

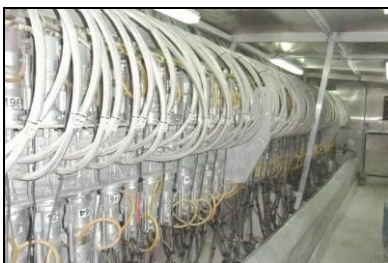
Acme Surplus Machinery Inc.

Quality Surplus Machinery for Pulp & Paper

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6450 mm Trim Paper Machine with 2 Deinking Lines Acme A098377

Used 6.45 meter (254") paper machine, new in 1998, with deinking lines capable of 170,000 TPY on 40 – 120 gsm. Ran LWC 54 – 85 gsm with a production of 506 TPD with the highest being 785 TPD. The design speed is 800 – 1500 MPM. The machine includes: Beloit headbox; fourdrinier bottom former; high capacity Belbond top former; presses; pick up roll; 31 pre dryer section; metering size press; airturn and air dryer hood; 7 post dryers; soft nip calender; reel; QCS and DCS; and 2 winders. Additionally, there are two deinking lines.



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General:

Width: 6.45m trim, drive r/hand.

Capacity: 170,000 tons/year, 40 to 120 gsm, on LWC 54 to 85gsm

Daily production 506 t./day and record production 785 t/day

Speed design: 800 to 1500 m/min

Operational Speed: 1330 m/min

Headbox:

General description: Concept IV-MH (Converflo type) from Beloit with Cleanvac from Alfa Laval deculator system with a tube battery for consistency control.

Speed design: 1500 m/min

Design flow: 76,500 l/min(first step)

88,300 l/min (second step)

Forming section:

Hybrid former: standard fourdrinier on bottom position with high capacity Belbond on top.

Fourdrinier bottom former:

General description: 15,000 mm between breast and couch roll axis

Breast roll Ø 965 mm, face 7210 mm

Couch roll Ø 1118 mm, face 7210 mm, vacuum boxes 153 mm and 203mm

Driven roll Ø 978 mm, face 7210 mm

Back rolls 4 units, Ø 711 mm, face 7210 mm

Forming board: 1 leading blade, 3 trailing blades

Hydrofoil boxes: 3 units containing 5 foils each one

Vacufoil box: 6 foils units

Flat suction box: 2 units

High Capacity Belbond Top Former:

Lead in roll Ø 965 mm, face 7210 mm

Driven roll Ø 978 mm, face 7210 mm

Guiding roll Ø 711 mm, face 7210 mm

Stretcher roll Ø 965 mm, face 7210 mm

Inverted curved suction box: 2 suction zones, 1 autoslide bar, 20 foils

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Inlet vacuum box: 1 leading blade, 18 Blades

Transfer vacuum box: 17 blades

Stock: Belmont bottom wire: dryness 19.5%

Press Section:

Supplier: Beloit and Kusters

Type: Tri-Vent plus suction pick up

Contacts: 3 Nips with a center press roll

Loading pressures: 90 Kg/cm 1st press, 109 kg/cm 2nd press and 130 kg/cm 3rd press.

3rd press, 2nd press, 1st press: dryness 43.5%

Pick up Roll:

Ø 914 mm, face: 7036 mm, high vacuum box width 100 mm, low vacuum box width 127 mm

1st Press: Ø 835 mm, type HV, manufactured by Kusters

Top suction roll 1st Press: Ø 1218 mm, face: 7086 mm, high vacuum box width 152.4 mm, low vacuum box width 798 mm

2nd Press: Ø 835 mm, type HV

Centre roll: Ø 1550 mm, face: 7240mm, cover: Microrock

3rd Press: Ø 835 mm, type HV

Guiding rolls: Ø 580 mm, face: 7391mm

Spreader rolls Ø 267 mm, face: 7391mm

Pre Dryer Section:

General description: Bel-Champ by Beloit: single tear configuration with 31 drying cylinders and vacuum rolls (PV-ROLLS), 6 Drying Groups with enclosed gear drive, rated pressure 5.3kg/cm² (75 P.S.I)

Drying cylinders: Ø 1829 mm, face 6985mm

Baby roll: Ø 1220 mm, face 6985

Guiding fabric rolls: Ø 508 mm, face 7340

Vacuum rolls: Ø 609 mm, face 7342 mm

The dryer section is also equipped with a moisturizer unit (water spray nozzles) in dryer 26 for curling and moisture profile control and Duocleaner express for cleaning dyer fabrics in first and second group. The dryer section was rebuilt in 2003 by Metso in order to install stabilization boxes (HI RUN) in the first and second group to improve web stabilization in the edges.

Metering Size Press:

General description: Coating /sizing station consists of two big diameter application rolls in an inclined size press standard configuration. "Short Dwell" headers apply coating or sizing over the application rolls through application rods.

Top roll: Ø 1313 mm, face 6970mm, 55 PJ cover

Bottom roll: Ø 1313 mm, face 6970 mm, 45 PJ cover

Guiding rolls: Ø 630 mm, face 6990 mm

Spreader roll: Ø 267 mm, face 6990 mm, type Mount Hope.

Airturn and Air dryer Hood:

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After the rebuild of the machine in 2003 in order to produce coated grade, an Airturn system was installed after the coating station, both for guiding the wet web entering the air dryer hood and to control web tension.

Post Dryer:

General description Bel-Champ by Beloit: 7 drying cylinders in Slalom Configuration, rated pressure 5.3 Kg/cm² (75 P.S.I)

Drying cylinders: Ø 1829 mm, face 6985 mm

Soft Nip Calender:

General description: two-roll soft calender: Thermo roll (metallic hard roll) plus MHV roll (soft roll).

Two nips with inverted roll order: hot roll at top (1st cal.), hot roll at bottom (2nd cal.).

Thermo roll: Ø 1168 mm, face 6970mm, carbide tungsten cover

MHV roll: Ø 803 mm, face 6970 mm, CCR roll with 34 control areas.

Reel:

General description: Beloit HLR, maximum winding diameter Ø 2800 mm, goose neck type turn up system, automatic spool loading system.

Drum: Ø 1220 mm, face 6758mm, water cooled, spiral grooved to avoid air entrapped cover.

Primary arms: through hook shaped forks, pneumatic loading system, electrically driven.

Secondary arms: pivoting arms, pneumatically loaded.

Spools: 12 units, Ø 730 mm, face: 6990 mm

Rebuilt in 2010 in order to upgrade control system to Siemens S7.

Spares:

Complete with all spares and spare rolls.

Drive Section:

General description: ABB AC Sectional Electric Drive, 50 Hz, 500 volts, 3-phase. Type ACV 700 in all sections but bottom wire ACA and winder n°2 ACS 600.

Speed design: 150 m/min

QCS and DCS:

General description: DCS based in ABB AC 450. QCS system from ABB

Scanners: 2 frames: one before sizer and at reel

Measures before sizer: grammage, moisture, ash content

Measures at reel: grammage, moisture, gloss: top and bottom, shade, brightness, caliper.

Winders:



General description: two winders, two-drum winding concept, articulated rider roll wheels for adapting the RR pressure to the paper profile. Maximum speed: 2500 m/min, maximum diameter: 1525 mm. Maximum trimmed width: 6470 mm, minimum possible trim 155 mm. Core diameters: 70, 76, 100, 120, 150 mm. Web tension range: 750-2000 N/m. Main functions: automatic set change, automatic rider roll pressure control, automatic web tension control.

Other equipment:

Ultrafiltration unit: supplied by METSO, capacity up to 800 m³/day

Web detection systems: web inspection system from ABB (WIS), installed at reel position.

Web detection cameras: high speed cameras and complete software system from PROCEMEX.

DIP 2 LINE

General: Capacity: 400 ton/day, supplier Voith



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Pulping:

Pulpers 2 units type HDC 50
Helical pulpers with 50 m³ capacity
Consistency 12 to 18%
Fiberizer type F4-P.b supplied by VOITH
Screen basket holes Ø10 mm
Trommel: supplied by Lamort
Screen basket holes Ø16 mm
Screenex Type SX60 manufactured by Meri
Compax Type CX50 manufactured by Meri

High consistency cleaning:

HDC cleaning Protector system by VOITH
1st stage type DR600/20
2nd stage type KS205/6
Sedimator SM 28 manufactured by Meri

1st screening stage hole screening
Primary: Omniscreen OS8-LR Ø1.2 mm by VOITH
Secondary: Omniscreen OS2-LR Ø1.2 mm by VOITH

2nd screening stage Slot screening
Primary: Spectroscreen SS-33D //0.25 mm by VOITH
Secondary: Spectroscreen SS-23D //0.25 mm by VOITH

3rd screening stage HDC plus slot screening
HDC type KS250/6 by VOITH

Spectroscreen SS-13 // 0.25 mm by VOITH
Rejectosorter Two units RS2B supplied by VOITH
Screen basket holes Ø2.2 mm

Preflotation:

General description: 6 primary flotation cells plus 2 secondary plus mixer
Mixer cell ECO ECC 5/41
Primary cells ECO ECC 5/41

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Secondary cells ECO ECC 5/41

HDC Cleaning:

General description: 4 stage HDC cleaning

1st stages 114 units (15x8) HC5

2nd Stage 34 units (5x8) HC5

3rd Stage 12 units (2x8) HC5

4th stage 5 units (1x5) HC5-AK5

Screening:

1st screening stage: slot screening, vertical screen, type VS-41/16, screen basket Cbar // 0.15mm

2nd screening stage: slot screening

Primary: vertical screen VS-25/1, screen basket //0.25 mm

Secondary: Minisorter MS-11 screen basket //0.15 mm

3rd screening stage: slot screening, vertical screen, type VS-21, screen basket // 0.15 mm

Disc filter and thickening and dispersing:

Disc Filter Hidrodisk

N° Discs: 19

Thickening Screw Press

Andritz SCP 1400-7

Disperging Disperger HTD5

Brightness 80 to 85



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DIP 3 LINE

General: Capacity: 200 ton/day, supplier Voith / Lamort

Pulping:

Pulpers 2 Units LAMORT
Helico pulpers with 18 m³ capacity
Consistency 7 to 16%
Auxiliary Pulper Pera from Lamort
Screen basket holes Ø10 mm
Trommel Supplied by Lamort
Screen basket holes Ø16 mm

High consistency cleaning:

HDC cleaning Protector system by VOITH
1st stage type DR600/20
2nd stage type KS205/6

1st screening stage Hole screening
Primary: S- Screen Ø1.6mm
Secondary: Turbosorter Ø1.6mm

2nd screening stage Slot screening
Primary: Spectroscreen SS-23D/0.25 mm by VOITH
Secondary: Screen CH7 0.25 mm by LAMORT

3rd screening stage HDC plus slot screening
HDC type KS200/15 by VOITH
Screen CH5 // 0.25 mm by Lamort
Rejectosorter RS2B supplied by VOITH
Screen basket holes Ø2.2 mm

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Pre flotation:

General description 3 primary flotation cells plus 2 secondary
Primary cells Vertical by LAMORT Size VI
Secondary cells Vertical by LAMORT Size VI

HDC Cleaning:

General description Beloit Posiflow 60 cleaners
1st stage 48 units
2nd stage 20 units
3rd stage 6 units

Screening:

1st screening stage Slot screening
Vertical Screen
Type VS-31
Screen basket Cbar // 0.15 mm

2nd screening stage Slot screening
Primary: Vertical screen VS-21 screen basket //0.25 mm
Secondary: Minisorter MS-11 screen basket //0.15 mm

3rd screening stage Slot screening
Vertical Screen
Type VS-12 Screen basket // 0.15 mm
Disc filter and Thickening and Dispersing:
Disc Filter Andritz
N° Discs: 12
Thickening Screw Press
Andritz SCP 1000-6

Dispersing:

Disperger HTD3B

Bleaching and Postflotation:

Bleaching: bleaching tower 75 m3
Postflotation: 4 primary flotation cells plus 1 secondary plus mixer
Primary cells ECO ECC 3/38
Secondary cells ECO ECC 3/38

Disc filter 2 and Thickening:

Disc Filter Hidrodisk 15
N° Discs: 8

Thickening Screw Press
Andritz SCP 1000-6

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Stock storage:

Storage tank 500 m3

Water treatment:

DAFs Krofta Supercell SPC-30

Deltapurge DP 28A-S by OMC

Brightness 80 to 85



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