

Messrs. **Siempelkamp GmbH & Co**
Masch-u. Anlagenbau, Siempelkampstr.
D-47803 Krefeld
project: **A-540 Chirk MDF II**
plant: **491/filter plant for plant 490**
referee customer

dispatch address: **Kronospan Ltd.**
Clywd LL14 5NT
GB-Chirk Wrexham/Wales

made of dispatch: ☒ unfree ☐ free collect dispatch advice ☒
packing: **adaped for Truck**
mounting ☒ Scheuch Ried ☐ by:

order no customer: date of order.
14372/8 4.2.98

referee
sales: **st. Abw. ri. AV al**

date of sp sheet
18.2.98

date of delivery
4.5.98

order no
33093

IMPULSE-FILTER

item: **491-01** no.: **1** pcs **serial no. F 5975/98**
type: **sf dw .05/12 - d - .03** [sfd]
const. [design] no. [bags/] [valves] [cartridges] [nominal] [length] [units]
per row

construction: ☒ d-bag filter ☐ p-cartridge filter
design: ☐ k-filter head ☐ b-bunker top
☐ t-hopper ☒ w-dust collecting trough + screw
☐ with units preseparating chambers ☐ Pos 2 ☐ Pos 4
dimension sheet: **11-0004-938 b** **drawing:**

Operating data:

gas volume: **45.700** Am³/h operating temp: **20** °C
kind of dust: **MDF saw granule and dust**
dust content crude gas: **-** g/Nm³ **clean gas: 5** mg/Nm³
filter area: **420** m² load per unit area: **109** Am³/m²h

Filter installation ☒ open air ☐ in workshop
fan: ☒ before filter (pressure plant) ☐ after filter (suction plant)

Temperature design and compressive strength

☒ 11<80°C ☐ 12<140°C ☐ 13<200°C ☐ 14<250°C [sfs hg]
☒ 50mbar 3mm ☐ 40mbar 2.5mm - spec. ☐ 40mbar 2.5mm - galvanized
☐ 80mbar 4mm ☐ 150mbar 4mm reinf. [sfs gv]
design pressure shock proof ☒ 1.3bar ☐ 1.6bar absolute

Filter bags **ø160** ord. ☐
no.: **180** pcs length: ☒ acc. to filter type ☐ special **mm**
filter material: ☒ PE 520 ☐ special [sfs]
☐ without bags (supplied by the customer)

Support cages ord. ☐
☒ single port ☒ SI 37-2 galvanized [sfs slk]
☐ 2-parts ☐ 3-parts with ☐ Alu-connecting rings ☐ wire-coupling
☐ primed <140°C ☐ powder-coated <120°C ☐ Alu-silver varnish <250°C
☐ 20 bars (for Teflon bags) ☐ special material
☐ supply without support cages (supplied by the customer)
☒ 10 bars ☐ 20 bars

Filter cartridges ord. ☐
☐ ø150 ☐ ø127 (mounting f bottom)
no.: **1** pcs length: ☒ acc. to filter type ☐ special **mm**
filter material: ☐ paper fleece ☐ special [sfs]
☐ without cartridges (supplied by the customer)

Filter head 491-01.01

material plate parts: ☒ SI 37-2 ☐ mostly galvanized (2.5mm)
☐ special (2.5mm from 4301)
for: ☐ dust exposed parts ☐ gas exposed parts
jet pipes: ☐ SI 37-2 ☒ galvanized ☐ special 1.4571 [sfs lrsd]
bag bottom: ☒ SI 37-2 ☐ special material
injectors: ☒ galvanized ☐ without injectors ☐ 1.4571 [sfs vj]
☐ powder-coated <120°C ☐ primed <140°C ord. ☐
pilot box: ☒ heating - 230V ☐ flameproof ord. ☐
☐ ord. ☐

Control unit

control voltage: ☒ 220V-240V, 50-60Hz (max 24 units)
☐ 110V-140V, 50-60Hz (max 12 units)
☐ 24V DC (max. 6 units)
☐ isl6 for 1 unit ☐ mounted to filter head
☐ loose for mounting by customer
☐ loose for switchgear cabinet installation
continuous cleaning with cycle time: **sec (20-300 sec)**
☒ isl10 m from 2 units onwards, incl ddm2 transmitter
☒ supplied loose for mounting by the customer
☐ installed in supplied switchgear cabinet
☐ without casing for mounting in switchgear cabinet by the customer
☐ diff.-pressure dependant cleaning **mbar**
forced cleaning **H min (5-50 min)**
☒ continuous cleaning with cycle time
L sec (20-180 sec) H min (5-50 min)

Compressed air

maintenance unit: **8/4** inch (1 3 units 1/2", 4 12 units 3/4")
setting to: **6** bar consumption: **33** Nm³/h
arrangement: ☒ Pos 2 ☐ Pos 4
☐ compressed air tank on top for clean gas connection pos 1 [sfs dl]
☒ sound damping for compressed air impulses [sfs sdd]
☐ isolated valve-exhaust sterco, ~~and damping valve for compressed air impulses~~
☐ compressed air mounting switch (PEV transformer) [pn ds]
☐ ord. ☐

Clean gas connection

☐ connection direct at filter head (up to max. 3 units)
arrangement: ☐ Pos2 ☐ Pos3 ☐ Pos4
☐ round connection opening NW **(max 400) DIN 24154R2**
☐ rectangular connection opening NW **x450 DIN 24158R2**
[slz re-asl]
☐ clean gas connection cover plate on Pos 3 **[slz re-ab]**
(necessary for connection Pos 2 or 4)

checked-sales

checked-construction

checked-customer date

construction tolerances for the operating valves acc. to DIN 24166
welding works DIN 8563 part 3 - CS.CK

Specification sheet
Scheuch Impulse-filter
sf_dwsingle row

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project. **A-540 Chirk MDF II**

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Casing

material: ☒ SI 37-2 ☐ plate parts mostly galvanized (2.5mm)
☐ special material (2.5mm for stainless steel)
☐ intermediate walls between [sfs zwg]
bunker top filter
inspection opening: ☐ Pos. 2 ☐ Pos. 4 ☐ with protecting grid [sfs fg]
☐ crude gas connection height [lbc] - without baffle plate
☒ with crude gas connection for each unit ☒ 3 pcs
☐ crude gas connection-covers [sfs rgo]
☐ sound insulation impact plate
rupture-disks ☒ 4 pcs ☐ -200mbar ☒ +50mbar [sfs bs]
burst fail not inspected ☐ pcs ☐ -50mbar ☐ +20mbar [sfs bl]
arrangement ☒ Pos. 1 ☐ Pos. 2 ☐ Pos. 4
☐ Pos. 3 (1 bag row less)
arrangement acc. to drawing (if possible) **3x high, 1x B**
☒ see sketch high

Dust collecting hopper

material ☒ SI 37-2 (galvanized not possible)
☐ special (2.5mm for Niro)
inclination: ☐ 60° ☐ 70° [sfs l70]
inspection opening: ☐ Pos. 2 ☐ Pos. 4
outlet nozzle: ☐ 250x250 ☐ 400x250 ☒ 500x315
☐ 630x400 [sfs ost]

Dust collecting trough with screw

material ☒ SI 37-2 ☐ panels galv. trough SI 37-2
☐ special (2.5mm for galv. or Niro)
inclination ☒ 60° ☐ 70° [sfs w70]
☐ both sides inclined inclined at ☐ Pos. 2 ☐ Pos. 4 [sfs ws]
☐ intermediate walls between [sfs zw]
dust outlet nozzle ☐ 250x250 ☒ 400x250 ☐ 500x315
☐ 630x400
arrangement ☐ Pos. 2 ☐ Pos. 4 ☒ Pos. 0 (middle)
arrangement inspection openings ☒ Pos. 1 ☐ Pos. 3 above outlet

Screw

☒ ϕ 250 ☐ ϕ 300 ☐ ϕ 400 [sfs sh]
☐ screw pipe standard ☒ screw pipe ϕ 114/Stg 200
☒ flanged bearing < 80°C ☐ spherical roller bearing v. stuffing box < 250°C
☐ spherical roller bearing v. stuffing box and grease sealing l. abras. dust < 250°C
☐ extension for L = mm ☐ Pos. 2 ☐ Pos. 4
☐ without middle bearing (up to max. 8 units)
☐ 2 separate screws with each 1 drive
☒ screw with broach rubber ord. ☐

Geared motor for screw drive

make. ☒ Scheuch-Standard ☐ special **SEW**
☒ with weather protection [gmae abd]
☐ 400V/50Hz design: B3 protection IP54 [gm -]
☒ special 415V/50Hz ord. ☐
motor arrangement (if possible at outlet) ☒ Pos. 2 ☐ Pos. 4
☐ 0.55 KW/16rpm (at $p=0.3$ l/m³) [sfs gm]
☐ 11 KW/19rpm (at $p=0.3$ l/m³)
☒ 1,1 kW/ 10 rpm at Typ: **R83 DT 90 S4**
☐ motor supplied by the customer-mounting in works (price reduction) [gm aeb]
☐ motor mounted by the customer
max. discharge capacity: **9,33m³/h to 100m³/h = 150kg/h to 1400kg/h**

Dust receiver

drwg-no
type total height: mm
dust receiver: height mm no:
receiver-extension side ☐ Pos. 2 ☐ Pos. 4

Corrosion protection

outside ☒ zinc chromate primer 120µm
☐ mostly galvanized trough resp. trough RAL 7035 light grey or special coat
sand blasting SA2.5. ☐ outside ☐ inside [os]
☐ primer coat µm / top coat-RAL - µm [og od]
☒ special coat **RAL 1015 (light ivory)-40µm outside**
☒ prime inside 40µm
☒ safety guard RAL 1021 (yellow)

Pre - mounting of filter

observe transporting dimensions
bags, support cages, injectors loose (danger of damage)
☒ filter head premounted (max. 7 units)
☒ casing in single parts
☐ dust collecting hopper with frame premounted
☒ dust collecting trough in single parts, trough screw premounted
☒ wiring filter-control unit by the customer (list 10 do)
☐ casing and filter head assembled [sfs gvm]
☐ filter completely assembled
☐ filter bags (cartridges) mounted (only for a-height)
☐ fan mounted acc. to drawing
☐ add. parts mounted (precise list)

Documentation

German are delivered with hard ware (General docu).
☐ foreign language
☒ General docu 1. times
☐ Spare part list acc. to customer
☐ mounting instruction ☐ Special docu. acc. to customer

Specification sheet
Scheuch Impulse-filter
sfz single row

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Accessories

- ▷ item: **491-01.04**
Support construction [sfz ug]
▷ bill of material no.: **752-1203-440-01**
☐ support foot (UH<2500mm) ☐ angle steel support ☒ PE-support
☐ special support — drg. no. _____
height support construction **4000** mm (graduation: every 100mm)
height for dust bin: ☐ 600 ☐ 900 ☐ without flap ☐ with flap
installation place: ☒ outdoors ☐ indoors
corrosion protection: ☐ zinc chromate primer 40 µm
☐ top coat RAL _____
☒ hot-dip galvanized ☐ sand blasting SA2.5 [av, os]
condition as delivered: ☒ in single parts ☐ mounted to filter [sfz gra]
☐ _____

- ▷ item: **491-01.05**
Anchorage - support construction
▷ bill of material no.: **752-0035-001-01**
☐ anchorage with expansion sleeve ball ☐ M20/25/175 ☐ _____
☐ anchorage with adhesive anchor ball ☐ M20/220 ☐ _____
☐ anchorage with J-ball ☐ M20 ☐ _____
☒ counter-welding plates 1-25mm ☒ M20x45 8.8 ☐ _____
no. of columns: **4** pcs
balls per column: **2** pcs
☐ special anchorage — drg. no.: _____

- ▷ item: **491-01.06**
Attendance stage, rail a ladder [sfz vb]
▷ bill of material **753-0127-319-01**
☒ Attendance stage, rail WITH ladder ☒ Pos2 ☐ Pos4
☐ Attendance stage, rail WITHOUT ladder connection (closed rail)
☐ Ladder (for closed rail) ▷ bill of material _____
☐ rail and ladder for compressed air tank on top
☐ stage extension ☐ Pos2 ☐ Pos4
☒ struts safe ☒ safety barrier at exit hatch [sfz vb]
☐ special construction — drg. no.: **751-0272-001-01**
☒ ladder 10500mm **753-0039-210-01**
corrosion protection: ☐ zinc chromate primer 40 µm
☐ top coat RAL _____
☒ hot-dip galvanized ☐ sand blasting SA2.5 [av, os]
condition for delivering: ☒ in single parts [sfz gra]
☐ rail mounted on filter, ladder loose
☐ _____

- ▷ item: **491-01.07**
Clean gas channel [sfz rek]
☐ clean gas channel for _____ units size _____ x _____
☐ material and design like filter ☐ special _____
connection frame arrangement ☐ Pos2 ☐ Pos4 ☐ special _____
☐ sound insulated
☐ _____
☒ exhaust cowl for **3** units
galvanized with protective grid, sound insulated [sfz abh]
corrosion protection ☒ like filter ☐ special _____

- ▷ item: _____
Dry extinguishing line [sfz ill]
c-connecting coupling 1m above step height ☐ Pos2 ☒ Pos4

- ▷ item: _____ **complete mounted**
Rotation monitoring screw
☐ make standard _____ pcs. ☐ special _____ ord. ☐ _____
☒ rotation monitoring complete [nr eff-pg-ubw]
or in single parts.
☐ impulse sending ring ☐ console only for proximity switch [nr pg]
☐ proximity switch with console 10 - 55 VDC [nr eff]
☐ monitoring unit ☐ 230V . 50 Hz ☐ 24 VDC [nr ubw]
☐ delivered loose
☐ installed in delivered switch gear cabinet
serial: **telemecanique type: XSA-V11373/24**
VDC

- ▷ item: _____
Insulation see catalogue part 5
filter head cover-insulation in workshop [sfz isk]
inside ☐ design A (cover 50mm, upper part 80, compressed air unit 50mm)
outside ☐ design C (cover 100mm, upper part 80, compressed air unit 50mm)
☐ design D (cover 100mm, upper part 130)
design C+D cover can only be filled with crane, housing necessary
☐ _____
other areas thickness _____ mm
insulation by: ☐ Scheuch ☐ customer [isgeh]
☐ casing ☐ copper ☐ rough ☐ filter head lateral ☐ clean gas channel
covering: ☐ alu. sheet ☐ galvanized sheet thickness ☐ 1mm ☐ _____
mounting place: ☐ at site ☐ in workshop
☐ _____ ord. ☐ _____

- ▷ item: _____
Auxiliary heating for rough resp hopper ord. ☐ _____
capacity: _____ kW voltage: 230V thermostat setting: _____ °C
height: ☐ hot height ☐ total height _____ m² heating area
arrangement terminal box: acc. to drawing no.: _____
☐ _____

- ▷ item: _____ [sfz]
Filter head housing
☐ housing with attendance stage
☐ housing for compressed air tank on top
☐ housing for compressed air tank on top, double row
specification sent to _____ at _____
drg.-on: _____
arrangement door ☐ Pos2 ☐ Pos4
☐ crane rail inside
☐ crane rail 2m projecting ☐ Pos2 ☐ Pos4 [sfz hkr]
☐ door element for crane rail passage [sfz ub l]
☐ trolley with lifting device mechanically operated load capacity 250kg [sfz fr.]
☐ trapezium plate covering in colour RAL _____
drainage gutter: ☐ Pos2 ☐ Pos4
corrosion protection steelstructure ☐ like support ☐ special
☐ _____