

- NOTES:**
- ROLL IS DESIGNED TO OPERATE @ 800 FPM, 300 PLI
 - VACUUM CAPACITY: 2.854 CFM @ 22 inHg
 - SHIPPING BRACKETS SHOULD BE IN PLACE ANYTIME ROLL IS GREASED, WHEN OUT OF MACHINE, IN ORDER TO HOLD THE CENTERLINE DIMENSION OF THE BEARINGS.
 - MECHANICAL DECKLE ADJUSTMENT: 12" OF TRAVEL EACH END
 - SEAL STRIPS AND DECKLE PACKING TO BE RUBBER GRAPHITE
 - SEAL STRIPS ARE AIR LOADED.
 - FRONT BEARING: SKF 23080 or EQUAL
 - REAR BEARING: SKF 23072K or EQUAL
 - INTERNAL BEARING: SKF 23036K or EQUAL
 - BEARING ASSEMBLIES DESIGNED FOR GREASE LUBRICATION
 - ROLL IS EQUIPPED WITH FLOODING AND FOG SHOWERS
 - SHELL MATERIAL IS BRONZE 1N
 - SUCTION BOX IS PAINTED CARBON STEEL.
 - GRIND CROWN: 0.063 FOR 300 PLI

Serial No. SR-366

1	3/29/2006	BKO	RELEASE FOR PRODUCTION	KLS
B	2/22/2006	BKO	RELEASE FOR APPROVAL	KLS
A	11/21/05	PkS	RELEASED FOR APPROVAL	KLS

DESCRIPTION: SUCTION DRUM ROLL #6 FM

CUSTOMER: Smurfit-Stone Container Corp.

CUST. ORD. NO.: _____ **ITEM NO.:** 80-34-15385-001

CUST. REF. DWG.: _____

R-V Industries Inc.
584 POPLAR RD.
HONEY BROOK, PA 19344
610-273-2457
FAX 610-273-2438

DRAWN BY: PkS **CHK BY:** KLS **DWG. NO.:** D-34-0G-15385 **SCALE:** 1:6 **DATE:** 11/21/2005

SECTION THRU ROLL
SECTION B-B
(1) UNIT REQ'D
W.O. # 12805-01
R-V P/N: 80-34-15385-001

MACHINE TOLERANCES UNLESS OTHERWISE SPECIFIED

X	±1/32
XX	±0.020
XXX	±0.010
XXXX	±0.005

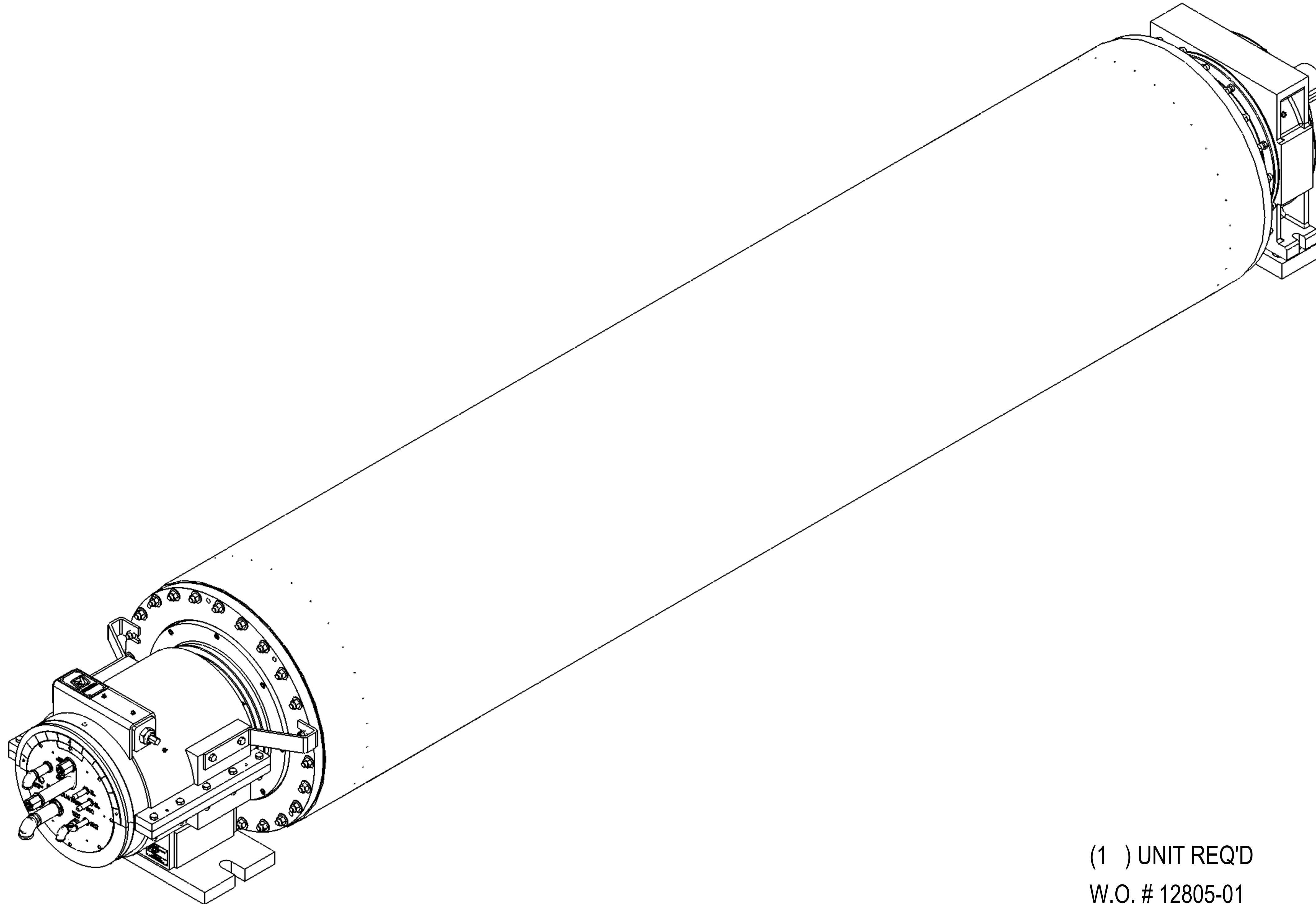
FRACTIONAL DIM ± 1/32
ANGLES ± 30 MIN

FABRICATION TOLERANCES

0' TO 36"	±1/16"
36" TO 120"	±1/8"
> 120"	±3/16"

BREAK ALL SHARP EDGES

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Bill of Material					
Item	Qty	Drawing	Part No	Description	Material
1	1	D-34-15399	803415399001	SUCTION DRUM ROLL SHELL DETAIL	
2	1	D-34-15626	803415626001	FRONT 080K BEARING ASSEMBLY, SERIES 90	
3	1	D-34-08982	803408982001	REAR BRG ASSY (72 BRG)	
4	1	D-34-15613	803415613001	036K INTERNAL BEARING ASSEMBLY	
5	1	D-34-15553	803415553001	SUCTION ROLL FRONT HEAD	
6	1	D-34-15552	803415552001	SUCTION ROLL REAR HEAD	
7	1	D-34-15854	803415854001	SUCTION BOX	
8	1	D-34-15857	803415857001	FRONT TRUNNION, 080K BEARING, SERIES 90	
9	3	D-34-16043	803416043001	SHIM FRONT HEAD	
10	1	D-34-15631	803415631001	END PLATE, SERIES 90 SUCTION ROLL	
11	1	D-34-15632	803415632001	END COVER PLATE, SERIES 90 SUCTION ROLL	
12	1	D-34-16022	803416022001	SUCTION BOX SEAL AREA ASSY	
13	1	D-34-15874	803415874001	MECHANICAL DECKLE ASSEMBLY	
14	1	D-34-16013	803416013001	FLOODING SHOWER ASSEMBLY	
15	1	D-34-15995	803415995001	FOG SHOWER ASSEMBLY	
16	1	B-34-11318	803411318001	PIPING SCHEMATIC - INTERNAL BEARING LUBE	
17	1	B-34-11319	803411319001	PIPING SCHEMATIC - INTERNAL BEARING GREASE RELIEF	
18	1	B-34-09736	803409736001	BALANCE POINT LABEL	
19	10	D-34-16044	803416044001	HAND HOLE COVER	
20	4	D-34-16045	803416045001	SLIDE BLOCK	
21	2	D-34-16046	803416046001	BOLT GUARD ASSY	
22	1	D-34-16047	803416047001	SHIPPING BRACKET	
23	1	D-34-16047	803416047002	SHIPPING BRACKET OPP. HAND	
24	48		251706007304	STUD, 3/4"-10 UNC x 5" LG	SA-193-B7
25	48		254210001001	HVY HEX NUT, 3/4"-10 UNC	SA-194-2H
26	48		255620001002	LOCK WASHER (SPLIT), 3/4"	C/S
27	16		251102002106	SHCS, DRILLED HD, 3/4"-10 UNC x 3" LG	SA-193-B7
28	4		251001035001	HHCS, 3/4"-10 UNC x 1 1/2" LG	C/S GR 5 ZP
29	6		251239001102	BSHMS, 10-24 UNC X 3/8" LG	18-8 S/S
30	20		251018002806	HHCS, DRILLED HEAD, 1/2"-13 UNC x 1" LG	18-8 S/S
31	8		251101007604	SHCS, 3/8"-16 UNC x 1 1/2" LG	18-8 S/S
32	1		203111002104	PIPE PLUG, HEX SOC, 1/8"-500# THRD	BRASS
33	2		251018001606	HHCS, DRILLED HEAD, 1/4"-20 UNC x 1 1/2" LG	18-8 S/S
34	1		102700002309	WIRE, 16 GA (.051" DIA) SAFETY LOCK X 60" LG	302/304 S/S

(1) UNIT REQ'D
W.O. # 12805-01

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R-V P/N: 80-34-15385-001

1	3/29/2006	BKO	RELEASE FOR PRODUCTION	KLS
B	2/22/2006	BKO	RELEASE FOR APPROVAL	KLS

DESCRIPTION: SUCTION DRUM ROLL

CUSTOMER: Smurfit-Stone Container Corp.

CUST. ORD. NO. _____ ITEM NO. _____

CUST. REF. DWG. _____

R-V Industries Inc. 584 POPLAR RD. HONEY BROOK, PA 19344 610-273-2457 FAX 610-273-2438

DRAWN BY: PkS CHK BY: _____ DWG. NO. D-34-06-15385

SCALE: 1:8 DATE: 8/21/2006 REV. 1

MACHINE TOLERANCES (Unless otherwise specified)	
X	+1/32
XX	+0.00
XXX	+0.010
XXXX	+0.05
FRACTIONAL DIM ± 1/32	
ANGLES ± 30 MIN	
FABRICATION TOLERANCES	
0' TO 36"	±1/16"
36" TO 120"	±1/8"
> 120"	±3/16"
BREAK ALL SHARP EDGES	
✓ = 125°	Rough Weight
⊕	Finish Weight