

## 7. ContiRoll Press

Item	Qty	Description	Make	Equip #
220	1	<b>ContiRoll MDF Press</b>		4520
		overall length of 35.4 meters (approx 117') x 10 ft width with 100 mm press clearance, design production speed range of 50 mm/s min to 1000 mm/s max. Powered by 760 kW installed power utilizing thermal oil heating medium. Complete press installation includes:	Siempelkamp Generation 9	
		steel belt reeling and sandwich draw devices,		
		press cylinder dismounting device		
		hot platen transport lifting device		
		full set of special press tools by SKR & safety fence		
		overhead vapor hood		
		plus steel support structure and access platforms		
	1	<b>ContiRoll Hydraulic System</b>		4540
		operating pressure of 315 bar with installed power of 208 kW		
		system complete with nitrogen for pressure vessels, noise protection, associated air duct and piping, and support		
	1	<b>Press Fume Exhaust System</b>		4550
		wet cleaning system utilized for exhaust and cleaning of press fumes.		
		Total air volume of 120,000 m3/h with 30-70 degree C air temp with approx 400 kw/4160 v radial fan with stainless housing,		
		compensators at suction and exhaust side,		
		drop separator or wet electrostatic precipitator,		
		water spraying nozzles & cleaning unit,		
		water pump circuit with tanks & drum screen		
		associate piping, electronics and support structure		
	1	<b>Steel Belt Cleaning System</b>		4571, 4572
		consisting of (1) belt cleaner for removal of glue coated material from belt, and (2) release agent application devices to reduce isocyanate glue buildup		
	1	<b>Steel Belt Repair Welding System</b>		4592
		for repair of steel press belts with argon gas bottles and fittings, water supply and collection bin for impurities		
	1	<b>ContiRoll Atomizing Extinguishing System</b>		4592
		fire detection and extinguishing system for press cool down under ignition temp.		
		system complete system with:		
		extinguishing unit for 6 sections		
		frost protection and water supply		
		booster pump and supporting pipework		
		safety fences to the manifold with lockable door		
	1	<b>Secondary Thermal Heating Syst.</b>		4720
		designed for thermal energy distribution and press temp control of 280 degree C primary supply temperature, and 1.0 - 1.2 bar difference pressure at 345 m3/h oil flow.	Siempelkamp	
		Consists of		
		5 heating circuits for hot press platens and return pump/piping,		
		leal oil pipes and collecting recipient with level switch,		
		plus thermal insulation, + fire detection and extinguishing system in pump room		
221		Contiroll Press Control Panels consisting of		

## 7. ContiRoll Press

		4500MC01 ContiRoll MCC panels, 4500MC12 ContiRoll servo drives, 4700MC01 press secondary heating, 4550MC01 press fumes exhaust cleaning (located in Electrical Rm SR-04)		
<b>222</b>	<b>2</b>	<b>Roller Conveyors</b>		<b>5211</b>
		(1) intermediate segment between press and trim saw	Siemplekamp	
		4100 mm length,		
		3400 mm width		
		removable chain driven rollers,		
		pinch roller unit, and		<b>5217</b>
		(1) longitudinal accelerating segment for single or bulk boards	Siemplekamp	
		5475 mm length, 3400 mm width,		
		pinch roller unit at infeed, plus support frame		
<b>223</b>	<b>2</b>	<b>Diagonal Saw Units</b>	Siemplekamp	
		cross-cutting to pre-selected board length		
		passline height of approx 1400 mm,		
		installed power of 37 kW, with		
		(2) 7.5 kW saw power motors		
		double saw carriages & cross cutting units		
<b>224</b>	<b>1</b>	<b>MD Saw &amp; Reject Area MCC</b>		
		#5200MC01 (located in Electrical Rm SR-04)		
		<b>Press Oil Heating Plant</b>		
		<i>Refer to Production Support Equipment (starting with item 300)</i>		
<b>230</b>	<b>1</b>	<b>Online X-ray Density Profilometer</b>	Siemplekamp	<b>5205</b>
		on-line board density profile measurement consisting of :		
		120 kV x-ray tube		
		signal measurement device		
		supporting radiogenic & detection/emission unit		
		plus motorized sideway system adjustment		
<b>231</b>	<b>1</b>	<b>Edge-Trimming Saw Station</b>	Siemplekamp	<b>5212</b>
		continuous edge trimmer of continuous board		
		passline height of approx 1400 mm,		
		installed power of 61 kW, with		
		(2) adjustable trimming units at infeed/outfeed		
		height & width adjustment on both units		
		pneumatic saw spindle tool carrier with tensioning device		
		quick change tool carrier and pneumatic spindle motor units		
		wear and heat resistant supporting table		
		maintenance free circular and flat guide		
<b>232</b>	<b>1</b>	<b>Board Thickness Gauge</b>	Siemplekamp	<b>5218, 5219</b>
		track by track thickness measurement with heads		
		includes delamination detector (5219) for ultrasonic measuring for board blister detection (shared support frame for both measurement devices)		
<b>233</b>	<b>1</b>	<b>Flat Belt Transfer Conveyor</b>	Siemplekamp	<b>5221</b>
		conveys board over weigh cells.		

## 7. ContiRoll Press

		7900 mm length, 3200 mm width		
		installed power of 4 kW with		
		tensioning station, heat resistant belt with spherical drum drive shafts		
<b>234</b>	<b>1</b>	<b>Board Weigh Scale</b>		<b>5222</b>
		board weigh measurement during conveying over load cells with 4000 kg measurement		
<b>235</b>	<b>1</b>	<b>Reject &amp; Pack Forming Station</b>		<b>5224.1, 5224.2</b>
		feeds board rejects to hog breaker. Measures 13,150 mm length, 3400 mm width, with pneu actuated pinch rollers. Includes Reject Board Handling Unit 5224.2 which reduces boards into 200 x 200 mm pieces. Power for handling unit is 200 kW/4160 v motor		
<b>236</b>	<b>1</b>	<b>Trough Chain Discharge Conveyor</b>		<b>5228</b>
		18 meter length,		
		1000 mm width		
		0/45 degree inclination:		
		installed power of 15 kW		
		with chain tensioner, guides and carrier elements		
<b>237</b>	<b>1</b>	<b>Dosing Bin with Screw Dischage</b>	Siempelkamp	<b>1955</b>
		4000 mm bin length		
		2000 mm bin width		
		3760 mm bin height with		
		(2) 4 kW gear motor drives		
		twin screw auger conveyor measuring 6000 mm in length and 400 mm dia		
<b>238</b>	<b>1</b>	<b>HAMMER MILL</b>	Pallmann	<b>1960</b>
		handles large pieces of wood/MDF waste, design rates of		
		3000 eff kg/h gravimetric throughput		
		30 m3/h volumetric troughput		
		1000 mm rotor diameter		
		800 mm infeed height		
		700 mm, infeed width		
		75 kW motor		
		includes material infeed and screen inserts		
<b>239</b>	<b>1</b>	<b>Rotary Board Cooling Station</b>	Siemplekamp	<b>5250.1, 5250.2</b>
		consists of (2) independent rotary cooler segments, the first revolving in a clockwise rotation, the second revolving in a counter clockwise rotation with an effective 180 degree board turn with (64) reel board pockets. Lateral cross pushers against cooler core avoid edge damage. Infeed conveyor segment consist of (4) roller conveyors of 7150 mm x 3400 mm wide, and (1) discharge conveyor measuring 8600 mm in length x 3500 mm wide. Both infeed and discharge conveyors have tensioning devices		
<b>240</b>	<b>1</b>	<b>Board Book Forming Station</b>	Siemplekamp	<b>5270.2</b>
		combines individual boards into 150 mm high segments or books, with pnue actuated allignment and motorized adjustable longitundal devices, prior to stacking		
<b>241</b>	<b>1</b>	<b>Stacking Carriage Gripper</b>	Siemplekamp	<b>5270.3</b>
		picks-up of "book bundles" to stack them into piles		
		tavel distance of approx 16000 mm with lift cap of 2300 kg		
		suction design of single cups and vacuum assist for operation		

7. ContiRoll Press

		carriage travel arrest at stopping position,		
		pne cylinders on all sides for proper positioning of boards	Siemplekamp	
<b>242</b>	<b>1</b>	<b>Base Carriage for Board Storage</b>	Siemplekamp	<b>5301.1</b>
		cross transport of two stack carriers (satellites)		
		total installed power of 5.6 kW		
		60 m/min transport feed		
		45,000 kg net carrying capacity		
		low-bed load supporting platform , with 2 pair of runwail rails for the stack carriers & 3 stack supporting beams, with protective contact device at both sides of the carriage		
<b>243</b>	<b>1</b>	<b>Aisle Equipment</b>	Siemplekamp	<b>5302</b>
		driving and guiding rails for X and Y travel,consisting of limit buffers and trip cams for the travel distances and the guiding ends, and positioning systems , laser distance control and direct scanning of the stacks		
<b>244</b>	<b>1</b>	<b>Cooling &amp; Stacking PLC Control Panels</b>		
		5200PLC01 & 02		
		located in Electrical Rm SR-04		