

Customer and Supplier information

September 2015

KRAFFT Wood – Rolls for producing MDF and chipboards

Dear business partner,

our subsidiary Kelzenberg is one of the leading producers of drums for the wood-working industry. These big rolls are used for a continuous pressing process of the basic material to e.g. chipboards, MDF or OSB.



In general two types of the presses are in the market:

Calender presses

Calender presses, also known as AUMA or MENDE presses, are used to produce boards with thicknesses up to 8 mm at an aerial density up to 1.200 kg/m².

The machines' core item is a peripheral drilled heating drum with a diameter of up to 4.200 mm at a face length up to 3.160 mm (10 ft.).

The drum is supported by one driving roll, one tension roll and one heated press roll with typical diameters of 1.400 or rather 2.000 or 2.500 mm each.

The rolls are embraced by a steel belt so the material can be compressed with defined pressure and hardened afterwards.



The picture on the right shows the final machining step. The staff member of stately size demonstrates the proportions.

Which services do we offer?

- Production and service of the peripheral drilled heating drum in advanced design

diameter	< 5.200 mm
face length	up to 4.000 mm
weight	up to max. 100 t
surface	cladding welding for high hard surfaces

- Production and service of the tension and driving roll

diameter	< 2.500 mm
face length	< 4.000 mm
surface	individual for any application

- Production and service of the heated press roll

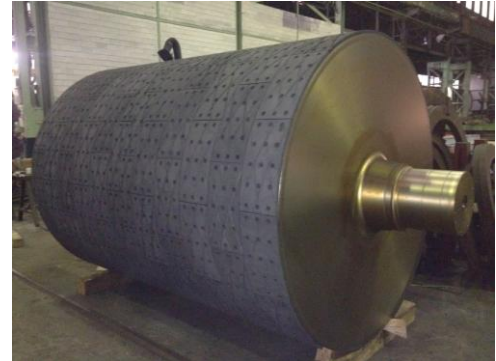
diameter	< 2.500 mm
face length	< 4.000 mm
surface	individual for any application

Double belt presses

Double belt presses are used to produce chipboards, OSB and MDF boards with thickness up to 40 mm.

These machines consist of two infeed and two outfeed rolls with a diameter of 2.000 respectively 2.220 mm. In each case a pair is entangled with a steel belt which pulls the product through an up to 70 m long heating and pressing device.

The outfeed roll is typically equipped with friction pads to transfer the essential driving torque onto the steel belt.



Which services do we offer?

- Production an service of the infeed roll

diameter	< 2.650 mm
face length	< 4.320 mm
weight	around 24 t
surface	machined

- Production an service of the outfeed roll

diameter	< 2.922 mm
face length	< 4.320 mm
weight	around 32 t
surface	machined and drilled for the use of friction pads

Any company running the above mentioned lines shall consider that these drums are subject of very high loads and therefore in consequence the material might show fatigue weakness. It is recommended to carry out recurrent inspections. Some companies even keep spares for exchange available, due to the significant lead times of such drums.

About KRAFFT:

KRAFFT is one of Europe’s leading manufacturers of and specialists for rotationally-symmetric components. The knowledge gained from building plants for the production of paper and cardboard was consequently aligned to new products and product segments throughout the past years. Four product sectors are the backbone of the company:

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|---------------------------------------|--|
| KRAFFT Rollers – KRAFFT Walzen | is the company’s flagship brand for rollers, cylinders and drums |
| KRAFFT Turning Technologies | Turning parts and large turning parts are used in plant construction and engineering |
| KRAFFT Engineering | Engineering and projecting, turn-key systems |
| KRAFFT Services | Service and maintenance, repair, assembly |

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