DOMTAR INC.

FINE PAPERS DIVISION

PROJECT NO. 85-9867

NO. 18 FOLIO PRODUCTION LINE

FINE PAPERS DIVISION

CORNWALL, ONTARIO

DATE: JANUARY 28, 1986

DOMTAR---------CORNWALL JUNE/87

NO. 18 FOLIO SHEETER (PAGE ONE)

MANUFACTURER.....JAGENBERG.....INSTALLED IN 1987

PRODUCTION STANDARD.....10833#/HR.....130 TONS/DAY NET

ROLL WIDTH ON.....MAX. - 86" MIN. - 31-1/2"

MAX. ROLL DIAM.....60"

MAX. ROLL WEIGHT.....8800#

CORES.....5" METAL TIP - 7-1/2" PLAIN

NUMBER OF PILES OFF.....MAX. - 4 MIN. - 1

TRIM ALLOWANCE.....1" (CAN HANDLE 3/4" TO 2")

MIN. QUANTITY PER ORDER.....20 TONS

PACKING.....LOOSE CARTONS AND SKIDS (CANNOT SEAL)

WIDTHS CUT.....16" TO 48" INCLUSIVE

LENGTHS CUT.....20" TO 60" INCLUSIVE

CARTON PACKER (PEMCO).....6 CARTONS PER MINUTE

CARTON HEIGHT.....MIN. 2-1/2".....MAX. 10"

CARTON SIZE.....MIN.- 17 X 22...MAX.- 40 X 50

SCHNEIDER STACKERS (SKIDS ONLY)

MAXIMUM SKID SIZE.....49" X 64"

MAXIMUM SKID HEIGHT.....72"

MAXIMUM PILES PER SKID.....4

MAXIMUM LIFT HEIGHT.....10"

DOMTAR---------CORNWALL JUNE/87

NO. 18 FOLIO SHEETER (PAGE TWO)

LITHIBAR PALLETIZER (CARTONS ONLY)

MAXIMUM PALLET SIZE.....48" X 54"

MINIMUM PALLET SIZE.....25" X 38"

MAXIMUM CARTON HEIGHT.....10"

MINIMUM CARTON HEIGHT.....2-1/2"

MAXIMUM CAPACITY.....6 PER MINUTE - SINGLE LAYER

10 PER MINUTE - DOUBLE LAYER

MAXIMUM LOAD CAPACITY.....2500#

ORION STRETCH WRAPPER

MAXIMUM PALLET SIZE.....56" LONG

MAXIMUM LOAD HEIGHT.....72"

NOTES:
- 5 ROLL DOUBLE BACKSTANDS WITH ZERO SPEED SPLICING FEATU
- FULLY AUTOMATED QUICK SIZE CHANGES
- DUAL SLITTER CAPABILITIES
- DESIGNED TO RUN FINE GRADES AND COATED GRADES
- WEB ALIGNING SYSTEM
- SPLICE DETECTION SYSTEM
- INK REAM MARKING SYSTEM
- AIR ROLL OUT STATION
- TWO CARTON LABELLERS
- INK JET CARTON STENCILLING SYSTEM
- ELECTRONIC FAULT FINDING SYSTEM
- ELECTRONIC PRODUCTION MONITORING SYSTEM

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

III. PRICE SUMMARY

One (1) JAGENBERG SYNCHRO-FLY® Simplex Sheeter
With Continuous Ream Delivery,
Model SYNCHRO-FOLIO 321
84" Nominal Trim,
with the following main components:

Shaftless Unwind System:	Five (5) pairs of AE 15 unwinds, with motorized adjustment for pick-up of different width rolls, each pair of stands with separate controls, for a max. roll diameter of 60", 2 pneumatically operated, Montalvo air-cooled disk brakes (1 front, 1 back) and 1 pair of combination chucks for 5" and 7 1/2" I.D. metal tipped and plain fiber cores
Roll Loading:	Ten (10) hydraulic scissors-type lift tables, with swivel alignment mechanism to ensure alignment of the rolls about center line of the machine, with 4 two-way and

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

Domtar Inc. - 19 - March 10, 1986
Cornwall, ON SY-FOLIO 321 - 84S2307

---

2 one-way kick-out devices, hydraulically operated, to position rolls on the scissor-type lift tables and height calculation for accurate pick-up by core chucks, keyboards for roll width and roll diameter entry included

Web Tension Control: Degressive brake control system via SIEMENS S5 computer, with 1 signal generator for each unwind roll, permitting individual constant tension for each web, even if roll diameters are dissimilar

Unwind Framework: of heavy gauge steel overhead bridge construction, to accommodate guide rolls, spreader rolls, decurlers, edge guides, splice detectors and splicers

Zero-Speed Splicers: Five (5) MARQUIP zero-speed splicers, mounted to unwind framework, each unit including splicer carriage with slack edge compensating rolls, paper stop bar, cut-off knife and splice sealing nip rolls

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 168 Enfield, CT 06082

Domtar Inc. - 20 - March 10, 1986
Cornwall, ON SY-FOLIO 321 - 84S2307

Multiple Decurler System:	Five (5) decurler stations with small-diameter supported decurler bars, for decurling from the top only, mounted to unwind framework, with motorized remote adjustment, remote position indicators, automatic retraction during splicing cycle and automatic return to initial starting position to accept new full-diameter roll
Spreader Rolls:	Five (5) Bingham type spreader rolls, with specially grooved rubber covers, strategically placed for effectiveness, mounted to unwind framework
Web Aligning System:	with 3 FIFE "OPG" edge guide systems and 2 FIFE "KAMBEROLLER" systems, for multiple-web (5 webs) operation, including retraction of scanners to permit passage of splices

Cont'd

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

JAGENBERG

JAGENBERG INC.
ENFIELD

Domtar Inc.
Cornwall, ON

March 10, 1986
SY-FOLIO 321 - 84S2307

Splice Detection:	Two (2) COLLDETECTOR® systems for detection of splices of all types and edge tear-outs, including 2 scanners and automatic reject gate controls
Zero-speed Splicers:	Quoted separately under U.S. dollar portion
Dual Slitters: (Can. Patent No. 990 639)	Five (5) pairs of slitters on each slitter bank (TRU-SLIT® top slitters with factory-set fixed shear angle - no operator adjustment required, TOPSPEED® top slitter blades, tungsten carbide tipped bottom slitters for long life and clean cutting); common slitter mounting elements ensure absolute slit width accuracy of both stations
Spreader Rolls:	Two (2) Bingham type spreader rolls, with specially grooved rubber covers, mounted after the slitters, to ensure controlled run of the webs to the draw roll section, thus eliminating possibilities of creasing and marking

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

Domtar Inc. - 22 - March 10, 1986
Cornwall, ON SY-FOLIO 321 - 84S2307

Trim Chutes:	Four (4) trim chutes with flexible hoses for 1 1/2" trim strip width per side (trim blower system from and ductwork from connecting flange are customer's responsibility)
TELESET®:	Fully automatic slitter setting and fully automatic setting in groups of all sheet size related elements on overlapping sections (sheet arresting assemblies, tapes), ream stacker and discharge (divider plates, stop plates, pusher paddles)
Dust Removal System:	Not required with dual slitters of the above patented design
Sheet Locking:	Web clamping mechanism to prevent webs from slipping out of the slitting and cutting section after an emergency stop

Cont'd

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

JAGENBERG

JAGENBERG INC.
ENFIELD

Domtar Inc.
Cornwall, ON

March 10, 1986
SY-FOLIO 321 - 84S2307

Basic Sheeter:	with draw roll station (draw rolls with special covers for prevention of marking) and SYNCHRO-FLY® cut-off station, including 2 rotating knife drums and electrical (programmable) sheet length setting in connection with two-motor digital drive
High-Speed Tape Section:	Pick-up section, for acceleration and separation of the sheets from the cut-off section to create a small gap between the sheets to permit overlapping; a vacuum system ensures correct transfer of the cut sheets to the high speed conveyor and eliminates the possibility of surface marking
Retractable Tape Section:	Pick-up section is pneumatically retractable for easy access to cutter section for maintenance and operational efficiency

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 168 Enfield, CT 06082

Domtar Inc.
Cornwall, ON

March 10, 1986
SY-FOLIO 321 - 84S2307

Reject Gate:	of "non-critical" design, activated by signal from COLLDETECTOR® splice detector, with pneumatic lift-off of top tapes
Broke Slitters:	to cut the reject sheets into strips, located under the reject gate
Broke Conveyor:	approx. 30 ft. long, 4 ft. wide, to horizontally convey the rejected sheets from the broke slitters in cross machine direction to a vertical sandwich conveyor for discharge into customer supplied broke cart
Change Gate:	with kick-out section and pneumatic lift-off of top tapes, to alternately direct the sheets to the two (2) overlapping sections
Overlapping Sections:	T w o (2) sections, mounted one above the other, operating in alternating cycles, each with full width bottom apron and individual top tapes with grouped tension

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 168 Enfield, CT 06082

Domtar Inc.
Cornwall, ON

March 10, 1986
SY-FOLIO 321 - 84S2307

---

adjustment to provide total support and prevention of any edge entrapment of the sheets at transfer points which eliminates any losses due to jams resulting in broke losses and machine down time

VACU-STOP®: Two (2) VACU-STOP® systems (one for each overlapping section), fully synchronized with automatic sheet length setting, for precise braking of the trailing edge, thus preventing damage to the leading edge in the tape arresting station; VACU-STOP® controls and supply units for vacuum and blower air included

Tape Arresting Stations: Two (2) stations (one for each overlapping section), to gently catch the incoming sheets without marking the edges or surfaces; the tape carriages are automatically positioned by TELESET® in accordance with the sheet length setting

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

Stop/Start Mechanisms: Two (2) mechanisms (one for each overlapping section), to prevent excessive broke losses caused by rejection of multiple clips in order to avoid collison of leading and trailing edges during the overlapping process, i.e. one-sheet rejection is possible

Combining Apron Section: to alternately direct the sheets from the upper or lower overlapping section to the stacker, with full width bottom apron and individual top tapes to provide total support and prevention of any edge entrapment of the sheets at transfer points which eliminates any losses due to jams resulting in broke losses and machine down time

Ream Stacker: with end jogging and side jogging, top tapes extending over the stacker, blower air nozzles, separating shoes, stacking table with built-in apron conveyor and automatic lowering controls; all stacker elements are grouped and

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

---

thus designed to ensure minimum down time for order changes due to simultaneous adjustment; a total of ten (10) groups is included, and the elements required for each order are automatically selected by the TELESET® system

Automatic Size Change: for all sheet size related stacker components by TELESET®, as described above

Ream Counting/Marking: One (1) ream counter and 4 ream markers (tag inserters); ream markers mounted in fixed positions in the kick-out section of the ream stacker

Ream Discharge Conveyor: with pusher paddles, to convey the finished reams out of the machine in cross-machine direction to the right hand side

Apron Conveyor: for ream transfer to ream packaging equipment, following the ream discharge conveyor

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

Domtar Inc. - 28 - March 10, 1986
Cornwall, ON SY-FOLIO 321 - 84S2307

Air Removal System:	to remove entrapped air from the finished reams to ensure stability and straight edge alignment of the individual reams during the conveyance into and through the cartoning line, with horizontally movable, rotating squeeze roll, mounted above the apron conveyor
Jam Detection:	Machine is fully equipped with jam detectors in all critical areas, especially transfer points, for prevention of unnecessary damage to machine components
Sheet Counting:	included in PLC process controls, to precisely count and discharge reams from delivery position to the cartoning line within design parameters
Catwalks:	in heavy-duty steel construction, with pressboard floorplates for environmental comfort of operators, ease of cleanliness and access for maintenance and operation, for sheeter and delivery system

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

Domtar Inc.
Cornwall, ON

March 10, 1986
SY-FOLIO 321 - 84S2307

Drive Package:	SIEMENS micro-processor controlled two-motor drive system (details as per "Drive Specifications"), including DC overlapping drives, main control enclosure
SIEMENS S 150 Process Control:	Program-controlled system for all machine functions, including micro-computer VDT screen and management data system (see appendix) with interface to HP 3000 host computer
Electrical Pre-wiring:	of the sheeting line, with cable festoons fully installed and tested at JAGENBERG factory and to be reused 100% at mill site to facilitate ease of installation and reduce start-up time to a minimum

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

Domtar Inc. - 30 - March 10, 1986
Cornwall, ON SY-FOLIO 321 - 84S2307

Factory Test Run: at JAGENBERG, to ensure customer's acceptance of machine capability prior to shipment; sheeter will be mechanically and electrically installed (with temporary unwind) and fully tested under simulated mill conditions with customer supplied materials

Cont'd

JAGENBERG INC. P.O. Box 168 Enfield, CT 06082

JAGENBERG

JAGENBERG INC.
ENFIELD

Domtar Inc. - 31 - March 10, 1986
Cornwall, ON SY-FOLIO 321 - 84S2307

One (1) Folio Ream Packaging Line
With PEMCO Case Packer,
Schneider Restackers,
Lithibar Palettizer
with the following main components:

Interconnecting Conveyors:
- One (1) 8 ft. long belt conveyor
- Two (2) 5 ft. long raise/lower conveyors with pusher
- One (1) 7 ft. long belt conveyor
- One (1) 5 ft. long orientation conveyor

PEMCO Model 141R
Folio Case Packer:
- Ream timing belt
- Electronic servo drive
- Reciprocating guide rails to center ream on air float table
- Overhead ream indexing mechanism to position ream precisely on bottom case blank

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 168 Enfield, CT 06082

- Feed mechanism for bottom case blank
- Auxiliary hopper for bottom case blanks refillable while machine is operating
- Folding mechanism to form bottom case blank around ream
- Hopper for lid blanks refillable while machine is operating
- Feed mechanism for lid blanks
- Mechanism to lower lid blank onto ream, compressing ream and folding side of lid blank against bottom case blank
- Enclosed pressurized hot melt glue system to apply glue to four sides of case with glue stitch mechnism
- Compression plates to hold sides of case until glue is set
- Electrical box with manual disconnect switch
- Transformer for control circuit
- Steps over infeed end of machine
- Automated package size changeover
- Programmable logic control

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

Domtar Inc. - 33 - March 10, 1986
Cornwall, ON SY-FOLIO 321 - 84S2307

PEMCO Model 74DHR
Dual Headed Case Labeler:

- Mounted to and driven by Model 141R case packer
- Cold glue system with circulating pump including ability to pump water for easy cleanup
- Vacuum head with venturi vacuum system
- Air cylinder actuated label hopper
- "No Package - No Label" feature
- Horizontal and vertical label location adjustment
- Handwheel for product length adjustment
- Spring loaded compression roller
- Label applied on left end of case as it travels through machine
- Electrical box with manual disconnect switch
- Transformer for control circuit

Restackers: Two (2) SENATOR K-S MASTER Model 3000 PL restackers, including steel tables, gripper systems and PC controls

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

Domtar Inc. - 34 - March 10, 1986
Cornwall, ON SY-FOLIO 321 - 84S2307

LITHIBAR Label Orienter:	with picture frame with hydraulic cylinder lift and motor turn to rotate 180° or 90° in either direction or not turn as required for labels out patterning; conveyor is powered roller, 3" pipe rollers on 4" centers
Infeed Conveyor:	1.0" dia. powered rollers on 5" centers, 52" B.F., 9 ft. section with hydraulic controls
Double Fork Palettizer:	with powered roller bed, double fork elevator carriage, upright tines, 45 GPM/25 HP pumping unit wiht 2 1/2 gallon accumulator, Allen-Bradley 205 programmable controller and all hydraulic and electrical controls for automatic operation; will handle 10 cases per minute on loads with 2 cases per layer; will handle 6 cases per minute on loads with single case layers

Cont'd

JAGENBERG

JAGENBERG INC.
ENFIELD

JAGENBERG INC. P.O. Box 188 Enfield, CT 06082

Domtar Inc.
Cornwall, ON

March 10, 1986
SY-FOLIO 321 - 8452307

Pallet Injector:	automatically inserts pallet onto load discharge slat conveyor; includes pallet hopper, elevator, latches and "low pallet" warning alarm
Slat Conveyor:	with 30 ft. of discharge beyond the palettizer; includes automatic shutoff
Lock-N-Pop Gluing System:	with Nordson guns; system capable of gluing cases and slip sheets
Tie Sheet Inserter:	with hopper, overhead track and carriage and elevator with vacuum pump

TOTAL PRICE OF THE SHEETING LINE AS PER SEPARATE PRICE SHEET

Cont'd

DOMTAR INC.
FPC-9867-0001
CORNWALL, ONTARIO

TECHNICAL SPECIFICATION

6.00 TECHNICAL SPECIFICATION

.19 General Description of Folio Production Line

84" maximum trimmed width. Low profile machine.

Ream discharge with continuous running features.

Five (5) backstands with zero speed splice (max. roll diameter 60"), and kickers for roll positioning

Fully automated quick size change.

Fully sychronized knife drive (600 g/m^2 capacity).

Dual slitters or Contractor's standard.

Fully automated carton packer.

Two Schneider stackers for piling on skids.

Micro-processsing computerized system.

Palletizer unit with surge conveyor system, automatic pallet injector and stabilizing gluing system.

.20 Working Width

Untrimmed max. roll 86"

Untrimmed min. roll 31.5"

Trimmed max. web 84"

Trimmed min. web 28.5"

Minimum sheet width 16"

DOMTAR INC.
FPC-9867-0001
CORNWALL, ONTARIO

TECHNICAL SPECIFICATION

6.00 TECHNICAL SPECIFICATION

.21 Cutting Length

Infinitely variable

from min. 20"
to max. 60"

.22 Number of Pads Out

1, 2, 3, and 4 pads out capacity

.23 Paper Roll Diameters

Maximum diameter 60" (Ability to remove rolls of any size 60" diameter and under.)

.24 Pad Height

Maximum 10"
Minimum 2 1/2"

.25 Mechanical Running Speeds at Various Sheet Lengths

at 20" sheet length	420 FPM
at 22" sheet length	525 FPM
at 24" sheet length	655 FPM
at 26" sheet length	850 FPM
at 28" sheet length	930 FPM
at 30" sheet length	1000 FPM
at 32" sheet length	1065 FPM
at 34" sheet length	1135 FPM
at 35" sheet length	1150 FPM
at 36" sheet length	1150 FPM
at 40" sheet length	1150 FPM
at 44" sheet length	1150 FPM
at 45" sheet length	1100 FPM
at 47" sheet length	1050 FPM
at 51" sheet length	985 FPM
at 55" sheet length	920 FPM
at 59" sheet length	870 FPM
at 60" sheet length	850 FPM

6.00 TECHNICAL SPECIFICATION

.25 Mechanical Running Speeds at Various Sheet Lengths

Attainment of the previously stated speeds depends on the given operating conditions and on a number of factors, e.g. number of sheets per ream (discharge time per set of reams 30 sec.), stiffness of the material, flat lay of the sheets, quality and properties of the papers, ambient relative relative humidity, static electricity, basis weight, condition of the rolls such as truth accuracy and curling tendency, coat thickness and type of coat. To prevent static loading, the paper moisture must be in balance with a relative humidity of the ambient air of 50 - 55% at an ambient temperature of 68 - 72° For a corresponding residual moisture of the paper.

.26 Operating Speed

As per sheet length

.27 Knife Cutting Capacity
600 g/m^2

.28 Cutting Tolerances

± 1/32" on cutting lengths up to 60".

at constant speed, measured on consecutive sheets from the same roll.

.29 Cutting Tolerances

± 1/64" on sheet width

± 1/64" on sheet squareness up to 60" sheet length.

6.00 TECHNICAL SPECIFCATION

.30 Drives

(a) Main drive:
SIEMENS type "SYMA-D" two-motor micro-processor controlled DC drive with electrical sheet length adjustment.

Drive motor for draw roll station: 64 HP, 1460 RPM. Armature regulation range 1:50.

Drive motor for cut-off station: 38 HP, 2150 RPM. Armature regulating range 1:50.

Acceleration and deceleration intervals 140 seconds each, adjustable from 95 to 175 seconds. Emergency stop within 8 seconds.

The drive has straight-line acceleration and deceleration curves. The beginning and end of any speed change is filleted

(S-curve) by means of a reference value delay (of about 2.5 seconds). Regulation of the web speed is controlled by a tacho generator.

The RPM reference value is given by the draw roll station, the cut-off station follows the reference value. Overspeed protection is included.

DOMTAR INC.
FPC-9867-0001
CORNWALL, ONTARIO

TECHNICAL SPECIFICATION

6.00 TECHNICAL SPECIFICATION .30 Drives (Cont'd)

(b) Tape drive:

is made separately from the basic machine through two DC motors, motor rating 30 HP, 2000 RPM each, overlapping regulating range 1:8, other data as for main drive. These motors are arranged for synchronous acceleration with the main drive.

(c) ADVANTAGES OF THIS TWO-MOTOR DIGITAL DRIVE

- Pre-setting of the sheet length without any material in the machine. This considerably reduces broke. The second sheet cut already has the correct length.
- Low wear and simple maintenance.
- High sheet length accuracy under all operating conditions, even during acceleration and deceleration.
- Automatic follower setting of the double-drag link drive to the chosen sheet length.
- Built-in equipment for speed monitoring, which prevents damage to the machine through excessive operating speeds.

DOMTAR INC.
FPC-9867-0001
CORNWALL, ONTARIO

TECHNICAL SPECIFICATION

6.00 TECHNICAL SPECIFICATION

.31 Noise Level

Noise level not to exceed 85 dB(A) at one meter from source of sound.

.32 Grades To Be Run

It is of utmost importance that the sheeter be designed specifically to run Cornwall coated grades. The surface of the coated papers is very susceptible to marking and therefore the folio sheeter line must be designed to handle the coated papers with no marking whatsoever. (Samples of Cornwall coated papers can be made available on request.)

The range of grades to be run on the sheeter is as follows:

Coated Grades
One sided and two sided coating. From .006" up to .014" calipers (132 to 308 g/m^2).

A two sided coated sheet will contain up to approximately 22 lbs. of coating per 2597 ft^2 (42 g/m^2).

Fine Grades
(Full range)From lightweights of 60 g/m^2 machine finish to heavyweights of 265 g/m^2 antique finish and smooth finish.

.34 Backstands

Five (5) double roll, shaftless, fixed centre height backstands.

6.00 TECHNICAL SPECIFICATION

.34 Backstands (Cont'd)

Max. roll width:	86"
Min. roll width:	31.5"
Max. roll diameter:	60"
Min. roll diameter:	15.75"
Max. roll weight:	8,800 lbs

.35 Each Backstand To Have

- Web tension control system to give even tension by a degressive braking system as roll diameter changes.
- Montalvo disc brakes (front and back)
- Motorized adjustments for roll widths.
- Controls at each stand position.
- Roll loading and unloading device (scissor lift with swivel top table for roll alignment.)
- Roll kickers for roll positioning in sheet direction. Four (4) two-way and two (2) one-way roll kickers in total.
- Combination chucks to take 5" and 7 1/2" cores - metal tipped and plain ends respectively.
- Automated zero speed splicing
- Five (5) rotary decurlers equipped with motorized remote controls (one for each sheet run).

6.00 TECHNICAL SPECIFICATION

.35 Each Backstand To Have (Cont'd

- Five (5) spreader rolls (Bingham) (one for each sheet run strategically placed for effectiveness).

.36 Web Aligning System

Electra Web Aligner system or equivalent just prior to knife section. Trim control to a minimum of 1/2" per side.

.37 Sheet Locking

Sheet locking rollers required just prior to slitters.

.38 Splice Detection System

Two splice detectors required connected to reject gate to automatically reject the spliced sheet.

.39 Slitting Section

Fully automated, programmable, motorized slitting units. Two slitting units with 5 slitter heads per unit (total 10), or Contractor's standard.

.40 Knife Section

Fully synchronized knife equipped with programmable size change (cutting length 20" to 60").

Polyurethane covered pinch roll (zero crown).

Ability to move back tape section after knife for ease of access.

6.00 TECHNCIAL SPECIFICATION

.40 Knife Section (Cont'd)
Require start/stop system for sheet overlap continuity when sheets rejected.

.41 Trim Handling System

Contractor to supply trim chutes from slitting units to a common manifold (chopper, blower and conveyor by others). Sized for maximum trim of 1 1/2 inches each side.

.42 Reject Gate System

Fully automated reject gate system with ability to reject a single cut at any machine speed.

Non critical gate design fully synchronized to reject paper machine splices and folio splices.

Contractor's scope includes all required broke conveyors to Owner's broke cart.

Note: The low profile machine has difficulty in removing rejected sheets. Supplier to quote for set of slitters that will cut the rejected sheets into manageable size that will then drop to a conveyor which will take the rejected paper out beneath the machine on to another incline conveyor directing into a 6 foot high broke car, or Contractor's standard. The system will have to be fully

6.00 TECHNICAL SPECIFICATION

.42 Reject Gate System (Cont'd)

automated. (Note the slitter speed must correspond to that of the sheet at the point of rejection.)

.43 Sheeter Counting System

Electronic system integrated to computer to give accurate productivity analysis and ream counting.

Tab inserter facility in both pads to carton packing and pads to skid piling.

.44 Jam-Up Detection System

Contractor to include a detection system for jam-ups in critical areas of the machine.

Sensors required before and after knife and in other critical areas.

.45 Overlap Section

Synchronized vacuum overlap system.

Full width perforated bottom carrying belt section on each of the overlap sections.

Habistat tapes on top with individual tension control.

The stop roller device on top of sheet at overlap section must be of a material that does not mark the surface of Owner's coated sheet.

DOMTAR INC.
FPC-9867-0001
CORNWALL, ONTARIO

TECHNICAL SPECIFICATION

6.00 TECHNICAL SPECIFICATION

.46 Layboy Section

Fully automated layboy section with quick size change ability.

Vibrating jogging ability all round. (Back plate, inlet feed plates and divider plates).

4 - 3 - 2 - 1 pad out ability

Handle sheet up to 60" in length (2 1/2" minimum)

Ream stacker capcity of 250 to 2000 sheets. Ream height of 2" to 10".

.47 Air Removal System

Air roll out system required following layboy section.

.48 Table Conveyor System

Required to transport reams/pads to carton packer and also to two Schneider stackers. Right angled transfers required to transfer reams/pads into Schneider stackers.

.49 Carton Packing System

Contractor to include costs, alternately for Pemco carton packing system.

Fully automated carton packer with quick size change.

Capable of maximum carton size of 40" x 50".

Carton lenght 22" - 50"
Carton width 17" - 40"

6.00 TECHNICAL

.49 Carton Packing System (Cont'd)

Maximum carton height of 10"

Minimum carton height of 2 1/2"

Capacity of 6 cartons per minute

.50 Skid Piling System (Schneider)

Two Schneider stackers required.

K-S MASTER RESTACKER 3000 PL

Max. sheet size:	48" x 64.5"
Max. lift height:	10"
Max. skid height:	72"
Max. pile/pallet	4

.51 Labeller and Ink Markers

Two carton labellers.

Ink jet marker identification system.

Ream length:	22" - 50"
Ream width:	17" - 40"
Ream height:	2 1/2" - 10
Label length:	4" - 14"
Label width:	1" - 4"

Fully automated carton palletizer system. (Include conveyor system to palletizer from carton packer).

6.00 TECHNICAL SPECIFICATION

.52 Palletizer (Lithibar)

Hold roller conveyor section after palletizer required capable of holding 6 pallets (30' section).

Palletizer system to include automatic pallet injector, pallet stabilizing gluing system and slip sheet injector system.

Max. pallet size.	48" x 54"
Min. pallet size	25" x 38"
Max. carton height:	10"
Min. carton height:	2 1/2"
Max. handling capacity	
- single case per layer:	6 cases per min.
- two cases per layer:	10 cases per min.
Max. load capacity:	2 500 lbs.

.53 Platforms and Catwalks

Contractor to supply, design and install to suit sheeter location.

.54 Installation Costs

Contractor to include complete system installation on site and state installation time.