



## PROCESS DESCRIPTION



### 11. WET LAPPING

#### 11.1 Application

The purpose of the wetlap machine is to thicken the deinked stock to about 50% consistency. The thickened stock mat or wetlap is cut and stacked into bales. These bales are weighed, strapped and sent to the warehouse for eventual delivery to the customer. The water pressed out of the stock by the wetlap machine is recirculated back into the process.

#### 11.2 Operation

Stock at about 5% is stored in the Wetlap Feed Chest. An agitator in this chest keeps the fibers in suspension. The Wetlap Supply Pump pumps the stock to the headbox of the Wetlap Double Wire Press. The stock consistency is measured and controlled by adding water to the pump suction. A flow controller regulates the stock flow. The production control system adjusts the flow controller setpoint to maintain the desired production. As the system is running without a repulper it is necessary to maintain a good feed consistency (minimum 3%) to the DWP. This is controlled with a recirculation line back to the feed chest according to the measured consistency.

Stock enters the headbox of the Wetlap Double Wire Press. The inlet pressure is monitored. The DWP presses the stock, displacing the water and creating a stock mat of approximately 50% consistency. A separate hydraulic unit provides high pressure to the last pair of press rolls to attain this high consistency. The stock mat is transferred to the cutter layboy machine. The pressed out water flows under gravity to a two-chamber filtrate pit. The DWP wires are cleaned with oscillating high pressure showers. Position switches provide alarms for improper wire tracking. Pressure switches indicate the wire tension.



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The stock mat from the wetlap DWP is transferred to the Wetlap Cutter Layboy. A level sensor measures the sag at the transfer point and adjusts the speed of the Band Guide Motor to prevent the mat from being torn. The band guide conveys the mat to the rotary knife roll. The knife roll cuts the mat to the proper length. The cut sheet is moved rapidly by the transfer belt to the bale handling system.

The bale handling system consists of several special purpose conveyors. The cut sheets are stacked on the bale lowering conveyor until a full bale height is reached. At this point, the lowering conveyor drops the bale down to the height of the following conveyor, the intermediate conveyor. While the bale is lowered, the cut sheets are temporarily caught on a pair of retractable forks. When the full bale has been moved to the intermediate conveyor, the bale lowering conveyor rises back to the height of the forks. The forks are then retracted and a new bale starts to be stacked.

The intermediate conveyor transfers the bale to the wire strapping conveyor. Wire is wrapped around the bale to keep the bale from shifting during transport. From the wire strapping conveyor, the strapped bale moves to the weighing conveyor. Here, the bale is weighed.

From the weighing conveyor, the bale moves to a holding conveyor. The conveyor is designed for a fork truck to pick up the bale. An inductive loop within the floor prevents the conveyor from moving without the truck present.

### 11.3 Starting Sequence of the Group

Wetlap knife roller, transfer belt and band guide drive ready to start

Hydraulic pump lift ready to start

Lift in upper position

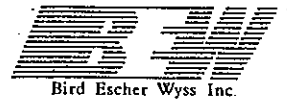
H.P. shower pump ready to start

Warm water pump ready to start

Wetlap DWP drives 1 and 2 ready to start

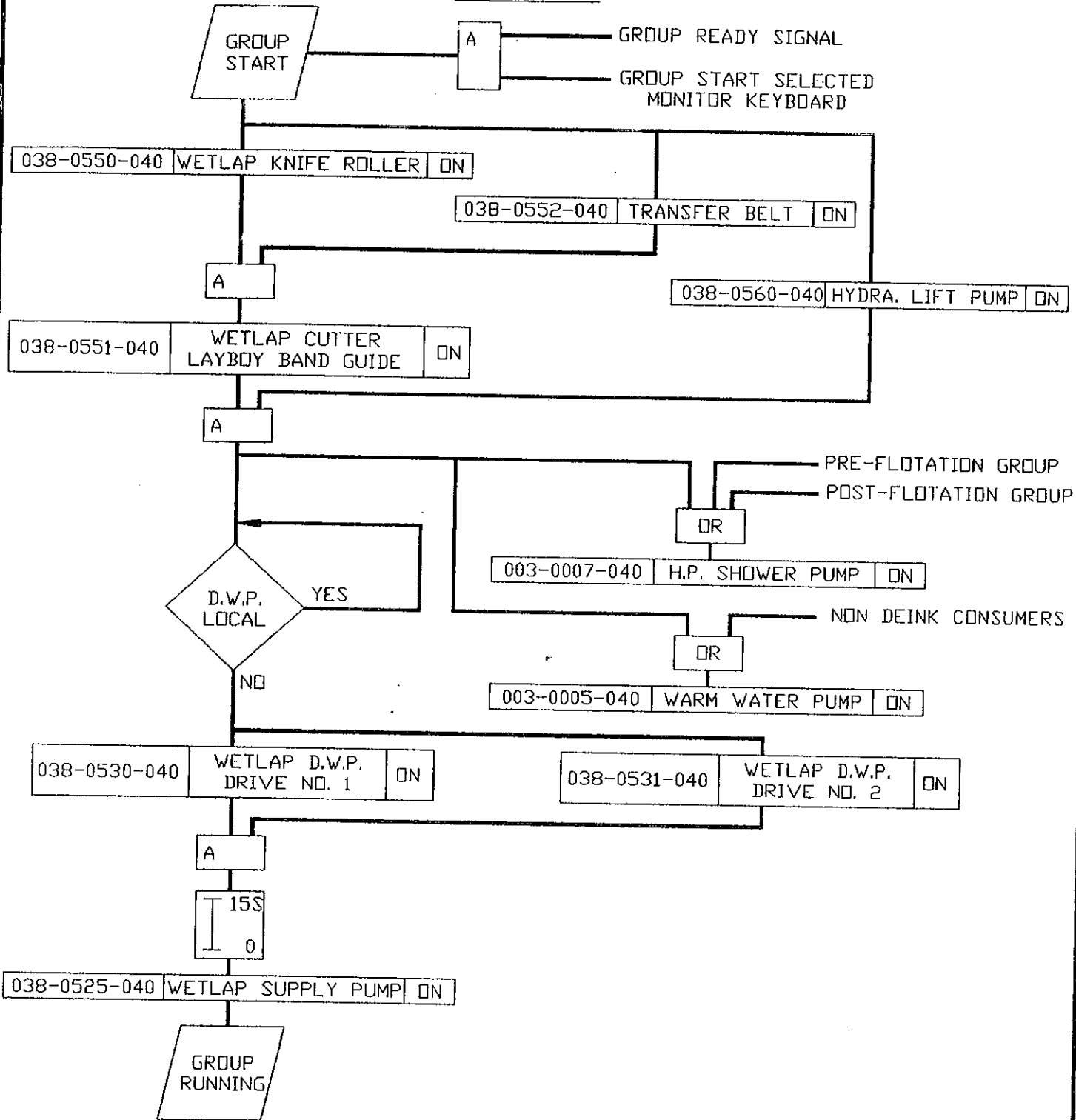



## PROCESS DESCRIPTION



DWP manual/auto selector in auto mode  
Wetlap supply pump ready to start  
Find attached start/stop diagrams.

WETLAP SYSTEM  
GROUP START



1/29/93	CERTIFIED	AC	0	 BURROWS PAPER CORPORATION LITTLE FALLS, NEW YORK
12/21/92	PRELIMINARY	AC	A	
DATE	REVISION	NAME	REV	
SCALE : NONE	TITLE: WETLAP SYSTEM START/STOP DIAGRAM			CLIENT DWG NO. 500-464
SHEET 1 OF 1				BEW DWG NO. TP11-917-00560
DRAWN BY AC	CHECKED KC	DATE 12/17/92	BIRD ESCHER WYSS INC. MANSFIELD, MA	

- CAD DRAWING -

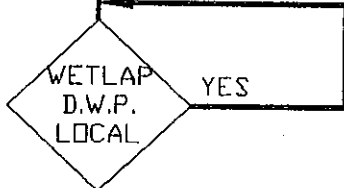
WETLAP SYSTEM  
GROUP STOP

GROUP  
STOP

038-0500-040 VARIO NO. 2 STOCK PUMP OFF

038-0525-040 WETLAP SUPPLY PUMP OFF

60S  
0



038-0530-040 WETLAP D.W.P. DRIVE NO. 1 OFF

038-0531-040 WETLAP D.W.P. DRIVE NO. 2 OFF


A

038-0535-040 WETLAP FILTRATE PUMP NO. 1 OFF

038-0545-040 WETLAP FILTRATE PUMP NO. 2 OFF

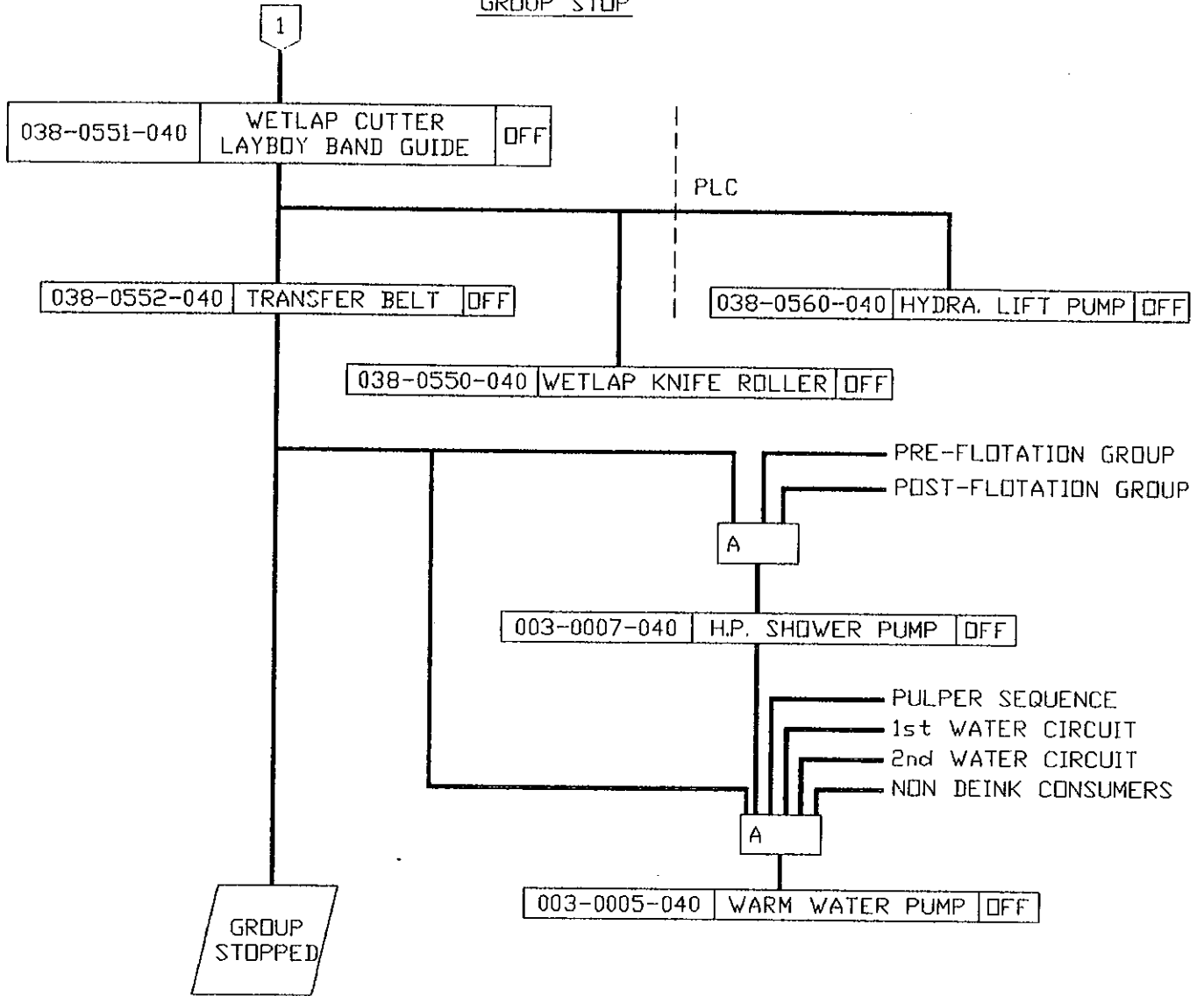
5S  
0


1

2/17/93	CERTIFIED	AC	1	 BURROWS PAPER CORPORATION LITTLE FALLS, NEW YORK
1/29/93	CERTIFIED	AC	0	
12/21/92	PRELIMINARY	AC	A	
DATE	REVISION	NAME	REV	CLIENT DWG NO. 500-465
SCALE : NONE	TITLE: WETLAP SYSTEM START/STOP DIAGRAM			BEW DWG NO. TPI1-917-00570
SHEET 1 OF 2				BIRD ESCHER WYSS INC. MANSFIELD, MA
DRAWN BY AC	CHECKED KC	DATE 12/17/92		

- CAD DRAWING -

WETLAP SYSTEM  
GROUP STOP



					BURROWS PAPER CORPORATION LITTLE FALLS, NEW YORK
2/17/93	CERTIFIED	AC	1		
DATE	REVISION	NAME	REV	CLIENT DWG NO. 500-465	
SCALE : NONE	TITLE: WETLAP SYSTEM START/STOP DIAGRAM			BEW DWG NO. TPI1-917-00570	
SHEET 2 OF 2				BIRD ESCHER WYSS INC. MANSFIELD, MA	
DRAWN BY AC	CHECKED KC	DATE 2/17/93			

- CAD DRAWING -

