



Building Leadership Excellence



Improving and Maintaining High Papermachine Efficiency

Grant Forrest

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RETHINK PAPER:
Lean and Green

Background Information

- 20 years in the Pulp and Paper Industry
- 2 paper machines producing a total of 1005 TPD uncoated freesheet.
- J1 machine is a smaller specialty machine. Operating speed range is 1800 fpm – 2600 fpm. 182” reel, 220tpd.
- J1 basis weight ranges from 26# to 70# (per 3300ft²)
 - Tradebook, Light weight financials, Offset/Opaque, filmcote
- J5 machine has a Metso Symformer MB with SSP. Operating speed range is 3200 – 4100 fpm. 238” reel, 785 tpd
- J5 basis weight ranges from 40# to 70# (per 3300ft²)
 - Produces Copy, Offset/Opaque, Envelope, Forms



Keys to Success

- Some “Givens”
 - Operator checklists
 - Shift maintenance checklists/rounds
 - Vibration Analysis/Oil Analysis/Infrared Survey's/Motor Hi-Pot testing
 - Routine PM's
- Need a grade formula center-lining tool – may be home grown or a purchased application like QIS
 - Develop documented grade change procedures for grade changes
 - Agreement with machine scheduling for grade sequencing plan
 - Minimum run length guidelines (or requirements)
- Honor the machine planned maintenance schedule
 - Be formal about the planning and execution of PMO's



Keys to Success

- Track sources of loss
 - Figures don't lie but liars figure
 - Ensure source of loss is properly coded considering root cause
 - Mtce reliability time vs operational time
 - Operations breaks vs operations other
 - Grade Change Losses
 - Other cull reasons
- Benchmark against relevant internal and external competition
 - To establish or validate realistic targets
- Work to eliminate sources of loss – use a formalized process to systematically work through and resolve sources of loss

