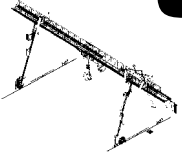


UPDATE



Winter 1990/1991

P&H FALL PORTAL CRANE USERS MEETING CALLED TOTAL SUCCESS

The 1990 P&H Portal Crane Users Meeting was held in Milwaukee on September 12-14 with eight mills represented, including: International Paper, Mead Coated Board, Federal Paper Board, Westvaco, S.D. Warren, Scott Maritimes Ltd. and Georgia Pacific (2 mills). Mack Manufacturing was represented and P&H brought in all of portal crane product support, engineering and sales personnel. The meeting proved to be a very worthwhile opportunity for users to meet the P&H product support team, learn about ways to improve their crane performance and also for P&H to be able to listen to our valuable customers. There were over 40 in attendance for the two day event which also included a tour of our Oak Creek manufacturing facility.

Thursday morning's round table discussions covered a wide variety of crane topics, including the following highlights.:

1. Following a brief welcome, Anti Trust Awareness discussions and instructions; each mill provided a summary of their crane application and key issues to address during the meeting.
2. Alan LePage of S.D. Warren warned the others to watch out for "counterfeit" cable clamps for the hoist cable dead ends. "Specify Crosby" to ensure top quality. Alan reported 98% uptime and 3 to 4 month hoist rope life using the PFV wire ropes as compared to 6 weeks using standard IWRC 6x37 ropes. Bud Toole of GP reported 12 to 14 month hoist cable life using PFV cables.
3. John Cody of Georgia Pacific reported excellent success with standard IWRC wire rope providing 9 months typical life.
4. The "Supernut" gantry drive bevel gear retainer was demonstrated and thoroughly discussed. See separate write up on this update.
5. Ken Attkisson of Bear Island Paper reported that his P&H 60 plus gantry wheels are wearing much better than the original rim toughened wheels and he was pleased with the 60+ wheels.
6. It was noted that the skew controls are ineffective at slow speeds but very effective at reducing wear and tear on the crane structure at high speeds.
7. users who switched from our old capsule type wheel bearing retainers to our new MCB design reported very good results and much greater ease of maintenance.
8. How do you measure drum groove wear? In general, if the drum groove root diameter is worn over 1/4 of the rope diameter, the drum should be replaced. Sharp edges can also be ground smooth to avoid rope damage. In some cases, drums can be regrooved.
9. Chuck Stoneman discussed his advanced operator training course. Several users confirmed the positive results of Chuck's training where operators learn to understand the crane system and also how to relax and avoid back problems. Scott Maritimes, S.D. Warren and Georgia Pacific all reported having 12 hour operator shifts with no noticeable back or fatigue problems
10. Cab improvements were discussed - more information will be in next issue.
11. Mack Manufacturing stressed the importance of proper filtration on the grapple hydraulic system as well as 8 hour greasing intervals.
12. The importance of spare parts stocking at the mill was highlighted by John Cody of Georgia Pacific, who reported a 50% improvement in uptime after setting up a parts stocking program. The P&H product support regional managers are available to help with this very important factor.
13. PM inspections by P&H ProCare specialists were reported as being very beneficial in improving uptime. Bear Island reported that their insurance requires one (1) PM inspection by an outside qualified firm per year.
14. The importance of cable reel PM was stressed by all users; "If the cable is slack at startup, rewind by hand prior to starting", reported one user.
15. A movie on wire rope maintenance was shown. This is available for loan to our customers.
16. During the banquet, awards were given to all users present in appreciation for their support and involvement
17. Drive truck guard and cab shelf drawings were handed out on a courtesy basis.

Installing Replacement Grapple Power Cable

By: Daniel J. Cunningham
Siemens Power Cables Division

Optimal performance of the electrical cable to power the grapple is realized by installign the cable correctly in the basket and, if needed, by modifying the basket.

Several users have reported that the basket can generally be improved by reducign the diameter of the entry ring to approximately twice the diameter of the cable. apparently, this small diameter rign is beneficial as it maintains the starting point of the coil of cale at all times during hoisting so that the coil is formed consistently. The ring can be easily installed if it is split and bolted around the cable. These tips are valid for any brand of cable.

when installign any cable, i is importatn to remove any twist that may have been introduced durign the handlingof the cble. After feeding it into the basket, counterclockwise fo Spreaderflex™, clockwise for others, it is best to raise the basket, tie the cble off on a swivel: theu run the basketdown and then back up helping the cable coil properly if it starts to backwarp.

when the top is reached again, the cable can be attached greased and terminated. A gresae or oil used in the woodyard can be usedfor convenience or standardization. One grase that works very well and resists washing off by rain is Nevamelt™ by Drew chemical of New Jersey. Spreaderflex™ cable must be greased prior to operation. The grease can be applied while wearing gloves, using rags, or a brush. the grease needs to be reapplied periodically with the time interval depending on the duty cycle, speed and weather conditions. After greasing, operations can begin. At the trolley, some mechanical stress relief for the cable is necessary. The best method is the use of a stress relief drum, around the cable is warpped 2 1/2 times or more.

Trolley Drive Disassembly

Due to the locaiton and type of mounting, when disassembly the new style (Hansen gearbox type) trolley drives, special care should be taken to follow proper procedures for safety and component replacement.

On Friday morning the Product support team ammounced sereral changes in both the parts and service areas that have already proven to improve customer satisfaction including:

1. Toll free 800 numbers for both parts and service.
2. Tansfer of parts manufacturing to one centralized facility in the Milwaukee area for improved delivery reliability.
3. Formation of repair parts expediting team that identifies problem areas, takes positive steps to resolve the problems and maintain promised delivery schedules
4. Appointment of Diane Mielke as our dedicated portal parts specialist.
5. Reorganization of the ProCare Service Department with more qualified portal technicians in the field and formation of a home office technical services team for improved reponsiveness to technical quesitons and trouble shooting.
6. Placement of Portal Crane Product Support Regional Managers in Atlanta, Toronto, and Vancouver who are totally focused on customer satisfaction with P&H parts and service.

P&H has and will continue to implement company wide programs throughout the 1990's that focus on customer satisfaction. The above changes in the product support group are a few examples of this very important initiative. We are listening to our customer's needs and responding to meet these needs. We welcome your ideas and suggestions on how we can further improve our customer friendliness.

Supernut

One of the important announcements of the fall user meeting was the release of the supernut as a replacement for the double input bevel gear hub retainers on the gantry drive input gear set. Thanks to the efforts of Dick Neiert of P&G Cellulose, Perry, FL, the supernut has been thoroughly tested and is now standard equipment on the new P&H drive trucks. This significant improvement resolves the last weak link in the P&H gantry drive package. Previiosy improvements included all gears in oil, MCB wheel bearing retainers, and improved gear quality and hardness.

If you have repetitive problems with the double nuts coming loose, you can obtain these supernut replacements from portal parts. Straight Track Cranes: Kit #20Z2672D1 and for Rotator Cranes: Kit # 20Z2672D2.