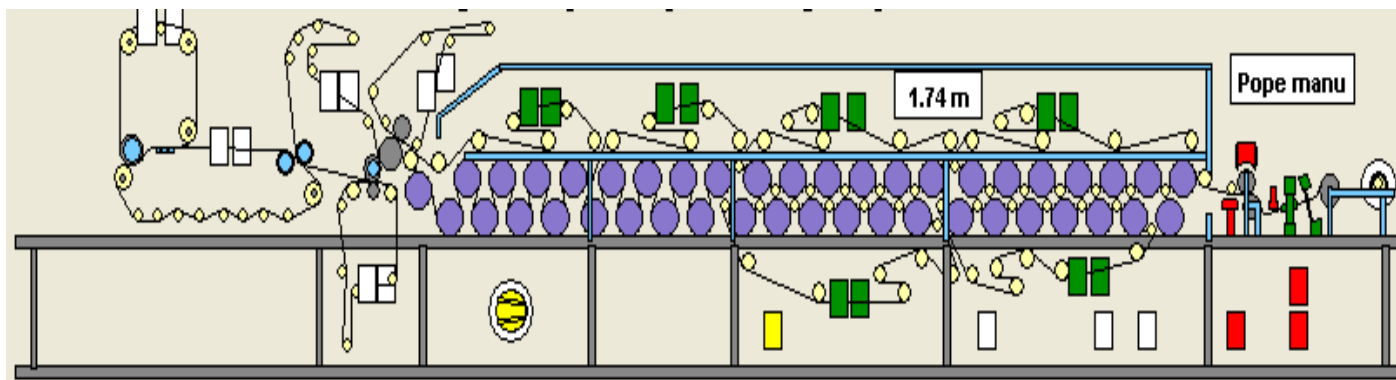
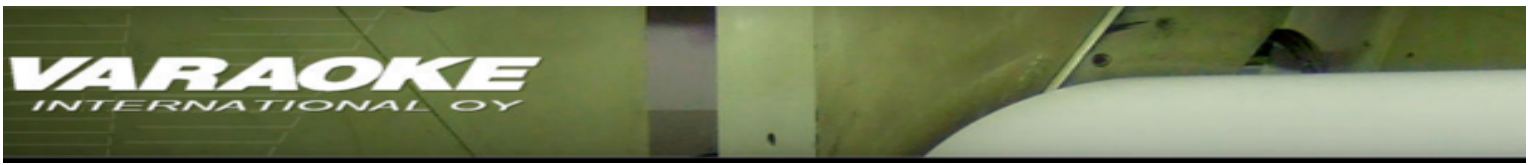


VALMET PAPER MACHINE 8170/7630 mm

Production line basic information

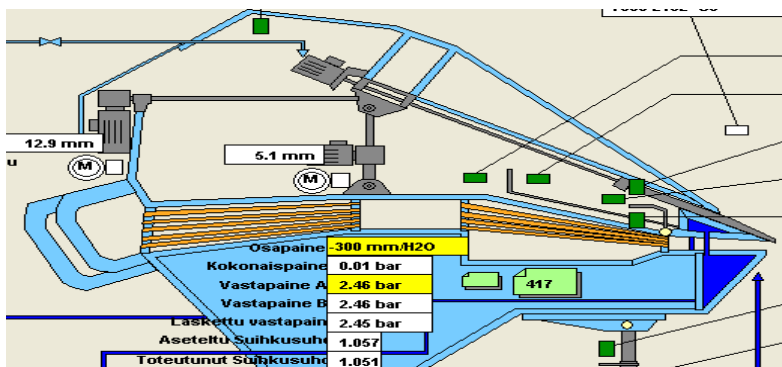
- Built 1981 by Valmet
- Construction speed, original 1200 m/min, new parts 1700/1800 m/min
- Max production speed 1640 m/min (24 h)
- Average speed 1550 m/min (1 year), efficiency 1740 km/d (LWC, 1 year)
- Capacity 250 000 t/a LWC grades, PM time eff. 92 % (1 year)
- Grammage 35 - 70 g/m² LWC , base 26 - 45 g/m²
- Wire/Trim width 8170/7630 mm, winder 7360 mm

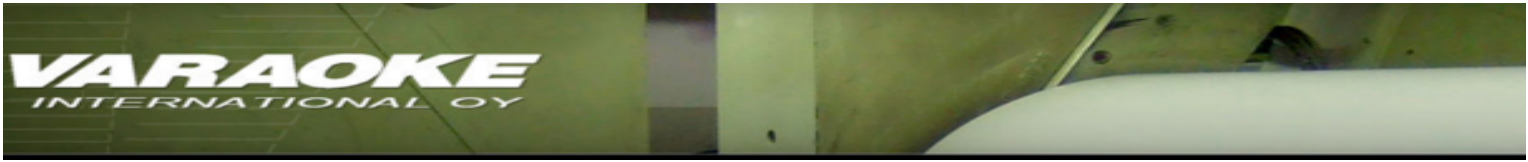




Head box

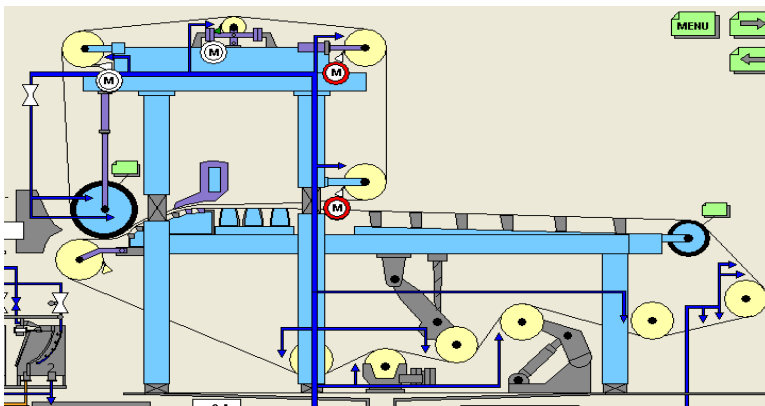
- Conventional Sym Flo HHS head box by Valmet (1992)
- Width 8040 mm
- Dry weight control system
- - Amount of control systems 81





Wire section

- Valmet Speed Former HHS (rebuild 1992)
 - Bottom wire 51,3 m x 8,17 m
 - Topwire 24,6 m x 8,19m
- 3 chamber forming shoe , 3 vacuum boxes , former roll, deflector+autoslice
- Renewal of bottom wire stretchers and guiding rolls (Valmet year 2006)

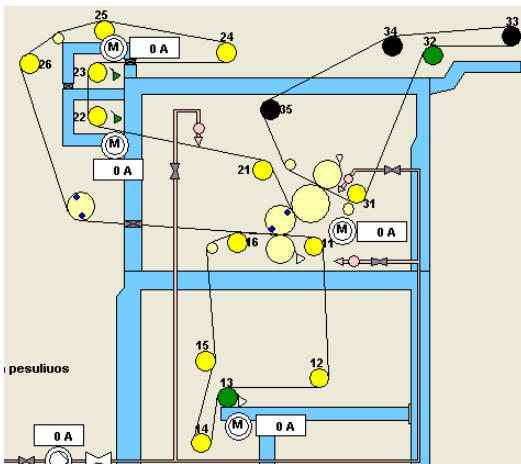


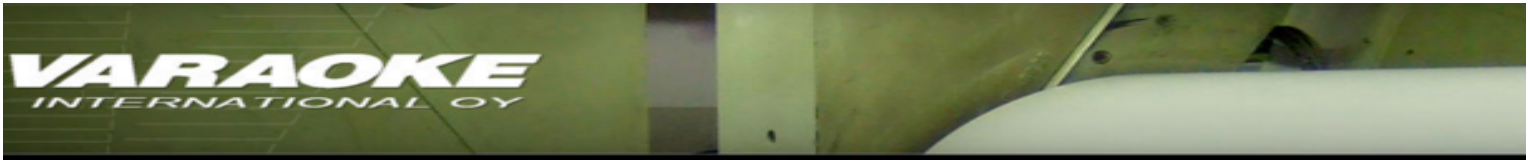
WET END



Press section

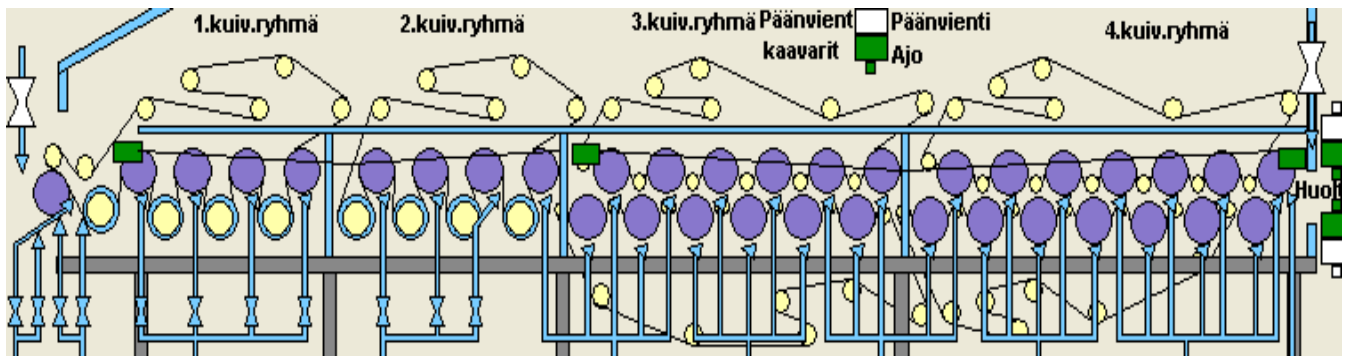
- Valmet SymPress II
- Valmet Profisteam E steam box (1997)
- Line loads 70, 80 and 130 kN/m (1.nip : kusters – suction roll, 2.nip: suction roll – center roll, 3.nip: center roll – Sym ZS roll)
- Double doctor blades for center roll (2011)

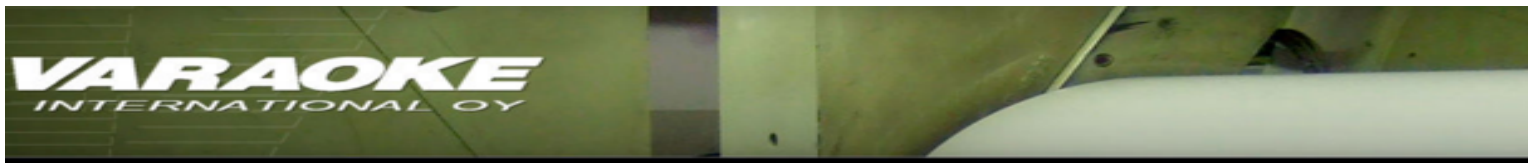




Drying section

- 4 drying groups, 43 cylinders + baby cylinder
 - Cylinder diameter 1830 mm, (baby 1500 mm)
 - Max operational pressure 0,50 MPa
- Dryer section parts 1-2 , single felted groups
 - VAC cylinders (bottom), UNO RUN blow boxes + press run box
- Dryer section parts 3-4
 - Double felted groups , twin run blow boxes
- Ropeless tail threading system (Voith year 2002)
- Renewal of several dryer fabric guiding rolls (Voith year 2001)



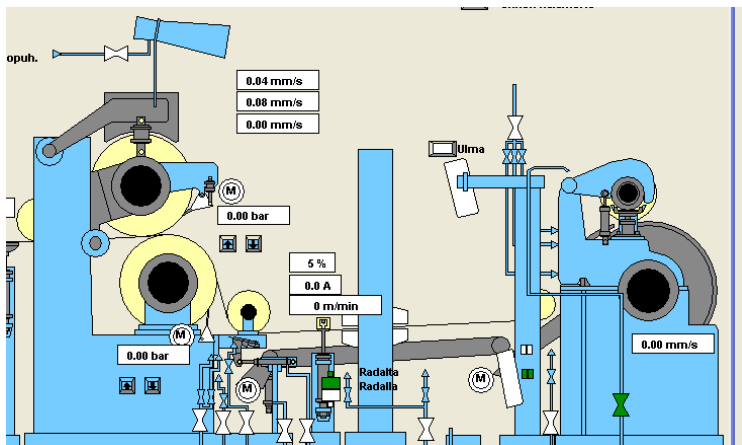


Drying section



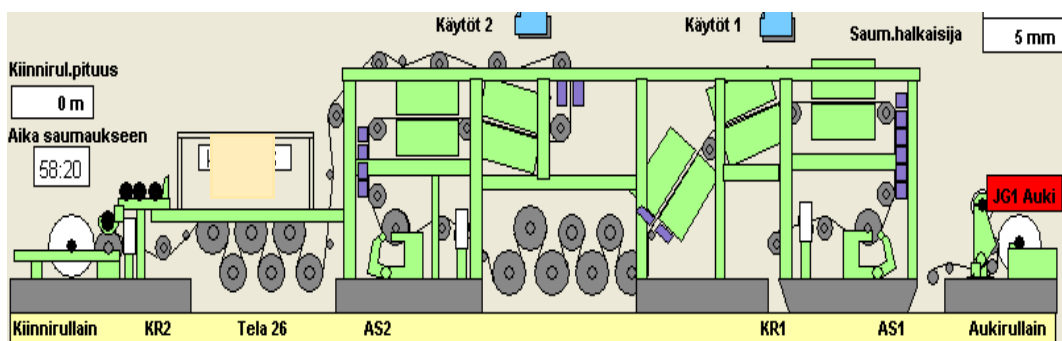
Machine calander and reeler

- Conventional hard nip machine calander
- Conventional pope reeler
 - Goose neck



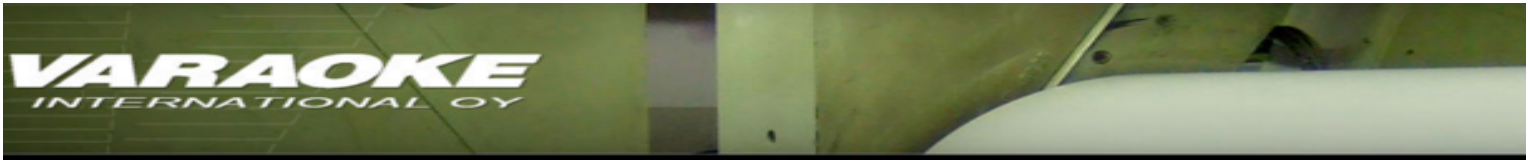
Off-line Coater (Coater 3)

- Built in 1988 by Valmet
- Construction speed 1600 m/min
- 2 Metso OptiBlade Plus coating heads
- 5 air dryers, 1 electric IR dryer, 2 gas IR dryers, 2 drying groups
- Pope reeler



Coater unwind station



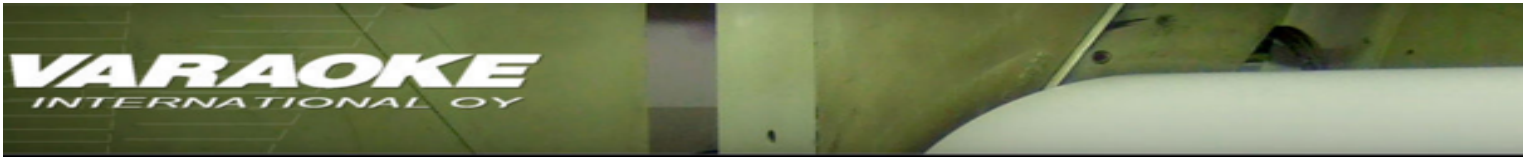


Coater Coating Station 2 (OptiBlade Plus)



Coater Station 1



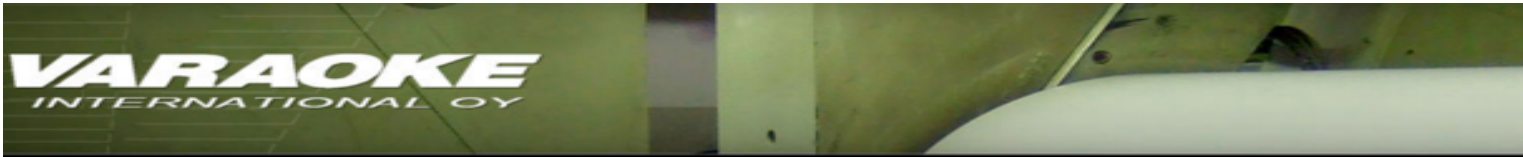


Winder 5

- Center-drum winder : WÄRTSILÄ JR 1000 (1988), Raumaster modernizing 2013
 - Speed. 2300 m/min
 - Width 7550 mm
- Stations
 - 6 standard 4000 kg
 - 3 heavy 6000 kg
 - 1 super heavy 8000 kg
 - 3“chucks (6“ adapters)
- Number of slitters
 - pre slitting 2
 - main slitting 13
- Belt press rolls, 9 pieces
- - width of rolls 7900 mm
- PU covered winding rolls
- hard center roll
- - Automatic set change by Raumaster
- Siemens S7 logic - wincc control (Raumaster)

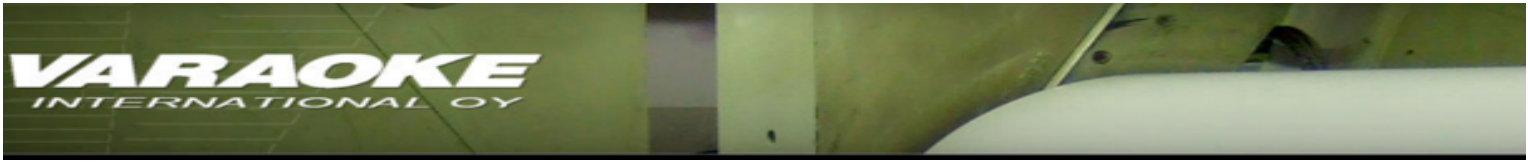
Winder PL 5





Rebuilds to PM

- Headbox
 - Sym-Flo HHS by Valmet – 1992
- Former section
 - Speed Former HHS top wire unit by Valmet – 1992- several bottom wire guide rolls and stretchers by Valmet – 2006
- Press section
 - steam box Profisteam E by Valmet – 1997 - double doctor blades for center roll – 2011
- Drying section
 - first two drying groups with Vac rolls (drilled) by Valmet – 1991
 - Press run, Uno run and Twin run boxes by Valmet – 1989
 - several new dryer fabric guide rolls by Voith – 2001
 - ropeless tail threading system by Voith – 2002
- Reeler- Foil force tail threading
 - Reel jet water change system – 2007
 - Ulma Nti defect detection by ABB – 2002
- Re -reeler
 - Optireel by Valmet – 1993
- Automation
 - Honeywell Alcont – 1998



- Off –line coater 3
 - Paprima water operated edge cutters – 2002
 - RP DCF 2000 machine screens – 2002
- Winder 5
 - Raumaster modernizing – 2013, (automatic set change, Siemens S7 logics, PU –cover rolls, one 8000 kg reeling station)
- PM stock handling
 - broke screening by Valmet – 1997

