

NEW TECHNIQUES—DRYING/COOLING FOR PAPERBOARD APPLICATIONS

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ABSTRACT

The purpose of this paper is to introduce some new areas in which flotation technology is being incorporated into production lines to specifically address web handling and drying problems. Topics include the following:

- Web cooling
- Differential air temperatures for curl control
- Air turns for non-contact turning

INTRODUCTION

Today's manufacturers of coated paperboard and paper face an ever increasing requirement for the production of sophisticated functional products. The move towards higher value added products and the recent trend towards "on-machine" coating operations has in turn brought with it a requirement for advanced drying/cooling configurations and contactless web handling systems.

Advances in these areas have brought forth a myriad of new machine configurations not thought possible with older generation equipment. These possibilities are still emerging and some new layouts have emerged as a direct result of the new technology.

Today's competitive global market requires a re-thinking of traditional operational practices. What we did yesterday may not be applicable for today's requirements. New technology and refinements of existing technology should not be overlooked when considering modifications to existing operations. Many times the new technology being offered can give a marginal operation a competitive edge in the marketplace.

It is important to realize that when the respective drying and web handling equipment are brought together in the tight space configurations prevalent in existing machine configurations, new and innovative layouts need to be considered.

Key words: web cooling, curl control, high performance flotation drying, combined gas IR and air flotation.

Web Cooling

Web cooling is not commonly discussed due to the wide familiarity of the need to cool the web prior to downstream operations. Typically, cooling is done by either leaving an open draw between operations or in some cases, traditional chill roll arrangements are employed where practical. As machine speeds increase and space becomes even more of a problem, mills have had to look to alternative technology to handle the cooling requirements.

Cooling webs to temperatures below 130°F (55°C) prevents operational problems from developing on calendar stacks and provides a suitable temperature to rewind without the typical problems normally associated with high sheet temperatures. It is typical to find sheet temperatures hovering in the area of 160 to 180°F (70 to 80°C) in the "dry end" of a paperboard machine. A cooling operation needs to efficiently and economically lower the web temperature some 30 to 50°F (0 to 10°C) without damaging the coated surface and within the minimum space possible. This is especially true for board applications where the weight of the board makes an excellent "heat sink" and is more difficult to cool.

The development of air flotation drying technology provides non-contact web handling while offering the enhanced benefit of two sided drying. A diagram of a typical flotation dryer is shown in Fig 1. This same arrangement can be used to effectively cool a web by using ambient or chilled air instead of heated air.

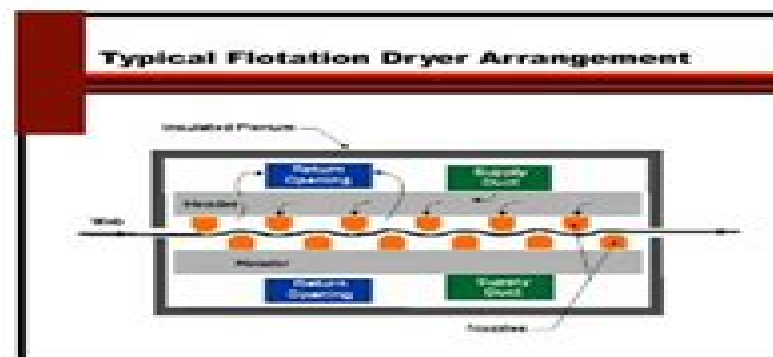


Fig. 1

The operation of a flotation cooler is quite simple. An air supply system delivers ambient air to the nozzles or air bars above and below the web. Arranged in a staggered

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