## Operator checks for edge bursts

Work through STEPS 1 and 2, then the steps that are relevant.

**STEP 1**

**Ask:**

Was there an event occurring that was likely to cause an edge burst? Such as speed change, grade change, head box grammage spike, sheet flip over a size press, etc.

**Investigate:**

Use break camera analysis to narrow down the source of the edge burst. Movies can be made to help identify sources of bursts that do not cause breaks.

If a fault (debris, etc.) can be found, use following steps of this guide to correct.

If no source can be found then have the tester check edge grammage.

**STEP 2**

**Inspect former for faults by c**hecking for:

* Build up on bottom apron lip or head box pond size door
* Build up on lead out shoe at separation of fabrics
* Build up on deckle cutters
* Build up on couch roll edge flicking off
* Pulp flicking off PU felt guide paddle into former
* Needle spray pressure is correct and oscillators are actually oscillating

**Action**: Check top and bottom fabric edge for pulp carry – adjust former edge sprays and clean build up away. Check needle spray pressure – 2200kpa and condition of sprays – clean needle sprays if required.

**STEP 3**

**Check edge strength and quality:**

* Check edge cut quality – use sample from reel and strobe to check cut
* Check for crushing at auto slice – adjust auto slice or slice opening
* Check formation – poor formation will result in reduced sheet strength
* Check for stock pulsing on wire observe attenuator bleed off and check drain valve for water (indicates damaged diaphragm)
* Check cheek bleed position and fibre orientation

**Action**: Address aspect of edge strength and quality as required

**STEP 4**

**Check water removal – low sheet dryness off former:**

* Wet line should not be past half way under the CIVB. If so, check vacuums and if normal adjust, lead in shoe, slice opening or free up stock as appropriate
* Couch Roll doctor should not be spraying water after the doctor. Check Vacuum on roll, doctor loading and wet line as above.

**Action**: Address aspect of water removal as required

**STEP 5**

**Check press section edge bursts:**

* Check drawers – particularly 2nd press back edge
* Check PU felt edge trim for flickering – cameras may help
* Check press doctors for passing
* Check 2nd and 3rd press doctors are oscillating correctly
* Felt tension correct
* No felt barring
* Check for build-up of grease in felt edge – common on PU felt
* Check uhle box sprays are on and none blocked
* Check needle sprays are in good working order, PU 1500kpa, 1st & 3rd 1100kpa and that they are oscillating
* Check for loose felt strands
* Check for build-up on 2nd P lead roll edge flicking off
* Check 3rd press doctors sprays are all working as any blockages will lead to passing on the second blade
* Check for debris in 2nd press outgoing nip
* Check bubble eliminator is not on too high or low – observe sheet from back of press
* Is a press felt barred – if so follow barring trouble shooting guide
* Check uhle box weirs to ensure separators pumps are working correctly
* Unloading 3rd press to 90KN has assisted in reducing bursts in the past. Also reducing edge loads on 1st and 3rd press
* Check 2nd press roll speed the same as former – adjust Suction Press roll draws to suit
* Check for water drips flicking off 3rd press and causing build up above open draw or start of 1st dryer
* Check tray heating is all working

**Action**: Address press section edge bursts as required

**STEP 6**

**Check dryer section bursts:**

* Check draw set points – are they normal. ½=0.02, 2/3 =-0.01, ¾=0.02
* Check fabric tensions – no seam damage or build up
* Check dryer screens for debris build up or damage
* Check for build up’s in section on doctors or in hood
* Check sheet edge stability at each of the dryers – particular focus in 1st section, 2nd section and 3rd section. Note on heavy weight sheets more vacuum is often required in the 2nd or 3rd section to prevent back edge bursts
* Check vacuums and valve positions in bel champ runs
* Check all sight glasses and each dryer section torque to see if any dryers are flooded causing speed changes in section.

**Action**: Address dryer section edge bursts as required