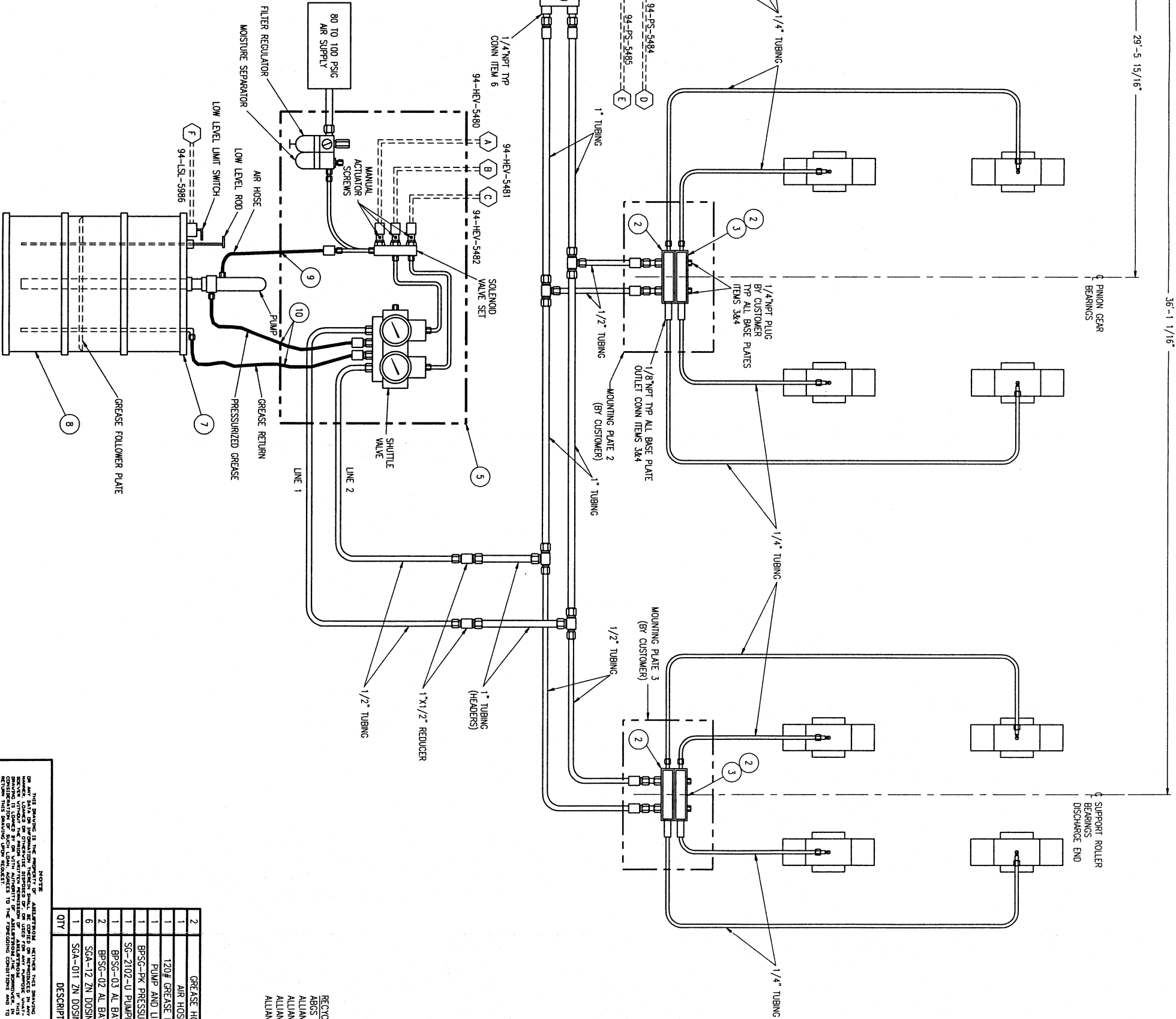
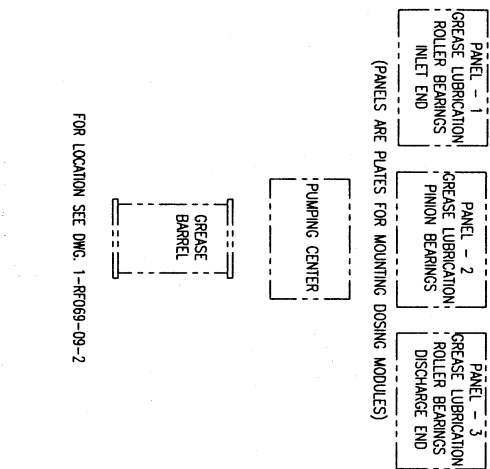
RF069
JOB NO.

REVISIONS			
NO.	DATE	REVISIONS	BY
1	5-1-00	ISSUED	-
2	10-10-00	REVISED FOR DOSING FROM CUSTOMER	ALM
3	11-30-00	REVISED FOR DOSING FROM CUSTOMER	TPP

RF069

JOB NO.

FOR LOCATION SEE DWG. 1-RF069-09-2



FUNCTIONAL DESCRIPTION FOR GREASE LUBRICATION SYSTEM

- Signal to start grease pump. Signal is 120 volts AC to open solenoid valve.
- Signal to move shuttle valve for grease flow to grease line #1. Customer supplies 120 volts AC signal to solenoid valve.
- Signal to move shuttle valve for grease flow to grease line #2. Customer supplies 120 volts AC signal to solenoid valve.
- 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.
- 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.
- Feedback to indicate when grease barrel is empty. Customer to provide 120 volt AC electrical current to the switch.

LOGIC FOR DCS

PROGRAM THE GREASE PUMP TO START AT THE DESIRED DOSING 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 DOSING 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.

NOTES:

- ALL TUBING IS TO BE CLEANED BY BLOWING CLEAN DRY AIR PRIOR TO INSTALLATION AND CAPPED THEREAFTER.
- QUARTER INCH TUBING IS TO BE FILLED WITH GREASE BEFORE CUTTING.
- HOSES ARE TO BE FILLED WITH GREASE BEFORE INSTALLATION.
- TUBING IS TO BE WELL SUPPORTED AND INSTALLED CLOSE TO FRAME IN A WAY WHICH PROTECTS THE TUBING & FITTINGS AGAINST DAMAGE.
- ALWAYS LOCATE PRESSURE SWITCH JUST BEFORE THE BASEPLATE WHICH IS FARTHEST FROM THE PUMPING CENTER.
- MAIN HEADERS SHOULD BE FLUSHED THROUGH BASEPLATES UNTIL CLEAN GREASE, FREE OF AIR IS SEEN.
- EACH BASEPLATE (ITEMS 3&4&5) INCLUDES TWO 5/16"x1-1/2" BOLTS TO USE FOR ATTACHING THE BASEPLATE. NUT INCLUDED, BUT BOLTS MAY BE USED IN A TAPPED HOLE IF BETTER SUITED.
- 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"WPT TO BE INSTALLED IN THE UNUSED HOLE IN THE BASEPLATE.
- ALL TUBING AND FITTINGS BY CUSTOMER. TUBING AND FITTING MATERIAL TO BE KOB-12016 WALL THICKNESS: 1/4" - .035" WALL 1/2" - .062" WALL 1" - .092" WALL

CERTIFIED

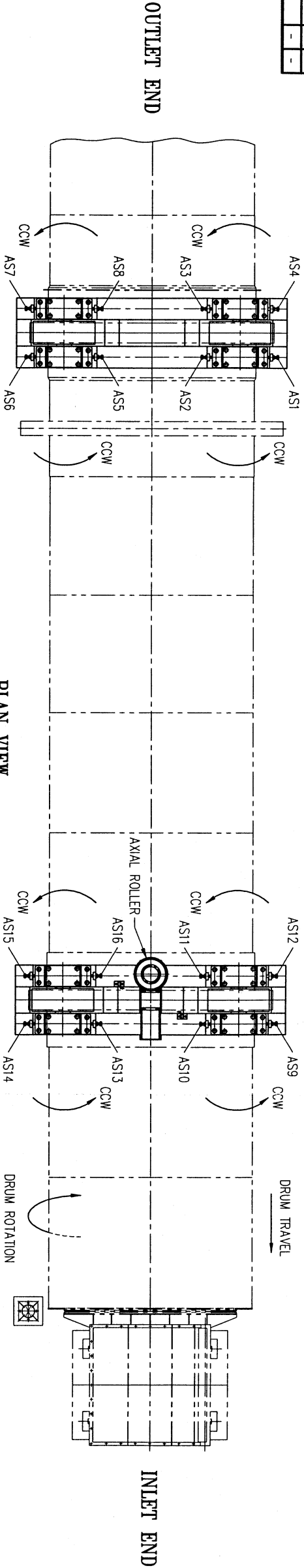
11-30-00

RECYCLE FIBER PLANT PROJECT - 1800 BOST/D ACCEPTS
 ABOS PROJ. # AFOP-001
 ALLIANCE FOREST PRODUCTS U.S. CORP., PROJ. # 60-0301
 ALLIANCE EQUIPMENT NAME GREASE LUBRICATION SYSTEM, B-LINE DRUM PULPER
 ALLIANCE EQUIPMENT # M94033
 ALLIANCE DRAWING # CR-94-M-0185

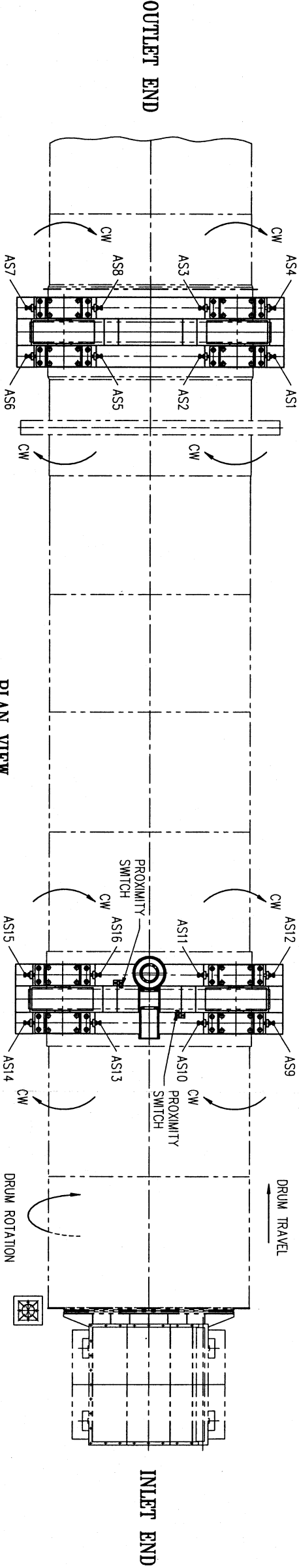
QTY	DESCRIPTION	MATERIAL	DIMENSIONS	ITEM	DWG. NO.
2	GREASE HOSE	SAFEMATIC		10	BY AH:STROM
1	AIR HOSE	SAFEMATIC		9	BY AH:STROM
1	120# GREASE BARREL			8	BY CUSTOMER
1	PUMP AND LID SET	SAFEMATIC		7	BY AH:STROM
1	BPSC-PK PRESSURE SWITCH	SAFEMATIC		6	BY AH:STROM
1	SG-2102-U PUMPING CENTER	SAFEMATIC		5	BY AH:STROM
1	BPSC-03 AL BASE PLATE	SAFEMATIC		4	BY AH:STROM
2	BPSC-02 AL BASE PLATE	SAFEMATIC		3	BY AH:STROM
6	SGA-12 ZN DOSING NOZZLE	SAFEMATIC		2	BY AH:STROM
1	SGA-01 ZN DOSING MODULE	SAFEMATIC		1	BY AH:STROM

GREASE LUBRICATION SYSTEM				AH:STROM	
FIBERFLOW 400				BOSTON, MASSACHUSETTS 02111	
DATE	BY	CHECK	DATE	DATE	BY
10/10/00	ALM	TPP	10/10/00	11-30-00	R3

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

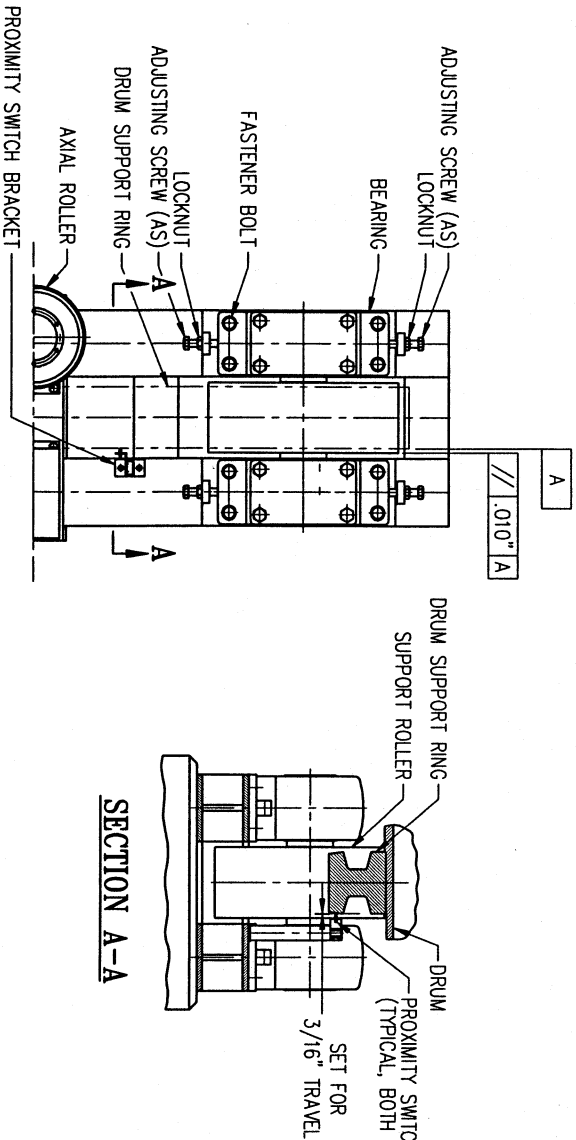


- LOOSEN ALL FASTENER BOLTS
- LOOSEN ALL LOCKNUTS
- LOOSEN ODD NUMBERED ADJUSTING SCREWS 1/4 TURN
- TIGHTEN EVEN NUMBERED ADJUSTING SCREWS 1/4 TURN
- TIGHTEN ALL LOCKNUTS
- TIGHTEN ALL FASTENER BOLTS



- 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

- 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.

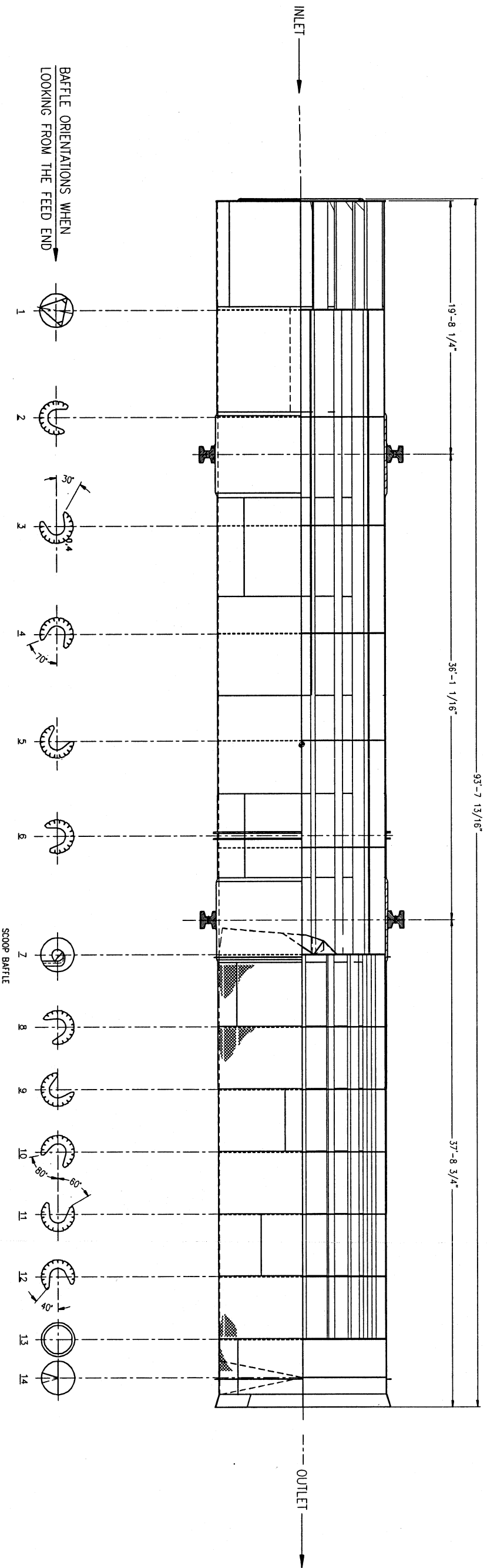


IMPORTANT !!!
IF DRUM ROTATION IS OPPOSITE HAND, REVERSE PROCEDURES.

CAUTION !!!
STOP DRUM BEFORE PERFORMING ADJUSTMENTS

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: $\pm 1/2'$, not to exceed 1/16" per 12"	
NOTE: THIS DRAWING IS THE PROPERTY OF AIRSTROM. NEITHER THIS DRAWING OR ANY DATA OR INFORMATION THEREIN SHALL BE COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF AIRSTROM. IF THIS DRAWING IS LOANED BY OR WITH AUTHORITY OF AIRSTROM, THE BORROWER, IN RETURN, THIS DRAWING AND RECORDS.	
CLOCKWISE ROTATING DRUM TRAVEL ADJUSTMENT INSTRUCTIONS FIBREFLOW DRUM	
DRAWN BY	DATE
TPP	5-8-00
CHECKED BY	DATE
TPP	5-8-00
2-26009-03 R1	

REVISIONS			
NO.	DATE	REVISIONS	BY
1	03/10	-	-



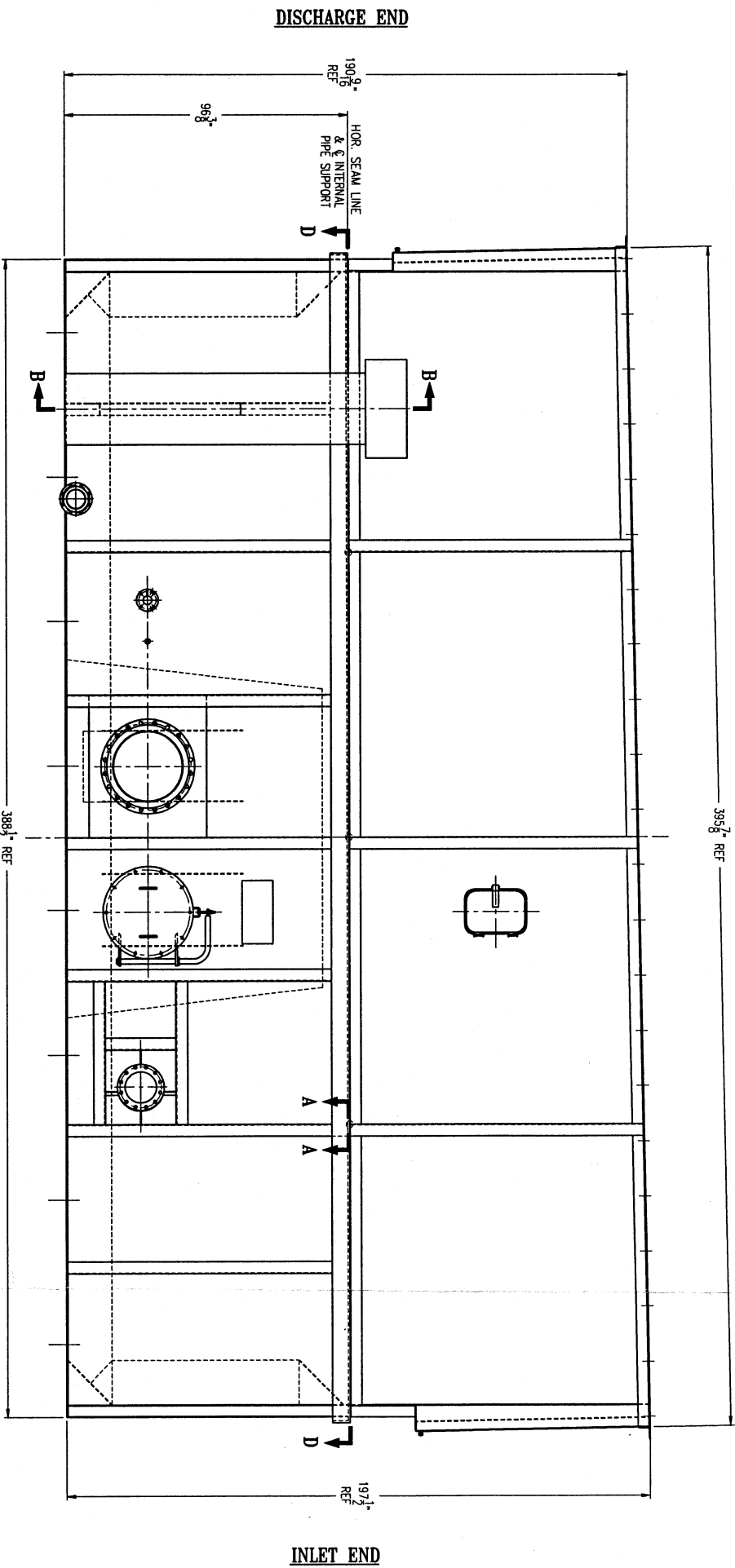
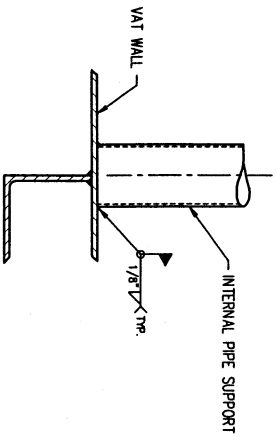
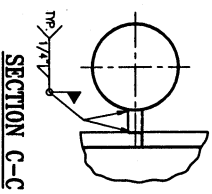
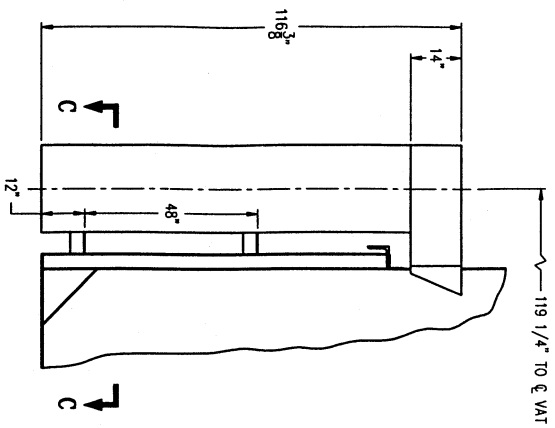
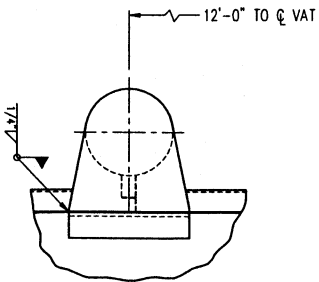
REF: 069
JOB NO.

Tolerance, Unless Noted Otherwise
Fractional
under 12" 3/16"
12" to 120" 3/8"
over 120" 1/2"
Decimals
2 places max ±.05"
3 places max ±.010"
Angles: 31/27, not to exceed 1/16" per 12"

NOTE:
The drawing is the property of the drafter and is not to be used for any purpose without the written consent of the drafter. The drafter is not responsible for any errors or omissions in the drawing. The drafter is not responsible for any damage or injury resulting from the use of the drawing. The drafter is not responsible for any loss of data or information resulting from the use of the drawing. The drafter is not responsible for any other consequences resulting from the use of the drawing.

FIBERFLOW DRUM
BAFFLE ORIENTATION
FIBERFLOW 400
Scale: 1/4"=1'-0" Part: 18-4-00
1-26009-18 R1

REVISIONS			
NO.	DATE	REVISIONS	BY
1	11-1-00	Issued	-



ELEVATION

SECTION B-B

SECTION C-C

SECTION A-A

REF: 069

JOB NO.

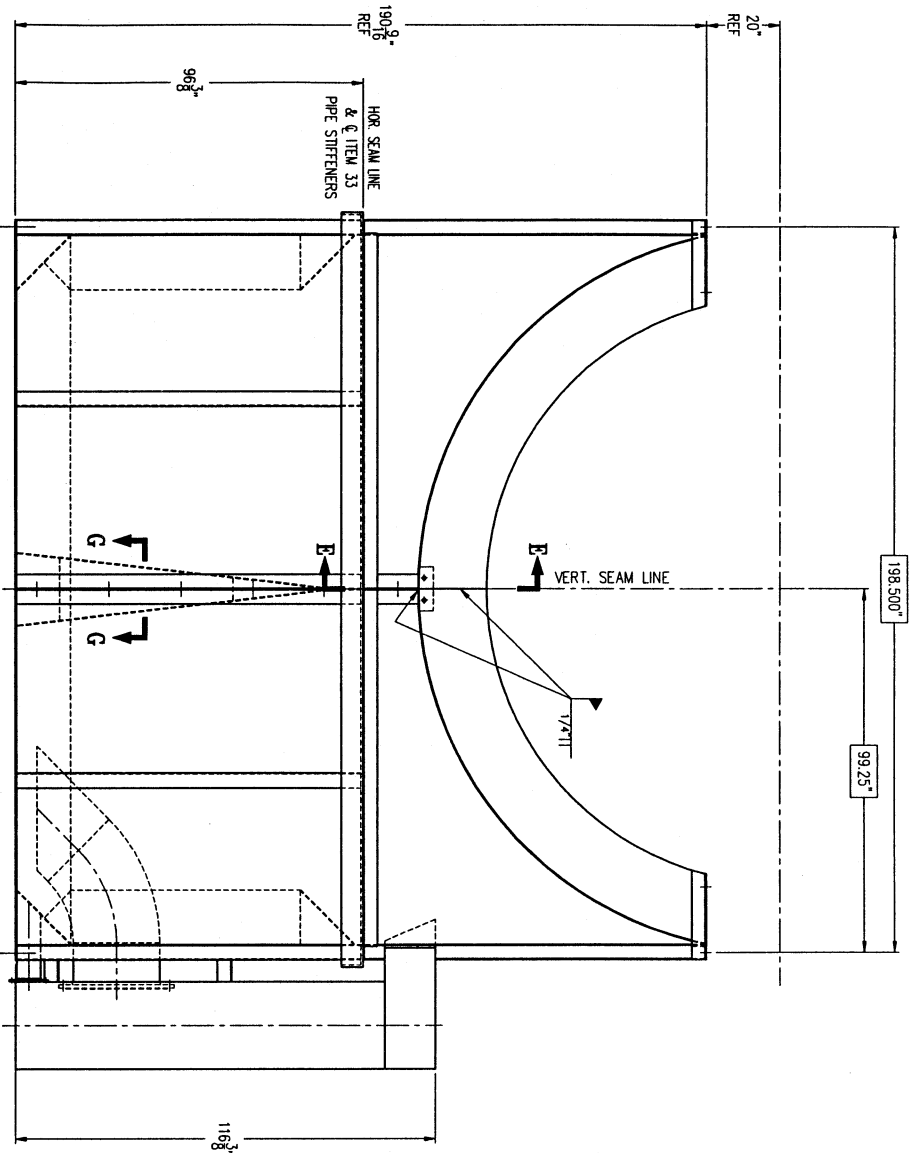
Tolerance, Unless Noted Otherwise
Fractional under 12" ±1/16"
12" to 12' ±1/8"
Over 12' ±1/4"
Decimal 2 places x.x ±.05"
3 places x.x.x ±.010"
Angles ±1/2°; not to exceed 1/8" per 12"

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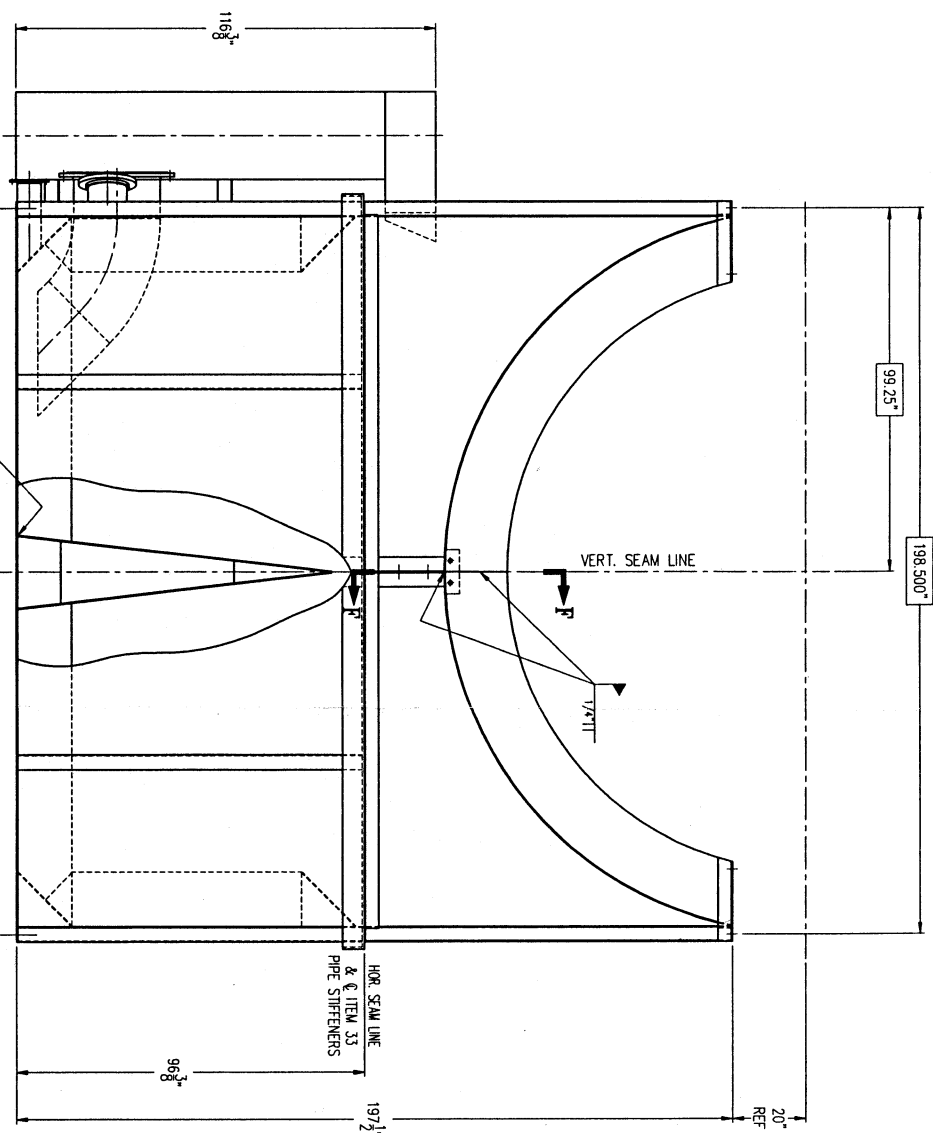
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SHEET 1 OF 3
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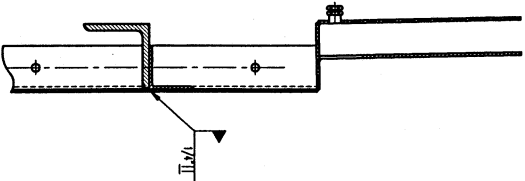
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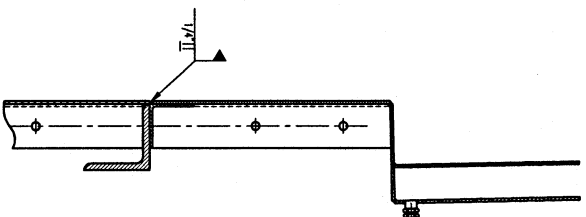
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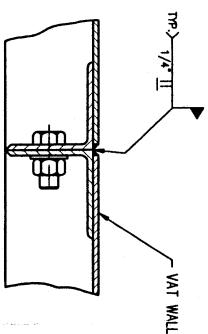
INLET END



SECTION E-E



SECTION F-F

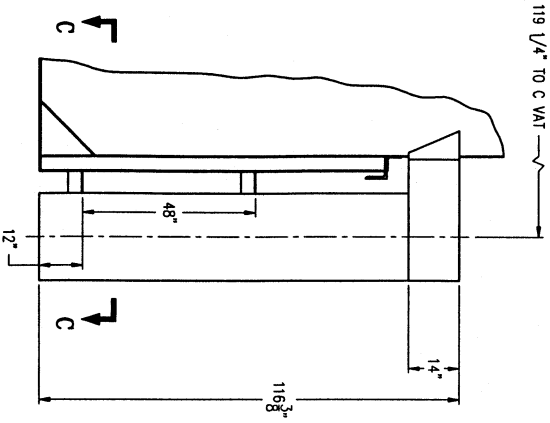
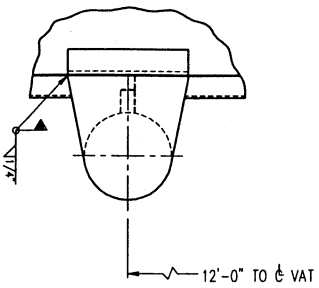


SECTION G-G

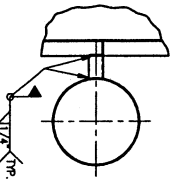
RF069
JOB NO.

Tolerance, Unless Noted Otherwise
Fractional 1/16" 3/16" 1/8" 3/8" 1/2" 5/8" 3/4" 1" 1 1/2" 2" 3" 4" 6" 8" 12" 18" 24" 30" 36" 48" 60" 72" 96" 120" 144" 168" 192" 216" 240" 264" 288" 312" 336" 360" 384" 408" 432" 456" 480" 504" 528" 552" 576" 600" 624" 648" 672" 696" 720" 744" 768" 792" 816" 840" 864" 888" 912" 936" 960" 984" 1008" 1032" 1056" 1080" 1104" 1128" 1152" 1176" 1200" 1224" 1248" 1272" 1296" 1320" 1344" 1368" 1392" 1416" 1440" 1464" 1488" 1512" 1536" 1560" 1584" 1608" 1632" 1656" 1680" 1704" 1728" 1752" 1776" 1800" 1824" 1848" 1872" 1896" 1920" 1944" 1968" 1992" 2016" 2040" 2064" 2088" 2112" 2136" 2160" 2184" 2208" 2232" 2256" 2280" 2304" 2328" 2352" 2376" 2400" 2424" 2448" 2472" 2496" 2520" 2544" 2568" 2592" 2616" 2640" 2664" 2688" 2712" 2736" 2760" 2784" 2808" 2832" 2856" 2880" 2904" 2928" 2952" 2976" 3000" 3024" 3048" 3072" 3096" 3120" 3144" 3168" 3192" 3216" 3240" 3264" 3288" 3312" 3336" 3360" 3384" 3408" 3432" 3456" 3480" 3504" 3528" 3552" 3576" 3600" 3624" 3648" 3672" 3696" 3720" 3744" 3768" 3792" 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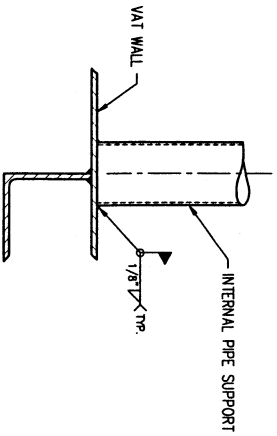
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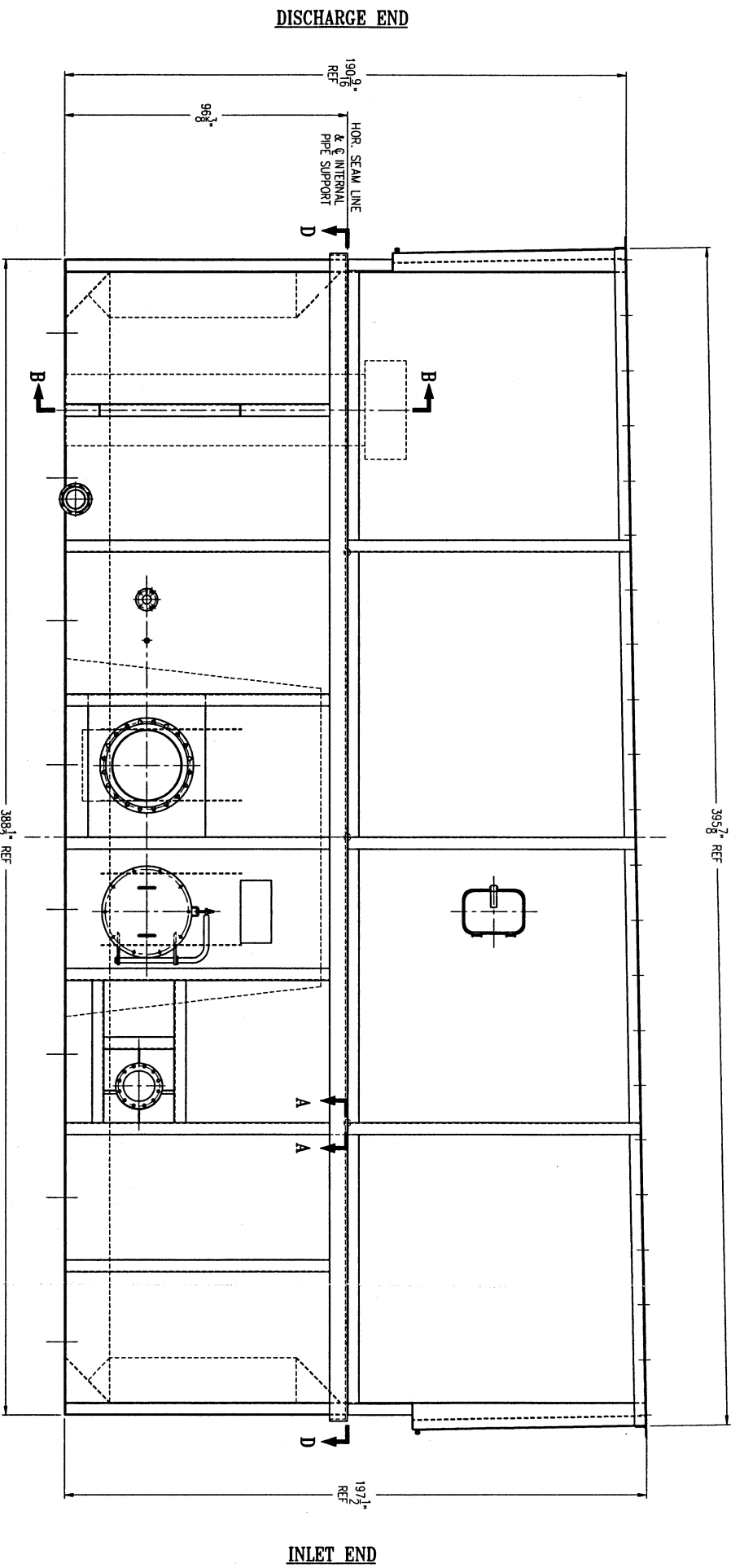
SECTION B-B



SECTION C-C



SECTION A-A



ELEVATION

REF069
JOB NO.

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

NOTE
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B-LINE BOTTOM VAT
FIBERFLOW 400
DATE: 1/23/01 BY: [signature]
SHEET 1 OF 3
R1

