

WET-LAP MACHINE

The wet-lap machine is two meters in width. It is a two section wet-lap. The primary section is a three-nip press section. The secondary press is a single nip capable of 1500 P.LI. pressure. The drives are Reliance Automax D.C. drives.

Two of the three press nips of the primary section are drive rolls. Both top and bottom rolls are driven. The secondary press nip rolls are driven separately with a draw function between the two sections of the machine.

The machine chest, 12 feet x 12 feet high has a capacity of 10,000 gallons. Stock is fed to the machine chest at 6% consistency and mixed with a Lightnin 30 H.P. agitator. A 50 H.P. Allis-Chalmer stock pump with consistency dilution feeds the headbox at 3.5 to 4.0% consistency. The headbox discharges stock between the twin wires supported by four-foot long plastic deckles. From the deckles, the sheet is formed between offset and converging table rolls. The first press rolls are driven, the second press rolls are not driven and the third press rolls are the master roll set. The bottom third press roll (75 H.P.) is the machine speed which all other drives are slaved for speed control. Discharge from the primary section is 45 to 48% air dry.

The secondary section is also a twin wire press. It is capable of higher nip pressures with the 24" diameter bellows loading each side of the press. Discharge from the secondary is 50 to 52% air dry running bleached Kraft softwood with a Canadian freeness of 600. The secondary press discharges to the cutter. The cutter is driven by a 25 H.P. D.C. motor, 56:1 Eurodrive gearbox to a 7-1/2 wide poly-v-belt.

The cut sheet is discharged onto a high-speed belt, which throws it on to an elevated conveyor. The height of the conveyor is controlled by a hydraulic scissor lift. At a determined bale height, the bale drops and forks extend to catch the first sheet of the next bale. The bale is conveyed at a right angle to the machine to a weight conveyor and then to a Cranston peg-up conveyor where it is removed by a forklift.

EQUIPMENT LIST

Machine In-Place

Tank -Machine chest 12 FT x 12 FT (10,000 Gal.)
Agitator -30 H.P. Lightnin mounted on side of chest
Pump -Machine chest to headbox 50 H.P. A-C F8MI
Screen -Bird model 7, 5/16" holes
Machine -Primary section, 3-press nip twin wire
Machine -Secondary section, 1-press nip twin wire
Cutter -Rotary knife with anvil
Conveyor -High speed belt
Conveyor -Belt conveyor on scissor lift
Lift -Scissor lift with hydraulic unit
Conveyor -Staging conveyor
Conveyor -Weight conveyor
Conveyor -Cranston peg-up

Auxiliary Equipment

Pump -White water return A-C CSO
Pump -Trim jet
Bridge -3-ton bridge crane with (2) Yale hoists
Panel -Control panel with Nematron and Panelalarm
Controls -6 controllers

Spares for Machine

Each roll has a spare; some rolls were converted to tapered bore bearings.
Most are straight bore journals. Spare cutter roll is included. All meters have
spares with spare cards for Automax drive system.

Not Included with Machine

Repulper agitator
Repulper return pump
Sump pump Bale
tracking system

EQUIPMENT LISTING - MECHANICAL

<u>ENTITY #</u>		<u>DESCRIPTION</u>	<u>CHARGE #</u>
842-101-00	7 M	PUMP: STOCK TO MACHINE CHEST	752
842-103-00	7 M	TANK: MACHINE CHEST 8X14	752
842-104-00	7 M	AGITATOR: MACHINE CHEST	752
842-105-00	7 M	PUMP: MACHINE CHEST TO HEADBOX 50 H.P., 1170 RPM, F8-MI ALLIS-CHALMER	752
842-105-10	7 M	SCREEN: STOCK (49ER) BIRD MODEL 7 40 H.P. 1170 RPM	752
842-106-00	7 M	MACHINE: SHEET PULP (49ER) 2 METER SILVER ENG, 4' SEC. DECKLES, 80-5XLPT 1984-8' SEC TABLE ROLLS, S/N 4-73-038, 3 PRESS ROLL SETS, FIRST & LAST DRIVEN	752
842-106-01	7 M	BOX: SHEET PULP HEAD	752
842-106-02	7 M	PRESS: PRIMARY SHEET PULP MACHINE	752
842-106-03	7 M	PRESS: SECONDARY SHEET PULP MACHINE	752
842-106-04	7 M	CONVEYOR: SHEET PULP MACHINE TRANSFER BELT	752
842-106-05	7 M	CUTTER: SHEET PULP MACHINE	752
842-106-06	7 M	CONVEYOR: SHEET PULP MACHINE HI SPD BELT	752
842-106-07	7 M	CONVEYOR: SHEET PULP MACHINE LAYBOY	752
842-106-10	7 M	DRIVE: PRIMARY PRESS HELPER	752
842-106-11	7 M	DRIVE: SECONDARY PRESS HELPER	752
842-106-15	7 M	ROLL: PINCH #1 - BOTTOM	752
842-106-16	7 M	ROLL: PINCH #2 - TOP	752
842-108-00	7 M	CONVEYOR: BELT SCALE INFEED	752
842-108-02	7 M	CONVEYOR: BELT SCALE	752
842-108-03	7 M	CONVEYOR: CHAIN RECEIVING	752
842-110-00	7 M	PUMP: WHITE WATER	752
842-113-00	7 M	PUMP: REPULPER CHEST <i>— IN Flock</i>	752
842-115-00	7 M	PUMP: SUMP	752
842-116-00	7 M	PUMP: TRIM JET	752
842-117-00	7 M	PUMP: TRIM JET	752
842-119-00	7 M	PUMP: TRANSFER	752
842-120-00	7 M	CONVEYOR: PEG UP	752

EQUIPMENT LISTING - MECHANICAL

<u>ENTITY #</u>		<u>DESCRIPTION</u>	<u>CHARGE #</u>
842-121-00	7 M	CONVEYOR: PULPER FEEDER	752
842-131-00	7 M	PUMP: ACID METERING	752
842-201-00	7 M	HOIST: EAST BRIDGE CRAIN (3 TON)	752
842-201-01	7 M	HOIST: EAST BRIDGE CRANE (NORTH HOIST)	752
842-201-02	7 M	HOIST: EAST BRIDGE CRANE (SOUTH HOIST)	752
842-050	6	REPULPER MIX TANK LEVEL CONTROL	752
842-053	6	49ER REPULPER STOCK TO BLEACH PLANT SELECTOR	752
842-054	6	49ER REPULPER STOCK TO 49ER MACHINE CHEST SELECTOR	
842-102	6	49ER STOCK SCREEN DUMP VALVE	
842-109	6	49ER MACH CHEST PH	
842-110	6	49ER MACH CHEST LEVEL	
842-111	6	STOCK CONSISTENCY TO 49ER	
842-112	6	49ER STOCK FLOW TO HEADBOX	
842-114	6	49ER WHITE WATER CHEST LEVEL	
842-115	6	49ER REPULPER CHEST LEVEL	
842-116	6	49ER REPULPER STOCK CONSISTENCY	
842-117	6	49ER REPULPER TRIM DILUTION	
842-120	6	49ER SHEET BREAK	
842-125	6	49ER SUMP LEVEL	
842-130	6	49ER BUILDING HEATING SYSTEM	
842-140	6	49ER L.P. STM FLOW TO STEAM HEATERS	
842-200	6	49ER FEED TANK TO HDBOX STK CONSISTENCY	
842-201	6	PULP STOCK FLOW TO 49ER MACH CHEST	
842-202	6	PULP CLEANERS STOCK FLOW TO LO D CHEST	

EQUIPMENT LISTING - ELECTRICAL

<u>ENTITY #</u>		<u>DESCRIPTION</u>
842-037-00	7 E	TRANSFORMER: INSTRUMENT POWER/49ER MCC
842-039-00	7 E	PANEL: B INSTRUMENT POWER/49ER HCC
842-043-00	7 E	PANEL: C GENERAL POWER/49ER MCC
842-055-00	7 E	PLC PROCESSOR 11A
842-101-00	7 E	MOTOR: STOCK TO MACHINE CHEST PUMP
842-102-00	7 E	SCREEN: BIRD STOCK
842-104-00	7 E	AGITATOR: MACHINE CHEST
842-105-00	7 E	MOTOR: MACHINE CHEST TO HEADBOX PUMP
842-106-00	7 E	MACHINE: SHEET PULP (49ER)
842-106-02	7 E	PRESS: PRIMARY SHEET PULP MACHINE
842-106-03	7 E	PRESS: SECONDARY SHEET PULP MACHINE
842-106-04	7 E	CONVEYOR: SHEET PULP MACH TRANSER BELT
842-106-05	7 E	CUTTER: SHEET PULP MACHINE
842-106-06	7 E	CONVEYOR: SHEET PULP MACHINE HI SPD BELT
842-106-07	7 E	CONVEYOR: SHEET PULP MACHINE LAYBOY
842-106-08	7 E	LIFT: HYD SCISSORS SHEET PULP MACHINE
842-106-10	7 E	MOTOR: PRIMARY PRESS HELPER DRIVE
842-106-11	7 E	MOTOR: SECONDARY PRESS HELPER DRIVE
842-106-15	7 E	MOTOR: #1 PINCH ROLL TOP
842-106-16	7 E	ROLL: TOP PINCH #2
842-108-00	7 E	CONVEYOR: BELT SCALE INFEED
842-108-02	7 E	CONVEYOR: BELT SCALE
842-108-03	7 E	CONVEYOR: CHAIN RECEIVING
842-110-00	7 E	MOTOR: WHITE WATER PUMP
842-116-00	7 E	MOTOR: TRIM JET PUMP
842-117-00	7 E	MOTOR: TRIM JET PUMP
842-123-00	7E	49ER LUB OIL PUMP
842-139-00	7E	HOOD: 49ER