

Installed on #2pm During July 2005 Shutdown



Metso Paper
P.O. Box 155
Ivy Park
Clarks Summit, Pa. 18414

**FOX RIVER
HOUSATONIC, MASS. 01236**

SUCTION COUCH ROLL (NEW SHELL)

P.O. 18927 and 20553

Our Order #604074

"AS SHIPPED REPORT"

September 16, 2005

FOX RIVER
295 PARK ST.
HOUSATONIC, MASS. 01236

Attention: Dennis Griffin

RE: P.O. 18927 and 20553
Our Order #:603465

Gentlemen:

We have completed the repairs to your Suction Couch Roll and offer the following report for your review.

If you need any additional information, please let me know.

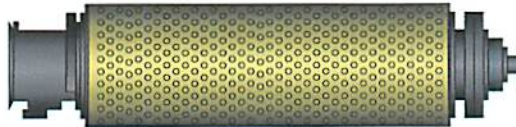
Lynn Costello
Your Customer Service Representative

**FOX RIVER
295 PARK ST.
HOUSATONIC, MASS. 01236**

SUBJECT: Suction Couch Roll PO # 18927 and 20553

We have completed the repairs to your roll and have prepared the following "As Shipped Report".

SHELL TYPE



[O] 1. Disassembled the roll .

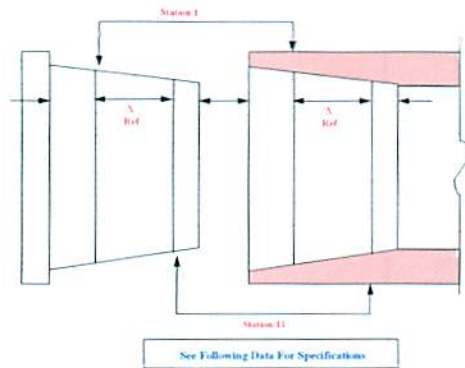
[R] 2. Replaced the shell per customer request.

Length 103.000"

Incoming Diameter 21.996"

Outgoing Diameter 21.986"

HEAD FITS: SHELL AND HEAD



[O] 3. Repaired the front head fit by electro-plating to restore proper size to fit new shell.

As Received Major Outboard 19.503"

Finished size: 19.495"

Recommended Interference .004/.008

Actual Interference .007

[O] 4. Repaired the rear head fit by electro-plating to restore proper size and to fit new shell.

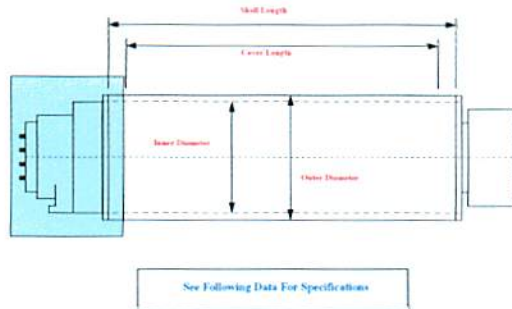
As Received Major Outboard 19.503"

Finished size: 19.494"

Recommended Interference .004/.008

Actual Interference .006

FRONT BEARING ASSEMBLY



[R] 5. Replaced the front bearing with a customer supplied new one

As Received - TORR. # 23048 BR /C3/ W33

Customer supplied - SKF # 23048 CC / C3 / W33

[A] 6. Inspected the front bearing retainer. No work was recommended at this time.

[A] 7. Inspected the front bearing housing. No work was recommended at this time.

As Received Outboard 14.176" Inboard 14.176"

Spec Size 14.175 /14.1765"

[R] 8. Replaced front bearing cover plate seal, due to being worn out.

[A] 9. Inspected the front bearing journal. No work was recommended at this time.

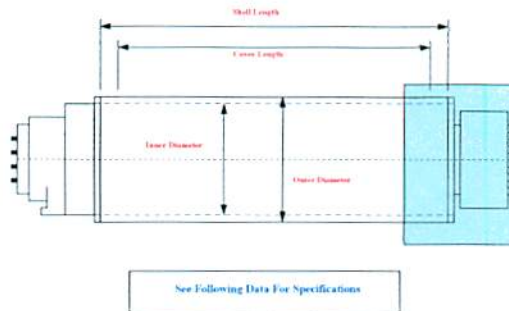
As Received H1/Outboard 9.451"

H2/Inboard 9.451"

Spec Size 9.451 / 9.452"

[A] 10. Inspected the flingers. No work was recommended at this time.

REAR BEARING ASSEMBLY



- [R] 11. Replaced the rear bearing with a new customer supplied bearing.
Customer supplied - SKF # 23048 CC / C3 / W33
- [A] 12. Inspected the rear bearing fit. No work was recommended at this time.
As Received H1/Outboard 9.451"
H2/Inboard 9.451"
Spec Size 9.451 / 9.452"
- [A] 13. Inspected the rear bearing housing bore. No work was recommended at this time.
As Received Outboard 14.177" Inboard 14.178"
Spec Size 14.175 / 14.1765"
- [R] 14. Replaced the rear internal bearing with a customer supplied new bearing
As Received - FAG # 22216 ES
Customer supplied - SKF # 22216 CC / C3 / W33
- [O] 15. Repaired the rear internal bearing housing bore by electro-plating to print dimension
As Received Outboard 5.512" Inboard 5.512"
Final size: 5.510"
Spec Size 5.5095 / 5.5105"
- [R] 16. Replaced the rear internal bearing cover end cap seal due to being worn out as received.
Customer supplied CR 34840..
- [A] 17. Inspected the rear internal puller ring. No work was recommended at this time.
- [A] 18. Inspected the bronze sleeve. No work was recommended at this time.
Outside Diameter Outboard 3.149" Inboard 3.149"
Inside Diameter Outboard 2.002" Inboard 2.002"
- [A] 19. Inspected the internal bearing journal. No work was recommended at this time.
Outboard 2.000" Inboard 2.000"

[A] 20. Inspected the internal bearing lock. No work was recommended at this time.

Locknut # AN 16

Lockwasher # W 16

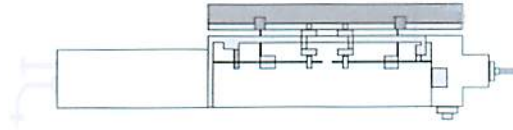
[A] 21. Inspected the plunger pin assembly. No work was recommended at this time.

[R] 22. Replaced the bearing end cover seals as they are worn out. Customer supplied (2) 64 x 4011.

[A] 23. Inspected the bearing flingers. No work was recommended at this time.

[A] 24. Inspected the R/J bearing retainer. No work was recommended at this time.

SUCTION BOX ASSEMBLY



[O] 25. Cleaned the suction box assembly by sandblasting and painted with corrosion inhibiting paint.

[O] 26. Repaired the packing holder(s) by cleaning and reassembling, the spring board design.
Customer supplied sealing strip springs.

[A] 27. Inspected end deckle holder. No work was recommended at this time.

[R] 28. Replaced the plain packing with customer supplied

[R] 29. Replaced the end deckles with customer supplied
Quantity supplied - 2

[A] 30. Inspected the skid block. No work was recommended at this time.

[R] 31. Replaced the lubrication shower with new stainless steel fabrication.

Fabricated and installed 2nd lubrication shower.

[O] 32. Repaired the oil/grease lines by cleaning, flushing and packing with customer specified grease

[O] 33. Repaired the water to packing holder lines by testing for proper operation

[R] 34. Replaced the front saddle housing seal, due to being worn out as received.

[O] 35. Repaired the worm gear/adjusting screw by cleaning and reinstalling

[O] 36. Repaired the bull gear by cleaning and reinstalling.

[R] 37. Replaced the identification tags as needed.

[O] 38. Repaired the end deckle adjusting rods/screws by cleaning and adjusting for full range of movement, and returning to as received location

As Received Dimension Front 4"

As Received Dimension Back 6-3/4"

[R] 39. Replaced any defective grease/oil fittings for routine maintenance.

[O] 40. Reassembled the roll per the prints

[O] 41. Tested per Metso specifications.

Total Cost \$ 83,237.00

Lynn Costello
Customer Service

CC: Joe DeGearo



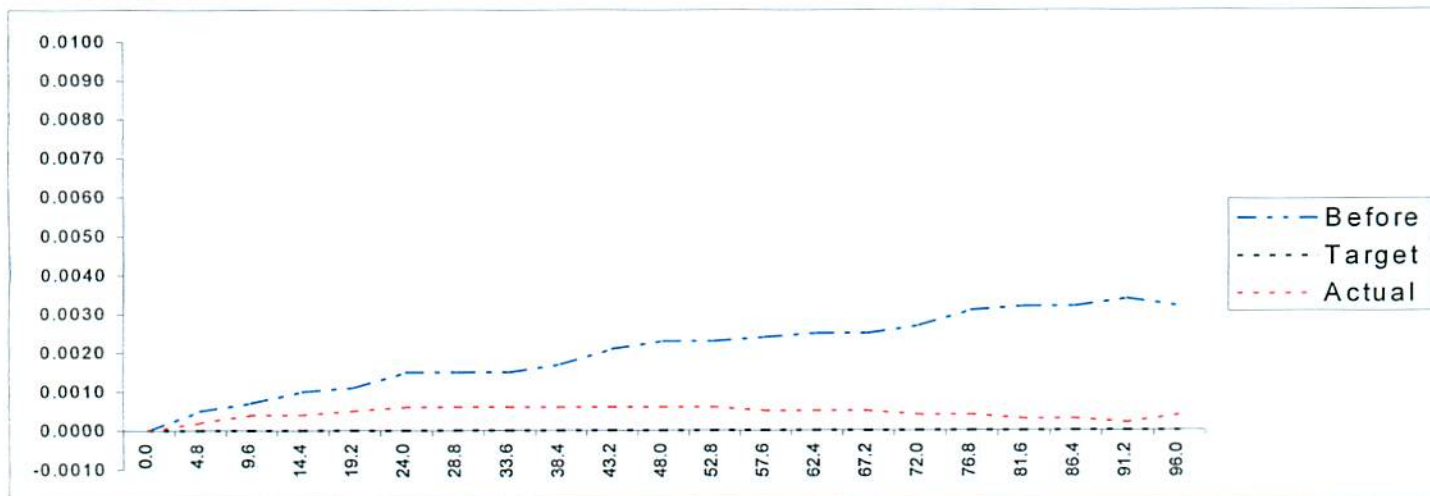
Metso

Grind Report

Fox River Paper
295 Park St.
Housatonic, MA 01236

Date Received:
Purchase Order:
Sales Order: 604074
Project Number 602583
Date Shipped:

Description: Manchester Suction Couch Roll with new S/S shell



	Station	Before	Target	Actual
DS	0.0	0.0000	0.0000	0.0000
	4.8	0.0005	0.0000	0.0002
	9.6	0.0007	0.0000	0.0004
	14.4	0.0010	0.0000	0.0004
	19.2	0.0011	0.0000	0.0005
	24.0	0.0015	0.0000	0.0006
	28.8	0.0015	0.0000	0.0006
	33.6	0.0015	0.0000	0.0006
	38.4	0.0017	0.0000	0.0006
CL	43.2	0.0021	0.0000	0.0006
	48.0	0.0023	0.0000	0.0006
	52.8	0.0023	0.0000	0.0006
	57.6	0.0024	0.0000	0.0005
	62.4	0.0025	0.0000	0.0005
	67.2	0.0025	0.0000	0.0005
	72.0	0.0027	0.0000	0.0004
	76.8	0.0031	0.0000	0.0004
	81.6	0.0032	0.0000	0.0003
TS	86.4	0.0032	0.0000	0.0003
	91.2	0.0034	0.0000	0.0002
	96.0	0.0032	0.0000	0.0004

Service Details

Cover Tradename

Cover Face 103
Incoming Diameter 21.996
Outgoing Diameter 21.986
Core Diameter 0
Cover Thickness 0

Crown Face 96
Crown Amount 0.000
Cosine 70

DS Dub 0
TS Dub 0

Surface Finish 0
Incoming Hardness 0
Outgoing Hardness 0

Notes:

Ground By: 141026

Date Ground: 5/2/05