



(22) Date de dépôt/Filing Date: 2003/01/31

(41) Mise à la disp. pub./Open to Public Insp.: 2003/08/25

(45) Date de délivrance/Issue Date: 2010/03/23

(30) Priorité/Priority: 2002/02/25 (FI20025007)

(51) Cl.Int./Int.Cl. *B65H 23/022* (2006.01),
D21G 9/00 (2006.01)

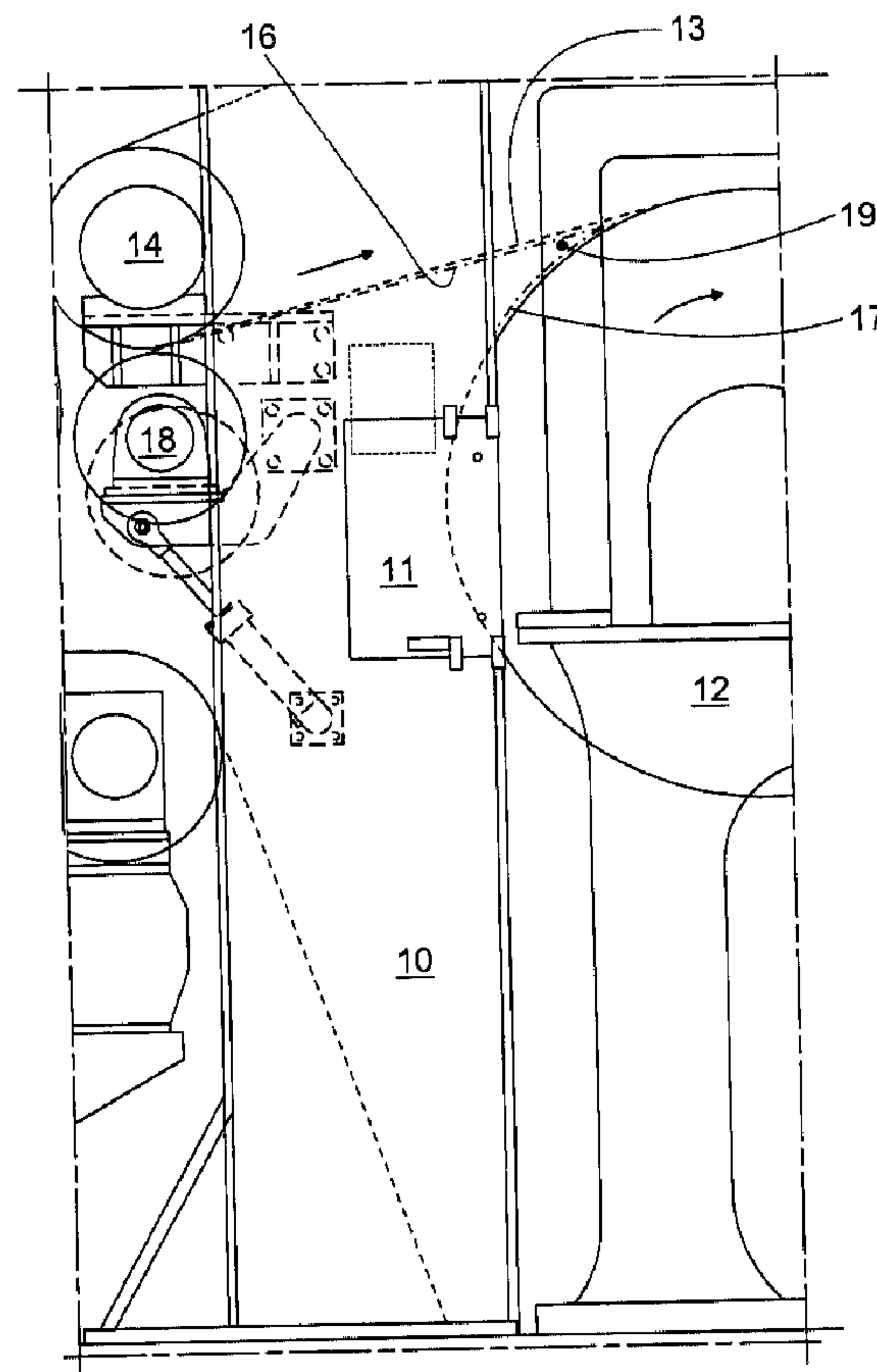
(72) Inventeur/Inventor:
SALMELA, JUHA, FI

(73) Propriétaire/Owner:
METSO PAPER, INC., FI

(74) Agent: GOWLING LAFLEUR HENDERSON LLP

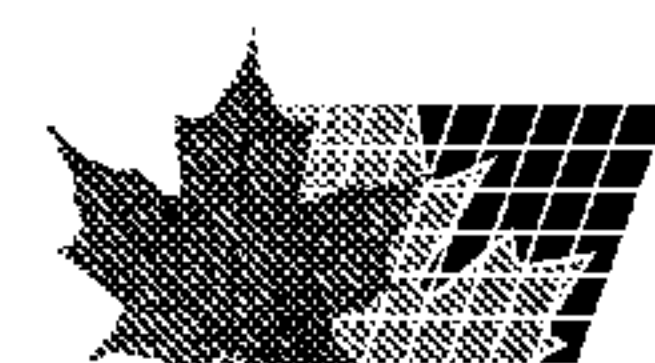
(54) Titre : METHODE ET DISPOSITIF POUR GUIDER L'ENGAGEMENT DE LA BANDE, EN PARTICULIER DANS UNE
MACHINE A PAPIER

(54) Title: METHOD AND DEVICE IN LEADING A WEB THREADING TAIL PARTICULARLY IN A PAPER MACHINE



(57) Abrégé/Abstract:

The invention relates to a method in leading a web threading tail particularly in a paper machine. In the method a device is used, which is moved close to the fabric (13) transporting the web threading tail (15) and by means of which the web threading tail (15) is



(57) **Abrégé(suite)/Abstract(continued):**

detached from the surface of the fabric (13). The web threading tail (15) is transferred laterally relative to its direction of travel to the following web threading device (16, 17, 19), after which the device is moved away from the vicinity of the web threading tail (15). The transfer of the web threading tail (15) in the cross direction of the paper machine takes place mechanically by pushing. The invention also related to a corresponding device.

(57) ABSTRACT

The invention relates to a method in leading a web threading tail particularly in a paper machine. In the method a device is used, which is moved close to the fabric (13) transporting the web threading tail (15) and by means of which the web threading tail (15) is detached from the surface of the fabric (13). The web threading tail (15) is transferred laterally relative to its direction of travel to the following web threading device (16, 17, 19), after which the device is moved away from the vicinity of the web threading tail (15). The transfer of the web threading tail (15) in the cross direction of the paper machine takes place mechanically by pushing. The invention also related to a corresponding device.

METHOD AND DEVICE IN LEADING A WEB THREADING TAIL PARTICULARLY IN A PAPER MACHINE

The present invention relates to a method in leading a web
5 threading tail particularly in a paper machine, in which method
a device arranged attached to the frame structure of the paper
machine is used, which device is moved close to the fabric
transporting the web threading tail and by means of which the
web threading tail is detached from the surface of the fabric
10 and transferred laterally relative to the direction of travel
of the web threading tail to the following web threading
device, after which the device is moved away from the vicinity
of the web threading tail. The invention also relates to a
corresponding device.

15

The construction depicted in the introduced is very common,
particularly in paper machines, especially between the press
section and the drying section of the paper machine. In this
position, it is usual to lead the web threading tail in a
20 specific way. In practice, in the beginning of the tail
threading, the web threading tail is led in a known way from
the press section on the surface of the fabric to the first
drying cylinder and from there down to a pulper. Once the
movement of the web threading tail has settled, the web
25 threading tail is transferred in the cross direction of the
paper machine to the web threading device of the drying
section, which takes the web threading tail through the drying
section. The two-stage operation is used in an attempt to avoid
web breaks in the press section caused by tail threading, in
30 which press section the tail threading is labourious.

At its simplest, an operator detaches the web threading tail
from the surface of the fabric and transfers it laterally by
hand, so that the web threading tail, which is moving forward
35 the whole time, travels on to the next web threading device.

Generally, the web threading device in question is a totality formed of ropeways, with the web threading tail being transferred to the rope throat that this forms. Usually, at least one ropeway is between the fabric and the operator, so that the operator's hand is always in danger of striking the rope of the ropeway. The situation is further aggravated by the cramped space and poor visibility. Additional major safety risks are the large rotating machine parts, the rapidly moving fabric, and especially the ropeways.

10

In order to avoid manual transfer, devices have been developed that would allow the web threading tail to be transferred laterally. One such device is disclosed in US patent number 4542160, in which two blower elements are used in combination. An improvement of the said device is disclosed in US patent number 4784443. In both applications, the first blower element is used to detach the web threading tail from the surface of the fabric. Similarly, the second blower element is used to create a blast essentially in the cross direction of the paper machine, and which is used to move the web threading tail laterally. However, the blower elements are at least partly in the area of travel of the web and are thus liable to be broken. In addition, they collect loose material on top of themselves. Further, the blasts are also difficult to control and their operation is otherwise imprecise. In other words, the use of blasts to transfer the web threading tail is imprecise and uncertain. In addition, the blasts are only suitable for pulp webs with a low grammage.

30 The invention is intended to create a new type of method for leading a web threading tail particularly in a paper machine, by means of which the leading of the web threading tail will be more certain and simpler than before. The invention is also intended to create a new type of device for corresponding use, which has a durable construction and which is easy to apply and adjust. The characteristic features of the method according to

35

the invention appear in the accompanying Claim 1. Correspondingly, the characteristic features of the device according to the invention appear in the accompanying Claim 6. In the method according to the invention, the transfer of the web threading
5 tail is arranged to take place in stages and in a straight line. The method is thus easy to implement and repeat. In addition, the transfer of the web threading tail is controlled, which considerably reduces the risk of failure. The device according to the invention is suitable for use with all kinds
10 of web threading tails. During the transfer, the web threading tail is continuously precisely controlled, which does not, however interfere with the movement of the web threading tail. In addition, the device can be located even in a cramped position and can be simply moved away from the vicinity of the
15 web threading devices and fabric after tail threading. It is also simple to adjust the device precisely to the desired position while retaining its settings, irrespective of use or operating conditions.

20 In the following, the invention is examined in detail with reference to the accompanying drawings showing some applications of the invention, in which

Figure 1 shows the location of the device according to the
25 invention, seen from the front side of the paper machine,

Figure 2 shows the device according to the invention in the rest position, seen facing the machine direction,

Figure 3 shows the device of Figure 2 in the operating position,
30

Figure 4 shows a sequence diagram of the device according to the invention,

Figure 5 shows the device of Figure 3, seen from the front side,

35 Figure 6 shows the support arm of the frame structure of the device of Figure 5.

Figure 1 shows the device according to the invention installed in a paper machine. Thanks to its versatility and efficiency, the device can also be installed in board machines and other similar machines. In this case, the device is in a position
5 between the press section and the drying section of the paper machine. The device is attached to the frame beam 10 of the paper machine, i.e. to the inside of the paper machine. The location of the device is shown by the rectangle drawn with a broken line in Figure 1. The construction of the device is
10 dealt with in greater detail in connection with the other figures. The control case 11 of the device is correspondingly on the other side of the frame beam 10.

The drying section's first dryer cylinder 12, the fabric 13
15 running over the upper surface of which is shown by a broken line, is partly visible at the right-hand edge of Figure 1. The fabric 13, which in practice is usually a drying wire, is guided onto the drying cylinder 12 with the aid of a lead roll 14. In the position shown, the lead roll 14 is the drying
20 section roll that is closest to the press section. When web threading is commenced, the web threading tail is guided from the press section to the lead roll to the under surface of the drying wire in a manner that is, as such, known. The web threading tail travels with the drying wire to the first dryer
25 cylinder, from which the web threading tail is run down, for example, to a pulper (not shown). Once the movement of the web threading tail has settled, the web threading tail is moved in the cross-machine direction of the paper machine, i.e. in this case towards the front side. The lateral transfer is used to
30 lead the web threading tail to the next web threading device.

In the position shown, the first web threading device of the drying section comprises two ropeways 16 and 17, which form a rope throat 19 to the first dryer cylinder 12. The ropeways
35 shown and the other ropeways related to them then carry the web threading tail through the entire drying section. The first

ropeway 16 is guided through the lead roll 14 to the dryer cylinder 12. Correspondingly, the second ropeway 17 runs through the dryer cylinder 12. The construction and operation of the ropeways are, as such, conventional, so that they are not depicted here in greater detail. In addition, against the lead roll 14 there is an auxiliary roll 18, at least the front-side end of which is lowered during web threading away from the lead roll 14. This is shown by a broken line in Figure 1. The rope throat 19 is formed close to the point of contact of the drying wire 13 and the dryer cylinder 12, so that a relatively small lateral transfer (Figure 3) of the web threading tail is required. Besides the web threading device formed by the ropes, it is also possible to use, for example, web threading zones (not shown) formed in the end parts of the rolls or dryer cylinders. The web threading zones are outside the fabric and their operation is usually based on pressure zones.

Thus, in the method, a device is used, which is moved close to the fabric and by means of which the web threading tail is detached from the surface of the fabric. The device and its operation are depicted in greater detail with reference to the figures. The device is also used to move the web threading tail laterally, relative to its direction of travel, to the following web threading device. Finally, the device is moved away from the vicinity of the web threading tail. According to the invention, the transfer of the web threading tail in the cross direction of the paper machine takes place mechanically by pushing. The imprecise and often ineffective blasts of the state of the art are then avoided. In addition, the web threading tail is detached from the surface of the fabric in connection with the pushing. Web threading is then accelerated compared to known methods. At the same time, the stages of the web threading become clear and follow each other, which helps to ensure the success of the web threading. The success of the web threading is also ensured by pushing the web threading tail laterally essentially linearly. This interferes as little as

possible with the travel of the web threading tail, while pushing corresponds to the well-proven method of manual transfer.

5 According to the method, pushing the web threading tail takes place in three stages, a device equipped with a transfer member being used for pushing. In the first stage, the device is moved close to the fabric, after which in the second stage the transfer member is moved close to the fabric. In the third
10 stage, the transfer member is used to push the web threading tail laterally. The stages in question are clear while the actual pushing is rapid and precise. The movement of the transfer member that pushes the web threading tail is preferably arranged to be linear, so that at the same time both the
15 linear pushing of the web threading tail is realized and the construction of the device can be made simple.

The actual device according to the invention is intended to be located in connection with the fabric that transports the web
20 threading tail. According to the method, the device is used to detach the web threading tail from the surface of the fabric and to transfer the web threading tail laterally relative to its direction of travel, to the following web threading device. For this purpose, the device includes a blower device 20 for
25 detaching the web threading tail 15 and a transfer device 21 for transferring the detached web threading tail 15. According to the invention, the transfer device 21 comprises a transfer member 22 that can be moved essentially in the cross direction of the paper machine. In addition, the transfer device is
30 arranged to mechanically push the web threading tail 15 (Figure 3). Thus, the web threading is more certain and faster than before. A blower device 20 is preferably also arranged in the transfer member 22, which will further simplify the construction and operation of the device. The construction of the
35 transfer member is dealt with later in greater detail.

Figure 2 shows the device according to the invention in the rest position, seen facing the machine direction. Figure 3 shows the same device in the operating position. In order to create a natural transfer, the transfer member 22 is arranged
5 on a support arm 23 that moves linearly. In addition, the support arm 23 is supported on the frame construction 10 of the paper machine in a way that allows it to be rotated. The device can thus be turned away from the vicinity of the fabric. At the same time, only sloping surfaces remain in the structure of the
10 device, so that little loose material will collect on top of the device.

In this application, the support of the support arm 23 comprises a frame piece 24, with a pivot pin 25 fitted to it for
15 the support arm 23. From beneath, the frame piece 24 is an open sheet-metal case, which helps to protect the support arm 23 and the rest of the structure of the device. The pivot pin 25 is attached to lugs 26 in the support arm 23, thus permitting the support arm 23 to move relative to the frame piece 24. The
20 device also includes a carrier 27 attached to the frame structure of the paper machine. In addition to this, there are guide members 28 in the frame piece 24, corresponding to the carrier 27, for positioning the support arm 24 in the cross direction of the paper machine. In the embodiment shown, the
25 carrier 27 is a protruding beam of bevelled steel bar, the upper and lower bevels of which support grooved rollers 29 fitted to the frame piece 24. The construction in question is extremely rugged, but also easy to move. In addition, the structure remains very clean, with the guide rollers protected
30 inside the frame piece.

The device is installed at the location planned for it on the frame beam. For fine setting, the baseplate 30 of the carrier 27 can be adjusted vertically (Figure 5). Correspondingly, the
35 carrier 27 itself is arranged to be able to be rotated relative to its centreline, by means of suitable attachments. Once the

settings are correct, the carrier is secured to be immovable during operation. The position of the frame piece, however, can be altered, even during operation. For positioning, a lockable adjustment arm 31 extends from the frame piece 24 to the side 5 of the frame beam 10, from where it can be operated safely. By releasing the adjustment arm, the frame piece and thus the entire support arm can be moved in the cross direction of the paper machine. The transfer member can then be adjusted to the correct position. This embodiment has a potential frame-piece 10 adjustment of about 100 mm.

Set to the correct position, the device is always ready for use, provided the other conditions remain substantially unchanged. All the operations of the device are preferably 15 implemented using compressed air, which is easy and safe to use. In order to be able to turn the support arm from the rest position to the operating position, the device includes a pneumatic cylinder 32, which is attached between the frame piece 24 and the opposite end of the support arm 23. In Figure 20 3, the support arm 23 is shown raised to the operating position.

To achieve the most reliable operation possible, the transfer member is also supported on the support arm in such a way that 25 it can be rotated, which particularly aids the operation of the blower device. Thus the transfer device also has rest and operating positions. In Figure 2, the transfer device 22 is in the rest position, and correspondingly in Figure 3 in the operating position. Figure 2 also shows the adjustment construction 33 of the transfer member 22, by means of which the 30 position of the first arm 35 of the basically V-shaped transfer member 22 can be altered. The angle of the second arm 34 of the transfer member relative to the fabric 13 and the web threading tail 15 can then be adjusted as desired, while the turning 35 movement of the transfer member remains the same. Thus the transfer member can be operated simply using the pneumatic

cylinder 36. The figures do not show the pneumatic hoses or other equipment relating to the control of the device. The same reference numbers are used for components that are operationally similar.

5

According to the invention, a blower device 20 is arranged in the transfer member 22, which simplified the construction of the device and ensures the pushing effect. Figure 2 shows the construction of the blower device 20 in greater detail. In this
10 case, the second arm 34, i.e. that closest to the fabric, of the transfer member 22 is arranged to be hollow, in order to form the blower device 20. In practice, a borehole 37 is machined in the arm 34, to the first end of which a compressed air connection (not shown) is connected. Correspondingly, the
15 other end of the borehole opens at the end of the arm 34 of the transfer member 22, in which there is a suitable nozzle 38 for creating a detaching blast. The nozzle 38 can also be turned relative to the arm 34, so that the direction of the blast can be set as desired. This further assists the detaching of the
20 web threading tail from the surface of the fabric.

To simplify and lighten the construction of the device, the transfer member 22 with the pneumatic cylinder 36 is fitted to an auxiliary frame 39 forming part of the device. In addition,
25 a cylinder 40 without a piston rod, to the slide 41 of which the said auxiliary frame 39 is attached, is used as the operating device of the transfer member 22. This avoids separate guides for the transfer member and at the same time exploits the load-bearing capacity of the cylinder 40 without
30 a piston rod. In addition, the cylinder 40 is well protected inside the support arm 23. Figure 6 shows a simplified view of the location of the cylinder 40 without a piston rod inside the support arm 23. The figure also shows the attachment of the auxiliary frame 39 to the slide 41 and also rubbing, but
35 flexible seals 42, which protect the attachment. One preferred cylinder without a piston rod is the cylinder known under the

product name ORIGA, in which the slide attached to the piston is supported by the frame of the cylinder. The cylinder can then be used directly as a guide.

5 In practice, the transfer member is preferably made of a plastic material, such as PTFE plastic. The friction between the web threading tail and the transfer member will then be the least possible, which will assist the success of the web threading. In addition, the plastic is highly resistant to
10 variations in temperature. To minimize disturbances, the second arm 34 of the transfer device 22 is also given a curved shape (Figure 5), so that the travel of the web threading tail will be disturbed as little as possible. The other structures of the device are preferably made from stainless steel.

15

The following describes the operation of the device, with particular reference to Figures 3 and 4. The device is controlled from a control box at the frame beam 10 or from the dryer group control room. The control commands are electrical
20 and are used to control magnetic valves. If necessary, limit switches, control logic, and indicator lights are used. However, the device is designed in such a way that the consecutive stages can be performed with the aid of simple control and operating elements. Thus, the total device is simple. Generally,
25 ally, when web threading is commenced, the support arm 23 is lowered in the rest position. The start command is then used to make the first cylinder 32 raise the support arm 23 to the upper position. At the end of the work stroke, it is preferable to receive some detectable information that the support arm is
30 in the operating position. It is then possible to commence web threading, if this is otherwise possible.

Next, the continue command is given, when the second cylinder 36 will turn the transfer member 22 from the rest position to
35 the operating position. At the same time, the blower starts and begins to detach the web threading tail 15 from the surface of

the fabric 13. Once the transfer member 22 is in the operating position, the third cylinder 40 begins to move the transfer member 22 towards the front side, i.e. from right to left in Figure 3. At the same time, the web threading tail 15, which has been detached by the blast, nevertheless continues to move in the longitudinal direction (Figure 3) to support the arm 34. The movement of the transfer device 22 continues to the end, unless the reverse command is given. By means of the reverse command, the transfer member 22 returns to the end of the support art 23 and drops to the rest position. At the same time the blowing stops. Without the reverse command, the transfer member 22 will continues its movement to the end, after which detectable information will be given. At this stage, the web threading tail has moved to the sphere of influence of the next web threading device, so that the device has carried out its task. By giving the terminate command, the transfer member 22 moves rapidly to the back side end of the support arm 23 and drops to the rest position. If the web threading fails, the next attempt can be made even immediately after this stage. If the repeat is unnecessary, the support arm 23 is lowered to the rest position. Thus, the stages of the operation of the device can be controlled manually or even pre-programmed. The stages are clear entireties, which can be repeated and implemented as the situation demands. In the example embodiment, the movement of the transfer member 22 is about 350 mm. In Figure 4, the symbols A and B refer to the end positions of the various cylinders 32, 36, and 40. Correspondingly, in connection with the blower device 20, 0 refers to the blast being shut off and 1 to its being opened.

30

The method according to the invention is easy to implement and can be applied in various positions. Correspondingly, the device according to the invention is simple and reliable in operation. The combination of the blower device with the transfer member achieves a very powerful device for transferring a web threading tail laterally. During the mechanical and

35

essentially linear pushing, the web threading tail is all the time controlled by the device, without, however, interfering with the travel of the web threading tail.

CLAIMS

1. A method in leading a web threading tail in a paper machine, in which method a device arranged attached to
5 the frame structure of the paper machine is used, which is moved close to a fabric transporting the web threading tail and by means of which the web threading tail is detached from the surface of the fabric and transferred relative to the direction of travel of the web threading
10 tail to a following web threading device, after which the device is moved away from the vicinity of the web threading tail, wherein the transfer of the web threading tail in the cross direction of the paper machine is made mechanically by pushing.

15

2. The method according to claim 1, wherein the web threading tail is detached from the surface of the fabric in connection with the pushing.

20 3. The method according to claim 1 or claim 2, wherein the web threading tail is pushed laterally essentially linearly.

4. The method according to any one of claims 1 to 3,
25 wherein, in the three-stage pushing, the device is equipped with a transfer member, which device is first moved close to the fabric, after which the transfer member is moved close to the fabric, and the web threading tail is then pushed laterally using the
30 transfer member.

5. The method according to claim 4, wherein the movement of the transfer member pushing the web threading tail is arranged to be linear.

35

6. A device for leading a web threading tail in a paper machine, which device is adapted to be attached to the frame structure of the paper machine, in connection with a fabric transporting the web threading tail and which includes a blower device for detaching the web threading tail from the surface of the fabric and a transfer device for transferring the detached web threading tail laterally relative to the direction of travel of the web threading tail to a following web threading device, wherein the transfer device is formed as transfer member to be moved substantially in the cross direction of the paper machine, and which is adapted to mechanically push the web threading tail and in which the blower device is attached.

15

7. The device according to claim 6, wherein the transfer device is arranged on a linearly moveable support arm, which is supported rotatably on the frame structure of the paper machine.

20

8. The device according to claim 7, wherein the support of the support arm comprises a frame piece with a pivot pin fitted to it for the support arm and a carrier to be attached to the frame structure of the paper machine, the corresponding guide members of which carrier are attached to a frame piece for adjusting the support arm in the cross direction of the paper machine.

9. The device according to any one of claims 6 to 8, wherein the transfer member is supported rotatably on an auxiliary frame belonging to the device, and which auxiliary frame is attached to a slide of a cylinder without a piston rod that is used as the operating

30

element of the transfer device in order to create a pushing movement.

10. The device according to any one of claims 6 to 9,
5 wherein the basic shape of the transfer member is that of a V, the arm of which located closest to the fabric is arranged to be hollow in order to form the blower device, the transfer member being of a plastic material.

10 11. The device of claim 10, wherein the plastic material is PTFE plastic.

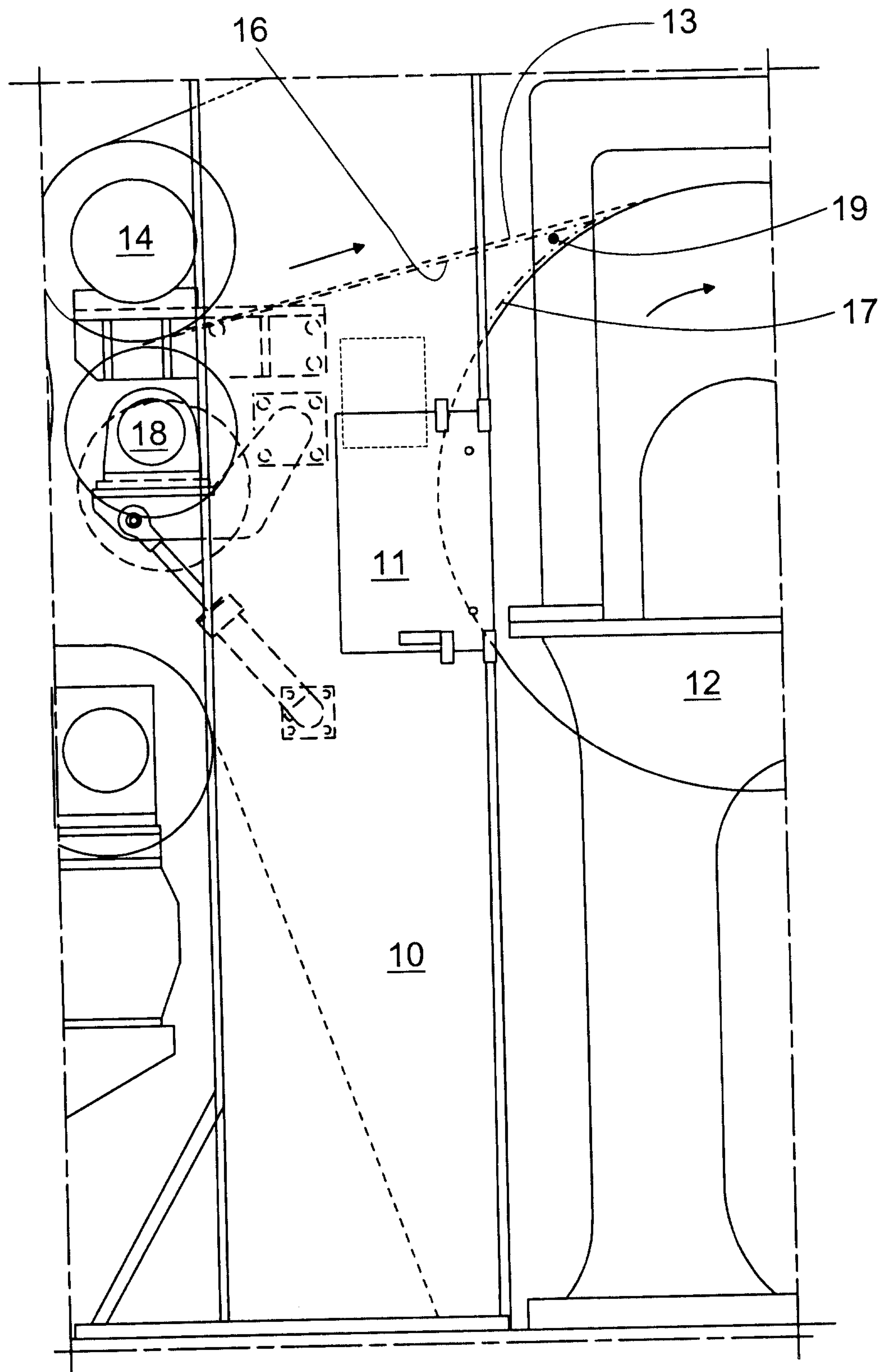


Fig. 1

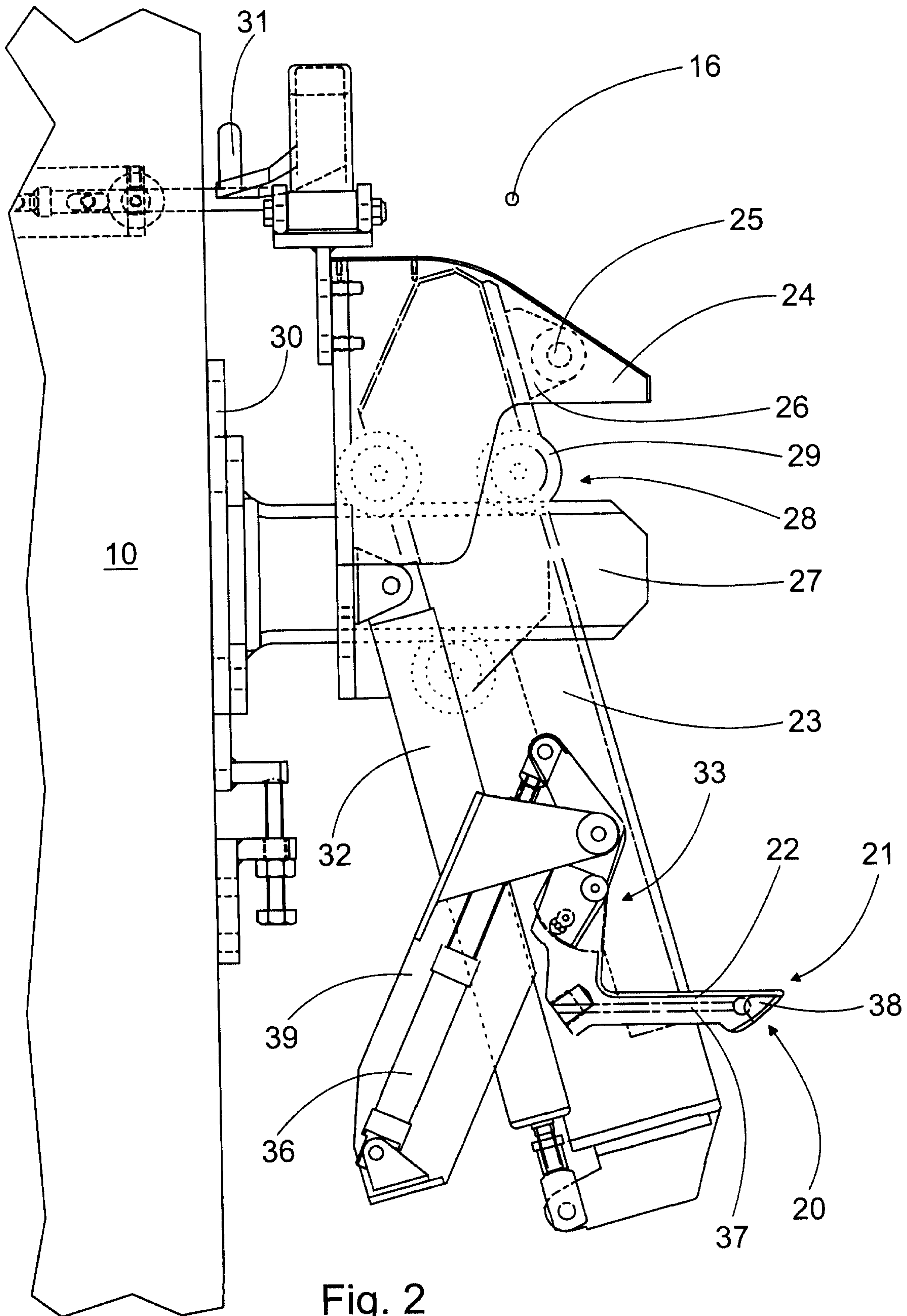


Fig. 2

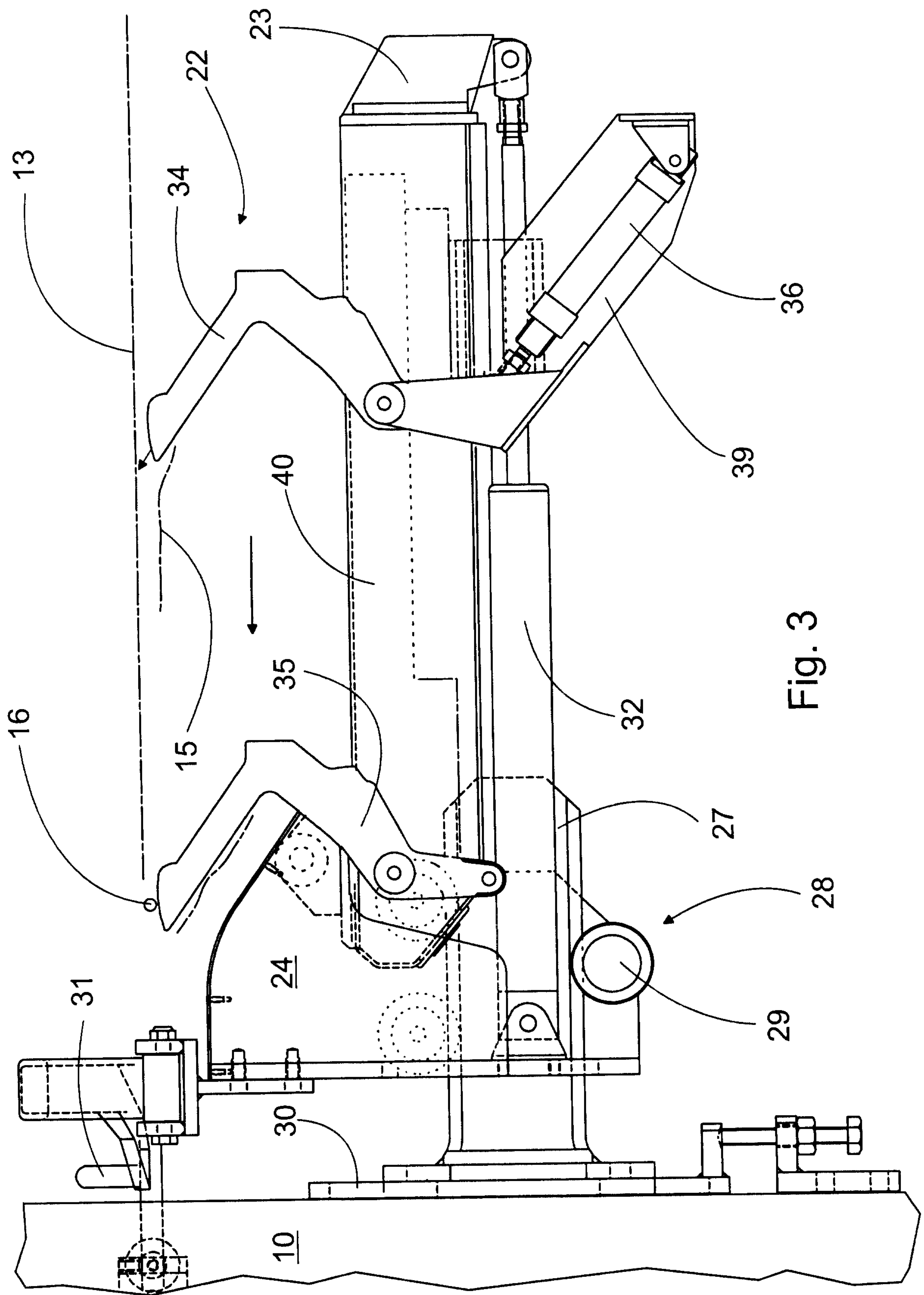


Fig. 3

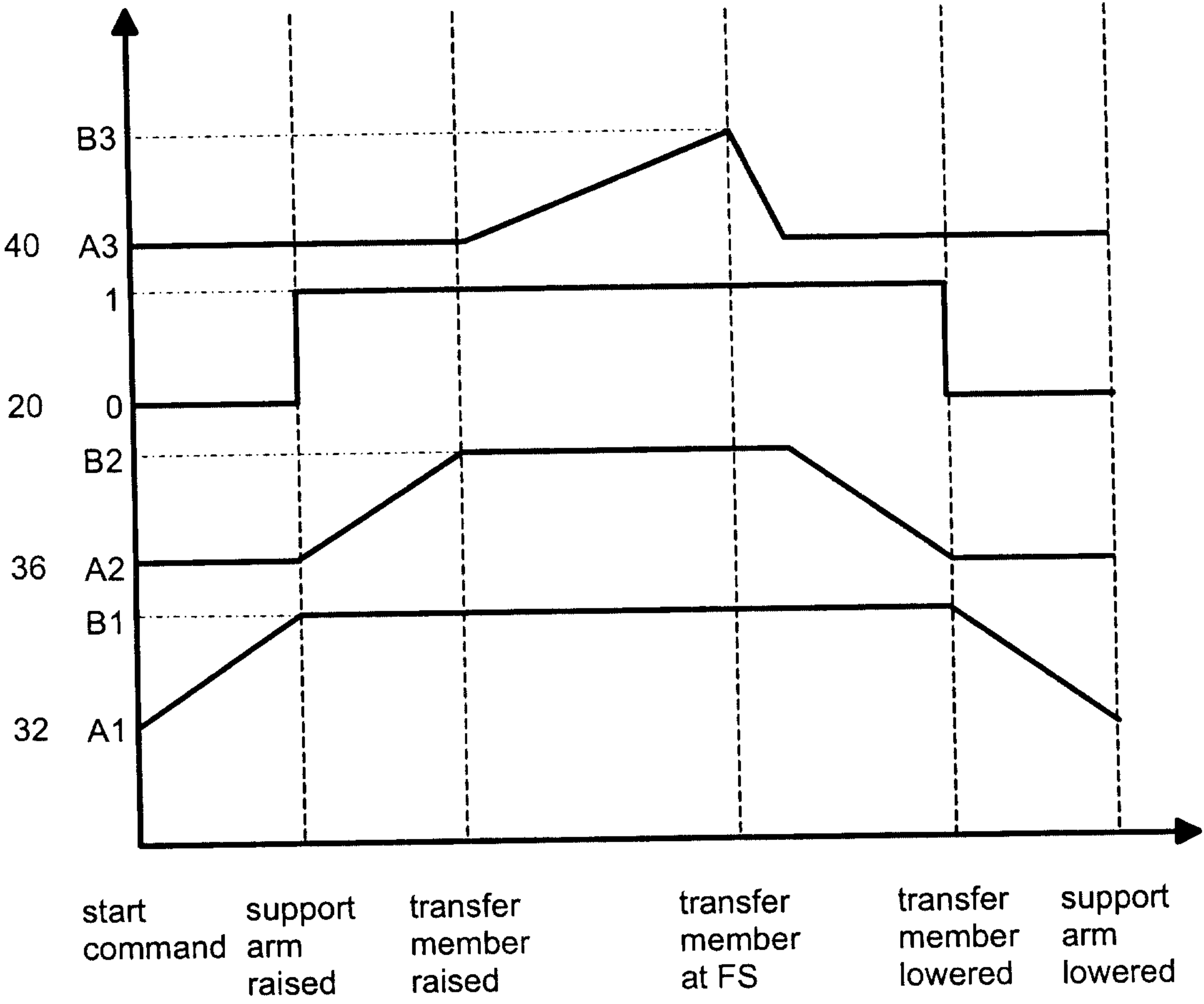


Fig. 4

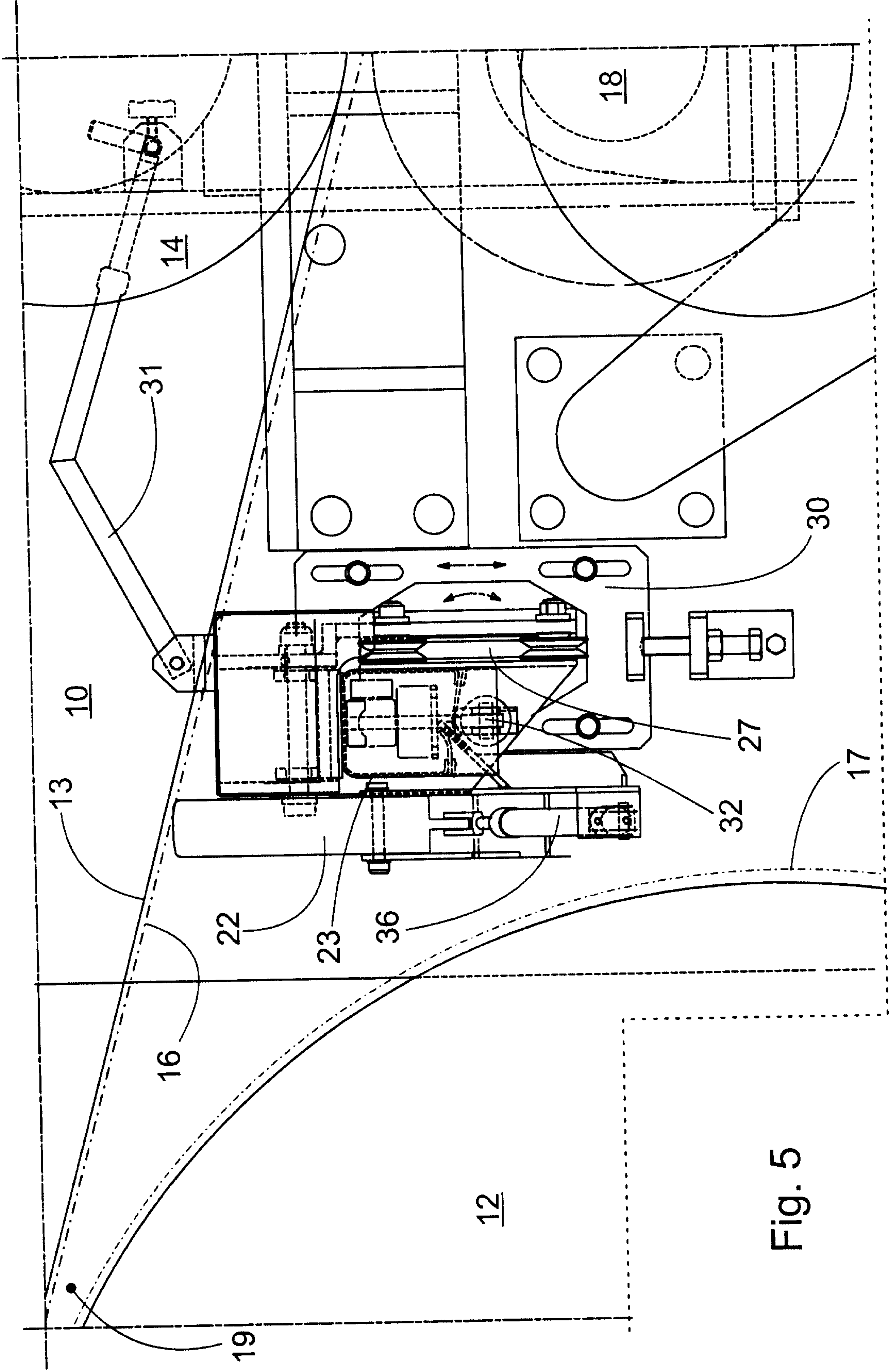


Fig. 5

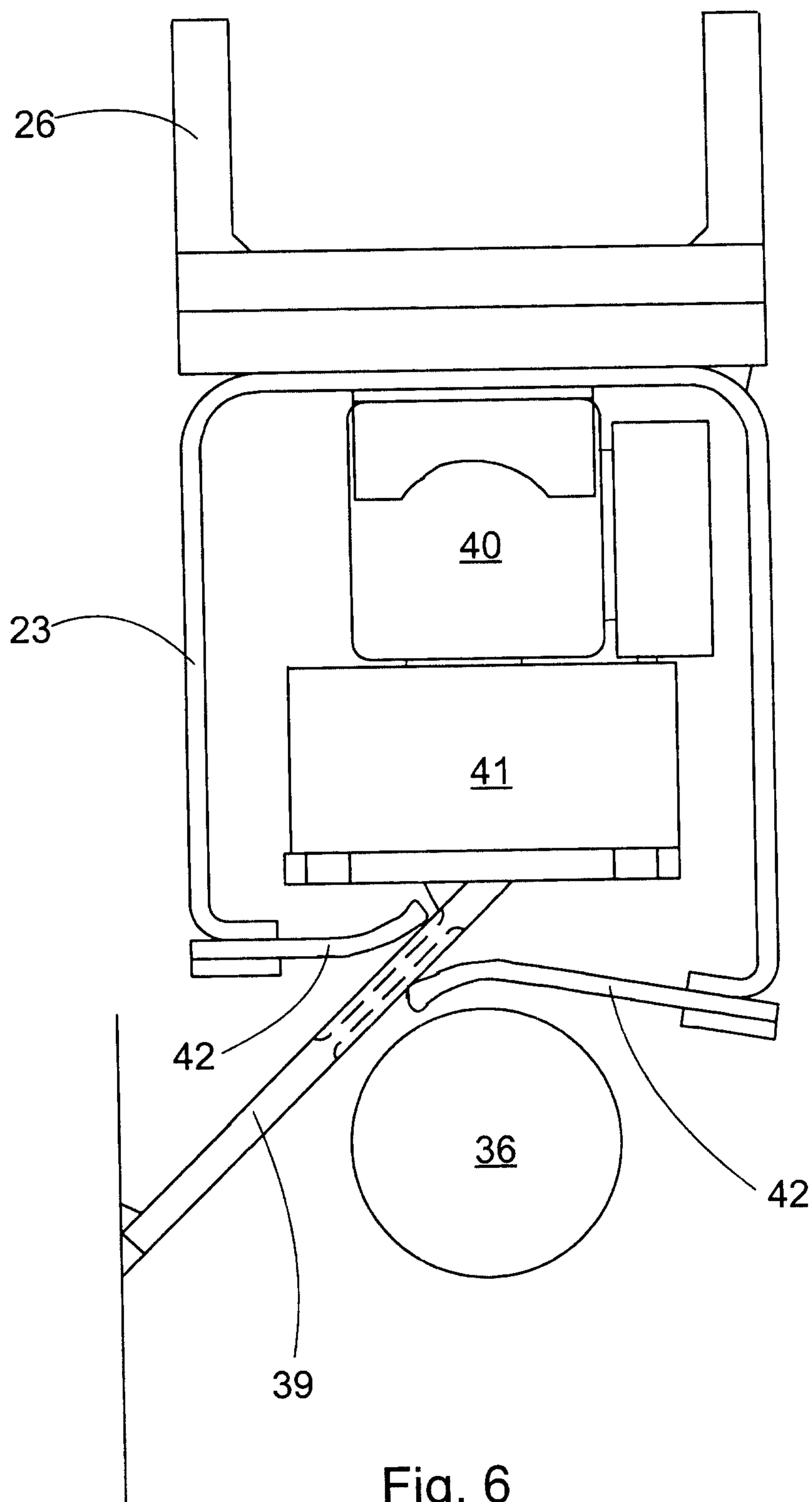


Fig. 6

