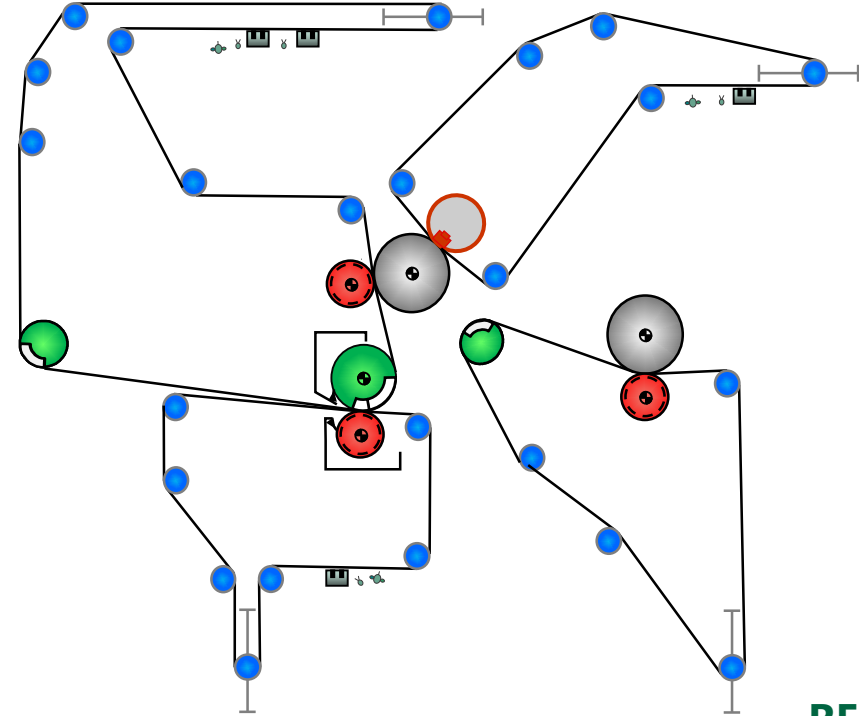


## 3<sup>rd</sup> Press Felt / Shoe Press

REGION:	Northeast	
MACHINE:	PM# XX	
POSITION:	3 <sup>rd</sup> Press Shoe	
GRADE:	Coated Free Sheet	
BASIS WEIGHT:	40-80#/3300	(48-115 gsm)
SPEED:	3800 fpm	(1150 mpm)
LOAD:	5000 PLI	



### OBJECTIVES:

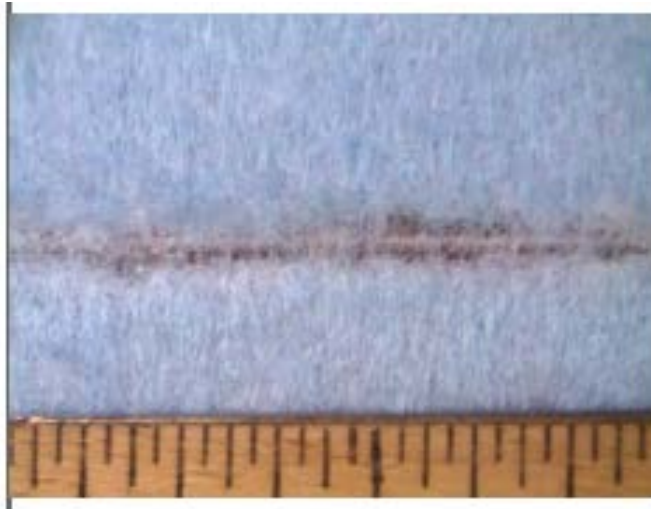
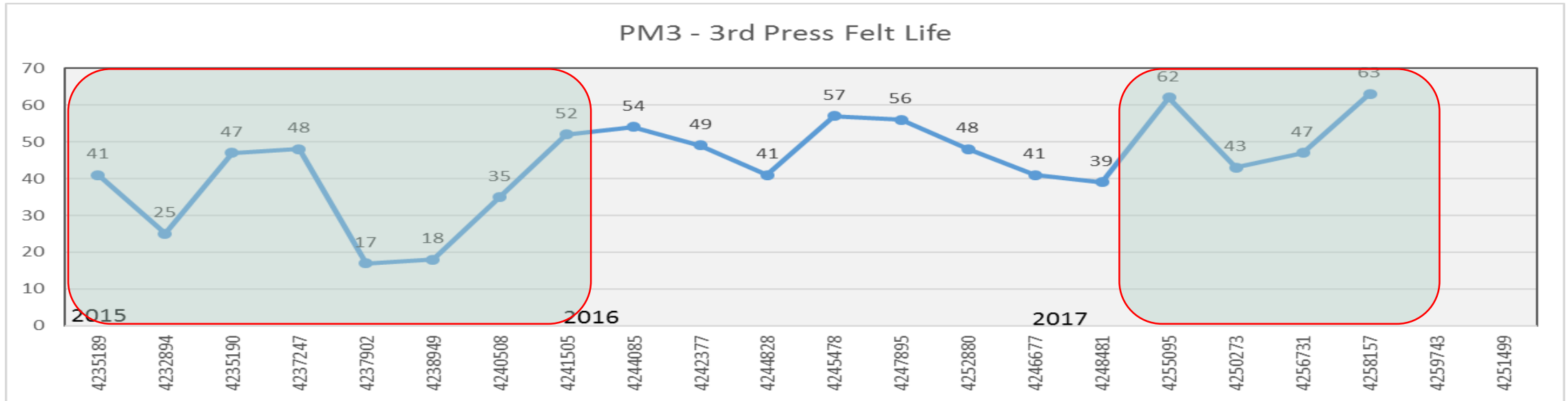
Improve PM runnability and increase felt life with the FlexFlow 2S

### ISSUES:

- Shoe press in the 3<sup>rd</sup> requires a high degree of seam quality, uniformity and durability.
- PM experiencing loss in productivity due to blunt nose seam breaks coming from the 3<sup>rd</sup> press felt.
- Seam was very loud going across the uhle box.
- Returned felt analysis of the 3<sup>rd</sup> press felt showing heavy wear to the seam flap and increasing overall weight loss.
- Struggling to get to a 56 day run cycle.

### RESULTS:

- Continued optimization of the FlexFlow 2 improved felt life from the 35-42 day range to the 56-63 day range!
- Blunt nose breaks due to the seam have been eliminated.
- Body of felt and Seam look very good when they come off at 63 days!



Seam at 47 days in 2015

- Smaller loop and more robust seam zone stuffer system with the FlexFlow 2
- Optimized needling and batt distribution



Seam at 63 days in 2017!!