



REFERENCE ENG. ES.CHAP000742			
FASTENER TIGHTENING TORQUE IN (FT.LBS)			
FASTENER SIZE	BOLT GRADE / MATERIAL		
	GRADE 5	GRADE 8	316 S
500-13 UNC	55	80	45
.625-11 UNC	110	160	100
.750-10 UNC	200	280	130
.875- 9 UNC	320	450	200
1 000-8 UNC	480	680	300
1.250-7 UNC	840	1360	550
1.500-6 UNC	1460	2370	930

- (A) 1ST MAIN PRESS (7.00" TOWARD WET END)
- (B) 1ST MAIN PRESS TOP ROLL (REF 6-5002)
- (C) 1ST MAIN PRESS BOTTOM ROLL (REF C-5445)
T.S. ROLL REMOVAL EXTENSION REQUIRED (BY CUSTOMER)
- (D) EXISTING EDGE TRIM ASSEMBLY TO BE MODIFIED
AND MOUNTED (BY CUSTOMER)
- (E) EXISTING DOCTOR AND OSCILLATOR TO BE MODIFIED
AND MOUNTED (BY CUSTOMER)
- (F) EXISTING DOCTOR AND OSCILLATOR TO BE MODIFIED
AND MOUNTED (BY CUSTOMER)
- (G) TAIL THREADING ROPE SYSTEM MODIFICATIONS (BY CUSTOMER)
- (H) SCANNER
- (J) FELT ROLLS (13.25 DIA. X 178.00 FACE)
- (K) PAPER ROLL (11.25 DIA. X 178.00 FACE)
T.S. BEARING HOUSING MODIFIED BY VALMET
D.S. BEARING HOUSING SPHERICAL DIAMETER
MODIFIED TO 6.870/6.875 DIA. (BY CUSTOMER)

- 16 FELT CHANGE PROCEDURE DWG. 5U390-0678
- 17 ROLL CHANGE PROCEDURE DWG 5U390-0679
- 28 2ND/3RD MAIN PRESS LOADING CHART DWG 3U390-0719

FRESH	☒ DENOTES ✓	☐ UNLESS OTHERWISE SPECIFIED	MASS (LB.)	SHEET 2 OF 5
UNIDIRECTIONAL FLOWLINES (INDICATE DIRECTION)				DEBURR ANY/OVER BREAK ALL SHARP CORNERS OR EDGES - Q3 RAD. MAX.
TURBOCHARGED	VALVE	SPRING	DATE	
1 PLANK 10-28-16	1 VALVE 10-28-16	1 SPRING 10-28-16		
2 PLANK 10-29-16	2 VALVE 10-29-16	2 SPRING 10-29-16		
3 PLANK 10-29-16	3 VALVE 10-29-16	3 SPRING 10-29-16		
4 PLANK 10-29-16	4 VALVE 10-29-16	4 SPRING 10-29-16		
ASSEMBLY	TEST	REWORK	ACTUAL	REMARKS/DRAW.
1 ASSEMBLY 10-28-16	1 TEST 10-28-16	1 REWORK 10-28-16		
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 VALMET Charlotte Inc.			DRAWN BY  D. PAUL DATE 2 MAY 94	
			CHECKED BY D. PAUL DATE 4 MAY 94	
			APPROVED BY D. PAUL DATE 5 MAY 94	
TITLE			REFERENCE	SUPPLIERS
PRESS ARRANGEMENT				
GROUP	FROM FRONT/ELEVATION (UPPER)		DRAWING NO.	
PRODUCT	PRESS		9U30UO-0360 A	