

VOITH

Voith Paper Rolls Central Inc.

December 16, 2005

PAPETIERE APPALACHES
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Tissue Cylinder Services Group
North America
Portland Service Center
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Portland, OR 97218
Telephone: (503) 284-2321
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cylinderservice.portland@voith.com

Reference: Voith Cylinder Services Proposal

Quotation #CS06-045

Project Title: #1 Yankee Dryer - 13' dia. x 123" face
Endura^{HC} Full Face Coating;
Grind with Tangential Grinder

Attention: Mr. Mike Valois

In response to your request, Voith Cylinder Services is pleased to provide the following quotation to re-condition the surface of the subject Yankee dryer.

Our **Endura^{HC}** coating is applied using the most technically advanced thermal spray equipment available. Our arc spray units are computer controlled to provide a consistent coating and interlocked to prevent damage to your dryer. Our thermal spray dust extraction system provides a safe work environment as well as a higher quality coating. Our grinding equipment and personnel achieve the highest stock removal rates in the industry, shortening your down time.

After the project is finished Voith's diagnostic and technical assistance is available to continue working with you to maintain a high level of operational efficiency. We strive to establish and maintain a long term working relationship through machine optimization.

The procedure will be to prep grind to all normal tolerances except surface finish, apply Voith's **Endura^{HC}** coating and finish grind at a nominal .030" final coating thickness.

We anticipate the following time line:

| | |
|--|----------------------|
| Set Up..... | 12 Hrs. |
| Prep Grind | 18 Hrs. |
| Grit Blast Cast Iron | 10 Hrs. |
| Apply Endura^{HC} | 17 Hrs. |
| Finish Grind..... | 23 Hrs. |
| <u>Tear Down.....</u> | <u>3 Hrs.</u> |
| Total | 83 Hrs. |
| | 3.5 days |

The price for this service will be.....\$146,900.00 USD

Add to this time line the mill time required to dismantle and re-assemble the machine.

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Included in the above pricing is one pre-job meeting at your facility. If the timing permits Voith's Laser Wire Check (LWC) could be used during this visit to evaluate the current crown profile.

Pricing is based on the work proceeding in a normal and timely manner. Any delays beyond our control will be documented and invoiced at \$175.00 per man-hour.

To enable our crew to work efficiently, several items are best supplied by your facility. These items are outlined on the enclosed list of mill services required.

Pricing is in US dollars, all customs, duties work permit fees etc are to the customers account. Also included for your files are our standard terms and conditions, with payment terms being net 30 days.

Thank you for this opportunity to be of service. We look forward to working with you to restore a desirable papermaking surface.

Sincerely,

VOITH PAPER SERVICE

Rob VanBeek

Rob VanBeek, Engineer
VOITH Cylinder Services - Portland

Enclosure: Mill Services List
Statement of Terms & Conditions

Cc: Richard Parenteau Papetieres Appalaches
Lloyd Willis Voith Paper Hawkesbury

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Yankee Dryer – Spray Only Mill Services Required - 4 Gun Set-Up

1. Electrical power, to consist of:
 - (4) Each Arc Rectifier----- 45 Amps, 480V, 3 Ph, 60 Cycle
 - (3) Each Vacublasters----- 20 Amps, 480V, 3 Ph, 60 Cycle
 - (2) Each Circuits, misc. equipment----- 15 Amps, 115V, 1 Ph, 60 Cycle
2. Mill electrician to provide electrical hook up for Voith Paper equipment.
3. Air supply to be instrument quality at 80-100 PSI and 600 CFM.
4. Roll drive speed control to provide 100 to 1000 SFPM including a start and stop.
5. Steam control from 10 PSI up to maximum operating PSI for the blasting and coating operation.
6. Thorough cleaning of the machine and machine area to remove paper dust and grease which pose a fire hazard.
7. A fire watch during the spraying operation, with safety curtains and barrier tape.
8. A machine felt to protect the grinder.
9. A forklift and driver to help unload and load the equipment and spot by the machine.
10. A mill crew to install a working platform for spray operations, as required.
11. Fluorescent lighting on the Yankee on the spray side.
12. An oxy/acetylene cart with regulators and hoses for possible spot repairs.
13. Clean the head bolts with a wire brush.

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Yankee Dryer Grind with Tangential Grinder Mill Services Required

1. Electrical power, to consist of:
 - (1) Each Voith Tangential Grinder ----- 60 Amps, 480V, 3 Ph, 60 Cycle
 - (2) Each Misc. Circuits ----- 15 Amps, 115V, 1 Ph, 60 Cycle
2. Air supply at 80-100 PSI and 40 CFM.
3. Mill electrician to provide hook-up for our equipment.
4. Roll drive speed control to provide 100 to 400 SFPM, including a start and stop.
5. Thorough cleaning of the machine and machine area to remove paper dust and grease which pose a fire hazard.
6. A mill crew to locate grinder at the Yankee and remove when complete.
7. A forklift and driver to help unload and load equipment and spot by the machine.
8. A working platform for the grind technicians.
9. An area to prepare the grinder 24 hours prior to installation with a controlled environment (no extreme changes in temperature).
10. Controlled temperature during the grind (no hood exhaust, no wash down near grinder, no drafts from open doors, etc.).
11. Fluorescent lighting to the Yankee surface.
12. An oxygen/acetylene cart with regulators and hose for potential spot repair requirements.
13. Clean the head bolts with wire brush.