

**Paper Company XYZ – Maintenance Department
No.2 Paper Mill
Control Document – Roll Rebuild**

Roll Name: PM2 Main Press Suction Roll

24 April 2010

Roll Serial Number: Shell # 891006, Box #234

Work Order Number: 399902-5

Team No. 2

Pertinent Roll History: Roll in service from May13/09 to Jan.8/10 (7 months), and removed due to **plugged shell at DS of center** (external shower oscillation was not functioning). A new FAG suction box bearing was installed on June 6/03. A new SKF bearing was installed on TS end on Sept.27/98, and a new FAG bearing was installed on DS end on March 25/01. **Shell suction holes have pitting corrosion and rough bores, making the shell susceptible to plugging, and the shell ID has severe pitting which increases wear on the seal strips. Micro-cracking was previously found in shell ID at the end-deckle locations. Shell material is KCR-A682 with 0.76 x life-cycles as of Jan.8/10. Only 1 year max. run time left on cover life as of Jan.8/10** (recommendation by ACME Recovering Co.).

Rebuild Task	Completion Date	Notes
1. Lower fully assembled roll to cleaning bay.	10/01/10	Digital pictures taken of plugged shell area on 09/01/10.
2. Clean TS & DS heads and housings very well, and preliminary cleaning of shell.	10/01/10	
3. Match-mark TS head and remove suction box from shell.	11/01/10	
4. Verify running condition of bearings during service.	10/01/10	No bearing defects detected while in service.
5. Check sump oil in TS & DS housings for water and debris contamination.	11/01/10	
6. Match-mark DS head, and remove head complete with bearing, housing and coupling still assembled.	14/01/10	
7. Inspect condition of paint on all external parts.	10/01/10	Housings and heads were painted with 2-part epoxy paint on 15/10/08, and still in good condition.
8. Inspect for shell pluggage from inside shell.	14/01/10	Roll internals were very clean. Plugged patch appears to have been caused by wet stock deposits on OD during felting change?
9. Inspect the internal flooding shower for plugged nozzles. All new nozzles were installed on flooding shower on 12/01/07.	14/01/10	Nozzle #44 @ DS of center was partially plugged, and nozzle #83 at DS end was completely