

DIA. OF ROLL	22" DIA. SUCTION COUCH ROLL
MACHINE NO.	#2 MACHINE
HAND OF MACHINE	LEFT HAND MACH.
WIRE WIDTH	113" WIRE
DECKLE ADJ.	8" ADJUSTMENT
	3-28-47
ASSEMBLY DRAWING	H-9094
INSTALLATION DRAWING	H-9764
AIR ROLL ASSEMBLY	(1) PER H-9012, TAB. #3
PRESSURE ROLL ASSEM.	NONE FURNISHED.
SHELL	(1) SC293 ON H-9069 SAND. STD. SHELL MIX.
SHELL BUTTONS	(12) P720S
SHELL C.S. FR. & BK. HEAD	(24) 1-P37585-1 (24) 1/2 HEX. NUTS (24) 1/2 x 2 1/4 HEX. C.S.
SHELL TO BACK HEAD LOCK SCREW	(24) BR2307
FRONT BRG. ASSEMBLY	(1) S.K.F. #23052 10.2362 BORE PER Z-31
FRONT HEAD	(1) IP6359D-14 C.I. CL. #40
FRONT JOURNAL SADDLE	(1) 2H3271XX-54
FRONT JOURNAL CAP	(1) 2H3272GG-46
FRONT BRG. WATER GUARD	(1) IH10705
FR. BRG. WATER GUARD C.S.	(2) 3/4 x 2" C.S. & HWY. W.
LOCK SCREW	(1) 3/4 x 2" S.S.S.
BACK BRG. ASSEMBLY	(1) S.K.F. #23052 10.2362 BORE PER Z-103
BACK BRG. HOUSING	(1) 2P5087PP-38 C.I. CL. #40
BACK BRG. STAND	(1) IH4851BE-66
BK. BRG. HSG. BOLTS	(2) 7/8 x 4 BTS. & HWY. WASHERS
BACK HEAD	(1) 2P4141CM-117 C. ST.
BACK JOURNAL PLUG	(1) IP3960
SUCTION BOX	(1) 4P2376XQ-430
SUCTION BOX PIPE PLUGS	(4) 2" C.SK. P.P.
SUCTION BOX BRASS WAYS	(2) BR1169 9'-4 1/2" LONG
SUCTION BOX BR. WAYS C.S.	(4) 1/2 x 1 1/4 BR. FT. HD. M. S.
SEALING RODS	(2) 1/4 DIA. x 9'-4 1/4" LG. BR. RODS ENDS 3/8"
PACKING HOLDER CLIPS	(9) BR1498
PACKING HOLDER CLIP C.S.	(12) 5/8 x 1" HEX. C.S.
GRAPHITE PLUGS	(48) 1/4 DIA. x 1/4 LG. GRAPHITE RODS
PACKING HOLDER SPRING	(10) P3686S
SPRING PLUNGER	(10) BR1483
SPRING PLUNGER SLEEVE	(10) BR1501
BOX BK. END SEALING PLATE	(1) IH6197J-12 Y.B.
END SEALING PLATE C.S.	(2) 1/2 x 1" HEX. C.S.
PACKING HOLDER	(1) 4P2298CCF-547 Y.B.
SEALING ROD SPRING	(5) BR2850 (5) BR2851
SEALING ROD SPRING C.S.	(20) #8-32 BR. R.H.M.S. 7/8" LONG
PACKING HOLDER END TIE	(1) IH5363B-7 Y.B. (1) IH5363B-8 Y.B.
PACKING HOLDER END TIE C.S.	(5) 3/8 x 3/4 BR. C.S. (2) 3/8 x 3/4 BR. F.H.M.S.
SKID SPACER	(1) RR309
SKID BOLTS	(2) 3/8 x 6 1/2 LG. M.S. STUDS - 1" T.B.E. (2) 3/8 HEX. NUTS
SKID	(3) AG1427
SKID BRACKET	(1) IP8932
SKID BRACKET C.S.	(4) 3/8 x 1 1/4 HEX. C.S.

41	FRONT JOURNAL	(1) 2P6181Y-35 C. ST.
42	FRONT JOUR. TO BOX C.S.	(13) 3/8 x 2 1/2 HEX. C.S.
43	GREASING FITTING	(2) 1-BR4494-3
44	FRONT JOUR. END PLATE	(1) IH10703F-6 R. B.
45	FRONT JOUR. END PLATE C.S.	(6) 1/2 x 1 1/2 HEX. C.S.
46	VACUUM GAGE	(1) 3" DIAL VACUUM GAGE - MARSH CO. - DRAWN BR. COVER - D'TO30" VACUUM - 1/4 MALE RT. CONN.
47	LOWER SEALING PLATE FRONT & BK.	(2) IH6604B-14 Y.B.
48	LOWER SEALING PLATE C.S.	(4) 3/8 x 1 BR. F.H.M.S.
49	END DECKLE HOLDER	(2) IH6595-2 Y.B.
50	END DECKLE HOLDER PLUNGER	(2) IH6601-2 Y.B.
51	END DECKLE HOLDER ROD	(2) 1-BR5388-1
52	END PACKING	(2) IAG1269
53	PACKING	(2) AG13 (9'-8 1/2" LONG)
54	DECKLE ROD SUPPORT BRKT.	(4) IH6998F-6 Y.B.
55	DECKLE ROD SUPPORT BRKT. BK.	(1) IH6998G-7 Y.B.
56	DECKLE ROD SUPPORT BRKT. C.S.	(6) 7/8 x 3 1/2 HEX. C.S.
57	END DECKLE ADJ. BRACKET	(2) IH6118C-3 Y.B.
58	END DECKLE ADJ. BRKT. S.S.	(2) BR4443 (2) 5/8 BR. CHK. NUTS
59	DECKLE ADJ. ROD SCREW	(2) 1-BR5384-1
60	DECKLE ADJ. ROD STOP	(2) BR967
61	DECKLE ADJ. ROD	(2) AY188 10'-11 1/2" LONG
62	OIL PIPE AT BACK INT. BRG.	(1) 1/2 BR. PIPE - 7" LONG T.B.E.
63	BACK INT. BRG. OIL PIPE	(1) BR482 LGTH. TO SUIT
64	OIL PIPE UNION	(1) 1/2 BR. FEMALE UNION
65	OIL PIPE COUPLING	1/2 BR. COUPLING - NO. TO SUIT
66	OIL PIPE CLIPS	(3) BR727
67	FRONT BRG. OIL PIPE	BR482 (1) 2'-1" LONG (1) 22 1/2" LONG
68	OIL LINE FITTINGS	(3) BR355
69	ALEMITE FITTINGS	(5) 1/2 ALEMITE - #1610
70	EYE BOLT FULCRUM BRKT.	(1) IP4127 GM.
71	EYE BOLT FULCRUM BRKT. C.S.	(3) 3/4 x 1 3/4 HEX. C.S.
72	BOX ADJ. EYE BOLT	(1) EBR6
73	BOX ADJ. PIN	(1) P1905S CN. EACH END
74	BOX ADJ. STUD	(1) P1486S
75	BOX ADJ. NUT	(2) IH12062 NI. BZ.
76	SHIPPING BRACKET	(2) IH10702 PAINTED YELLOW
77	SHIPPING BRKT. BOLTS	(4) 3/4 x 5 1/2 BTS.
78	SPACER FOR SHIPPING BRKT.	(2) P2704S 6 1/8" LONG
79	STUD FOR SHIPPING BRKT.	(2) 5/8 x 13 LG. CR. STUD 3/8 T.O.E. - 1/2 T.O.E.
80	NUTS FOR SHIPPING BRKT. STUD	(2) 5/8 HEX. NUTS
81	REMOVABLE FRONT FRAME	(1) 2H3751AG-48 #43 LEAKPROOF ALUM.
82	FRONT FRAME KEY	(2) H475S
83	FRONT FRAME SWING BOLTS	(8) EBR3
84	SWING BOLT NUTS	(8) 3/4 NUTS & HEAVY WASHERS
85	SWING BOLT PINS	(2) 5/8 x 8 1/2 LG. CR. ST. PINS - C.N. BETWEEN EARS
86	BOTTOM STAND	(1) 4H3302EE-23
87	BOTTOM STAND SWING BOLT PINS	(2) 5/8 x 8 LG. CR. ST. PINS (4) 3/16 C.N.
88	SUCTION PIPE FLANGE	(1) H3660S
89	SUCTION PIPE FLANGE C.S.	(6) 5/8 x 1 1/2 HEX. C.S.
90	JACK STAND ASSEMBLY	(1) PER H-5173 TAB. 94

91	AIR PIPE ASSEMBLY	(1) PER H-5174 TAB. #183
92	SHOWER ASSEMBLY	(1) PER H-8824 TAB. #34
93	COUPLING DATA	(1) 2T2811 (1) #3 1/2 "FAST" F.H. COUPLING PER T-1585 TAB #1833. (2) 3/8 x 1 1/2 FINE THD. HEX. C.S. FLOATING SHEET FURN. BY R.B. CORP. (R2)
94	GUARD FOR BOX WAYS	(1) 1-76-1882 BOTH SIDES OF BOX
95	PATENT PLATE	(1) PL5 SERIAL #1084
96	GREASING INSTRUCTION PLATE	(1) PL48
97	FRONT FRAME & ELBOW	OMIT
98	LOWER FRONT FRAME	OMIT

A.	9'-7"	K	9 7/8	U	2'-3 1/2
B	8'-3"	L	OMIT	V	29,000
C	5'-4 3/4"	M	3'-0 5/8	W	22,000
D	5'-2 1/2"	N	7 1/4	X	0"
E	5 3/4"	P	5"	Z	17"
F	1 1/8"	Q	8"	AA	2 1/4
G	18"	R	11 1/16	BB	10'-3"
H	OMIT	S	9 5/8		
J	8 3/16"	T	35°		

SHOP	WOOD S.	PURCHASE	STEEL	FOUNDRY	ORDER
BILL OF MATERIAL FOR					
SUCTION COUCH					
R.B. CORP FOR BYRON WESTON CO. DALTON, MASS. #2 MACHINE.					
BELOIT IRON WORKS BUILDERS					
BELOIT WISCONSIN					
SCALE ~ TO 1 FT. DATE 3-28-47					
ORDER NO.	DRAWN	EXAMINED	CHECKED	APPROVED	
8725	JXT		W.B.	B.	
SUB-SECTION H-SC					

H-10131 R2

ASSEMBLY NO.
H 3-9094

BELOIT, **BELOIT IRON WORKS** WIS.

THIS PRINT, THE EXCLUSIVE PROPERTY OF THE BELOIT IRON WORKS, IS CONFIDENTIAL. LENT ONLY FOR REFERENCE IN EQUIPMENT MAINTENANCE OR IN DEALING WITH BELOIT IRON WORKS. NOT TO BE COPIED OR REPRODUCED. TO BE RETURNED UPON REQUEST.

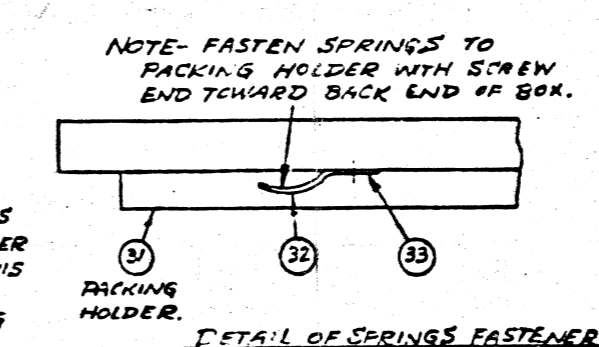
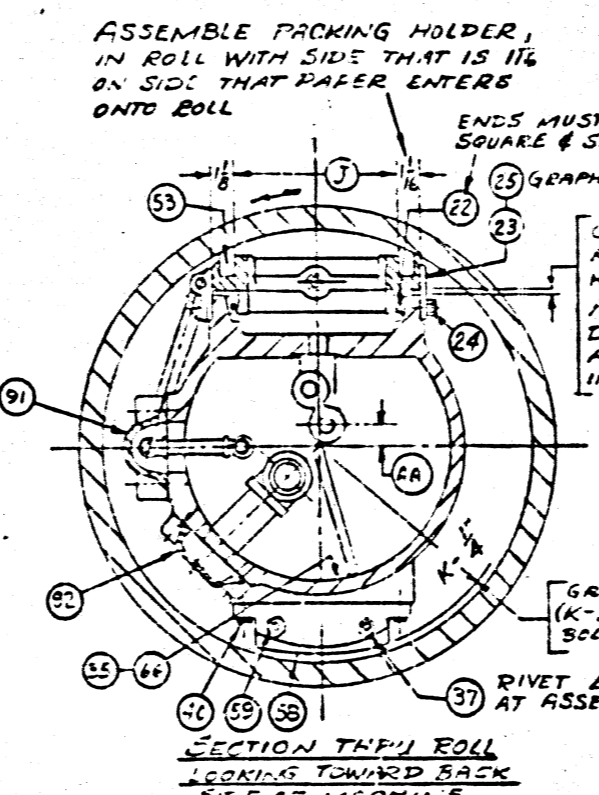
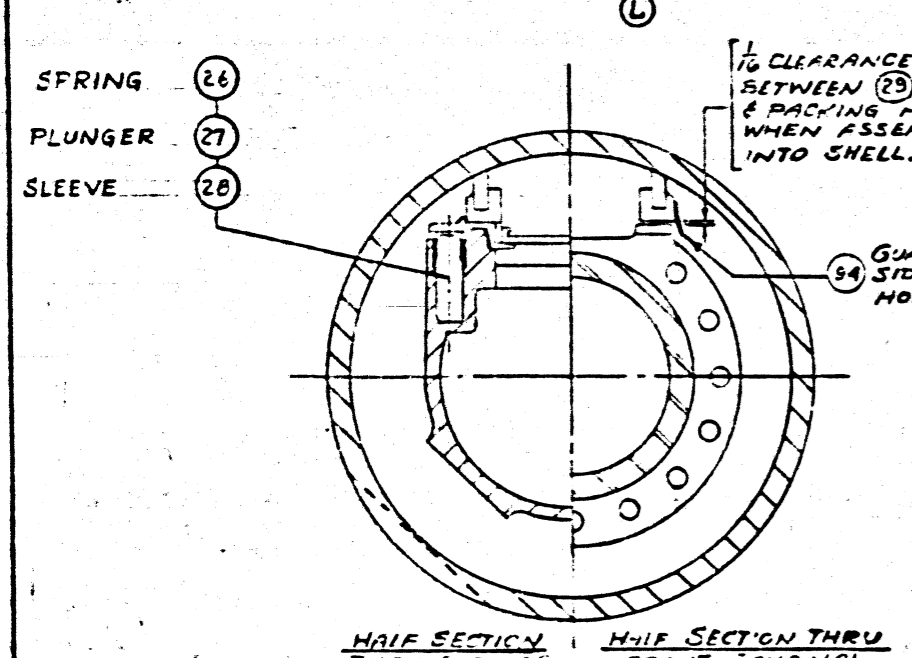
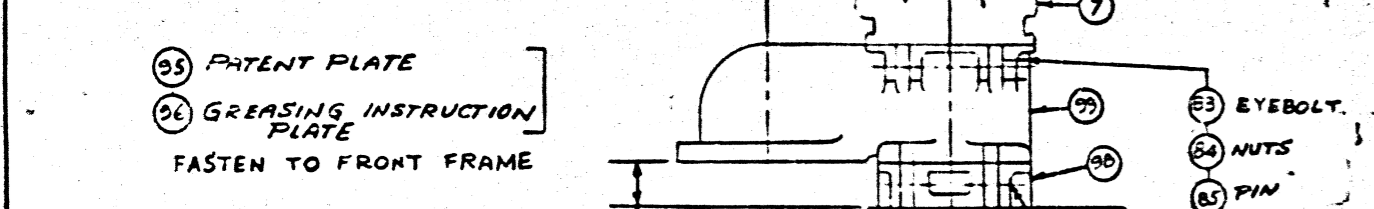
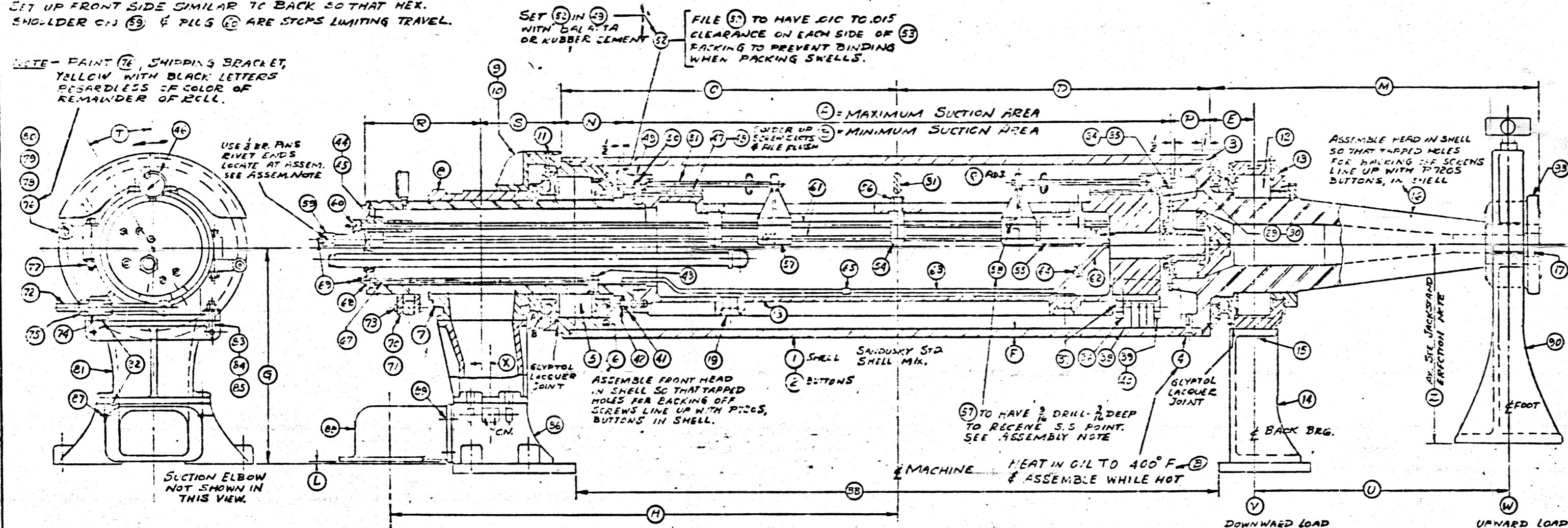
ASSEMBLY NOTE
 FOR SETTING UP TIECLE ADJUSTMENT ON BACK SIDE SCREW IN (2) UNTIL HEX. SHOULDER IS AGAINST FRONT END PLATE (4). LOCATE ROD (1) SO THAT BACK END IS APPROX. 7/8 FROM BOX AT Y. LOCATE (3) SO THAT END IS FLUSH WITH END OF PACKING HOLDER (3) USING A CUP POINT SET SCREW IN (5) NPT (1) ROD. REMOVE (2) FROM ROLL & DRILL A 1/8 DIA. HOLE 1/2 DEEP THRU ASSEMBLY USING A 1/8 X 1/2 CUP POINT SET SCREW IN SCREW CUT (13) UNTIL (3) IS DECKLED IN (5), THEN SCREW IN (2) UNTIL GOLD AGAINST END OF (4), & PIN (6) IN THIS POSITION.
 SET UP FRONT SIDE SIMILAR TO BACK SO THAT HEX. SHOULDER ON (5) & PINS (6) ARE STOPS LIMITING TRAVEL.

IMPORTANT ERECTION NOTE
 1ST SHOP WILL ADJUST FRONT BEARING SO THAT SURFACES "A" & "B" ARE FLUSH, THEN APPLY (2) SHIPPING BRACKETS (2) TO MAINTAIN THIS CONDITION DURING SHIPMENT & ERECTION. IF NECESSARY CHANGE LENGTH OF (7) SPACERS TO SUIT THIS CONDITION.
 AT MILL, ERECT ROLL WITH THESE BRACKETS IN PLACE. BRACKETS MUST BE REMOVED BEFORE TURNING ROLL OVER.

BORE OF (7) & (8) TO BE COVERED WITH GREASE. FILL ALL SPRING POCKETS WITH GREASE. COVER ALL SURFACES THAT END DECKLES SLIDE ON WITH GREASE. COVER JOURNAL EXTENDING FROM BACK END OF BOX WITH GREASE. USE SUPERLA #39 BY STANDARD OIL COMPANY OF INDIANA OR ITS EQUIVALENT.

NOTE
 WITH PACKING HOLDER (1) IN PLACE, RESTING ON SPRINGS (2), INSERT (3) & TAP HOLES IN BOX USING (4) AS TEMPLATE.

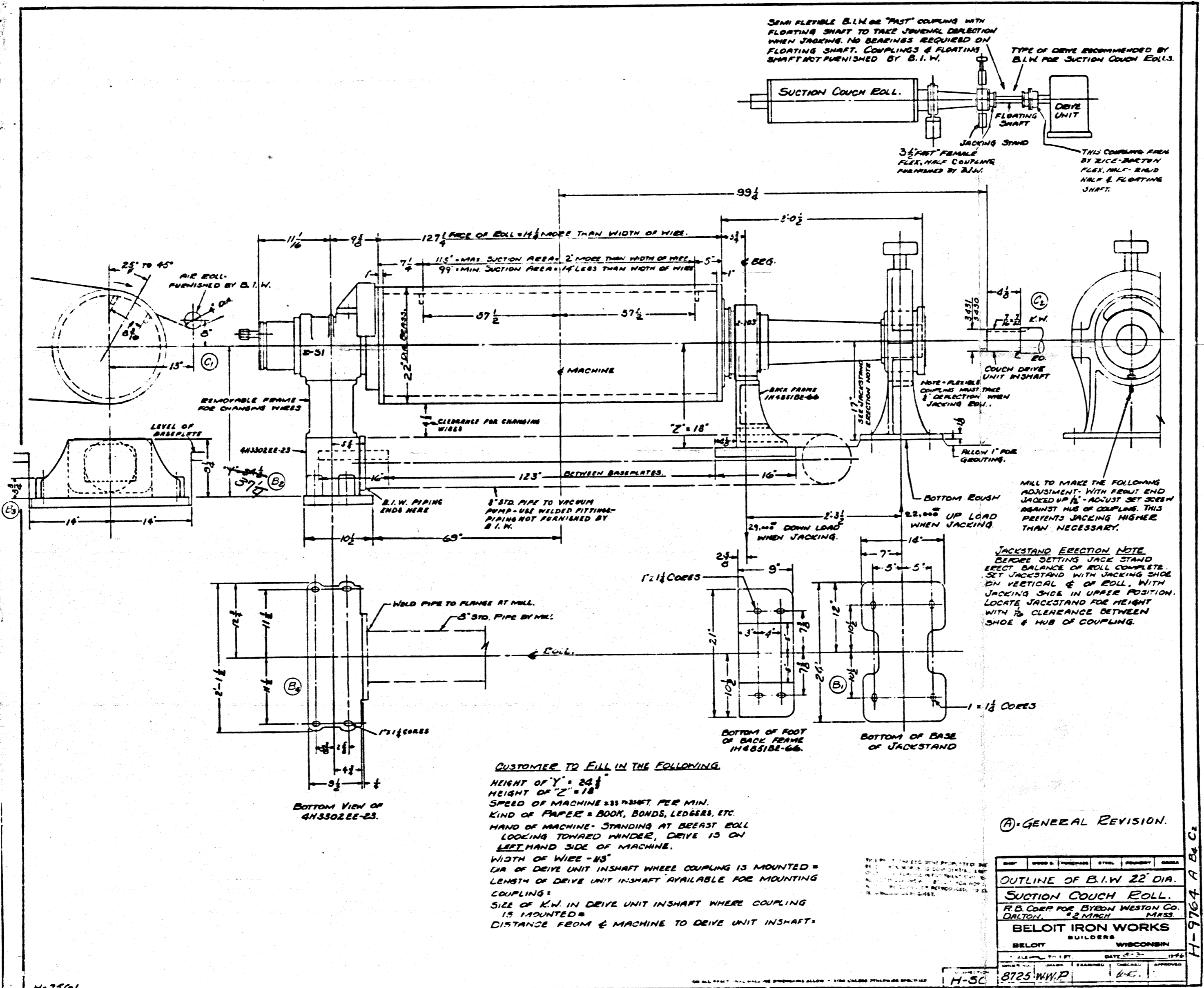
NOTE - PAINT (16) SHIPPING BRACKET, YELLOW WITH BLACK LETTERS REGARDLESS OF COLOR OF REMAINDER OF ROLL.



FOR DIMENSIONS CORRESPONDING TO LETTERS SEE BILL OF MATERIAL FOR EACH ORDER

ERECT AS SHOWN FOR B.I.W. R.H. MACH.
 ERECT OPP HAND FOR B.I.W. L.H. MACH.

CUSTOMER		ORDER NO.	SUB-SECT.	APP'D.	CHK'D.	DRAWN	DATE	SCALE	EXAMINED	REVISION	BELOIT, BELOIT IRON WORKS WIS.		ON ALL FRACTIONAL MACHINE DIMENSIONS ALLOW ± 1/16" UNLESS OTHERWISE SPECIFIED
SIO		SIO	H-SC			W.K.H.	4-2-40	1:1		A B C	TITLE SUCTION ROLL COUGH ASSEMBLY - STD		H 3-9094
REDRAWN BY D.C.M. 2-E-60 CHAD M.S.													



NO.	ISSUE	REVISION	DATE
1	AS SHOWN		11-23-56

OUTLINE OF B.I.W. 22" DIA. SUCTION COUCH ROLL. R.B. CORP FOR BYRON WESTON CO. DALTON, MASS. 2 MARCH 1955. BELOIT IRON WORKS BUILDERS. BELOIT WISCONSIN.