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| Production Line  1. Paper machine -1 2. Paper machine -2 3. Paper machine -3 4. CCPM -1 5. CCPM-2 6. BBS – 1 7. BBS – 2 8. Spiral Machine 9. Sticker Paper 10. Gum Tape 11. A4 Cutter |  |
| The main Raw materials : a) Paper machine -1: Main Raw materials for this product line are  FRM : Chemicals :   1. NBKP ( Soft wood pulp ) 1.AKD 2. LBKP ( Hard wood pulp )2.Emultion rosin (composize ) 3. CTMP3. Fibercon PC 120 4. UBKP4.Bufloc – 590 5. BCTMP 5. IVAX POLYTC 6. HWS6.Talcum Powder 7. HWEC7.CaCo3 PCC 8. OCC8.CaCo3 GCC 9. L.W.(Swedish board) 9. Titanium Dioxide 10. L.W.(Sack Kraft) 10. Starch 11. L.W.(OCC) 11.Defoamer 12. L.W.(White grade 1 &2) 12. OBA 13. Old white printed book13.Caustic Soda 14. Waste Wrapper14.Alum 15. BG Office waste 15. Dye |  |
| Basic Production Process : PM-1:At first we take pulp(NBKP/LBKP) to hydropulper and add water for slashing the pulp.We also adddye due to maintain paper shade. After taken out the slashing pulp to dump chest by pump. Then the stock is passed throw the high density cleaner, centrifiner and transferred to mixing chest to added different types of chemicals. After completed chemical mixing it is transferred to holding chest. At holding chest we added some chemicals also. After then it is transferred to machine chest by refiner. Now the stock is ready for making paper.  After completed the job of stock preparation, stock transferred to fourdrinier to make the formation of paper. Before fourdrinier we added some chemicals. There are some dewatering system of fourdrinier part. After dewatering 20% of water,the paper sheet is transferred to press part from fourdrinier wire. After pressing, paper contain 60% of moister. Then it is transferred to dryer part for proper drying. After drying the paper sheet passed throw the calender to pope reelforwinding. After winding, paper contained 5% of moisture. Then the paper roll is transfer to Re-winder for making baby rolls. We used paper core, splicing tape & some adhesive to make baby rolls. Some baby rolls directly transfer to ware house and some for sheet cutter for making sheet.    PM-2:At first we take pulp(NBKP/LBKP) to hydropulper and add water for slashing the pulp.After take out the slashing pulp to dump chest by pump. Then the stock is feed in to beater. After completed beating it is transferred to mixing chest to added different types of chemicals. After completed chemical mixing it is transferred to holding chest. At holding chest we added some chemicals also. After then it is transferred to machine chest by refiner. Now the stock is ready for making paper.  After completed the job of stock preparation, stock transferred to fourdrinier to make the formation of paper. Before fourdrinier we added some chemicals. There are some dewatering system of fourdrinier part. After dewatering 20% of water,the paper sheet is transferred to press part from fourdrinier wire. After pressing, paper contain 60% of moister. Then it is transferred to dryer part for proper drying. At the middle of dryer part, there is a size press & paper passed through the size press. We used some chemicals on size press. Again paper transfer to dryer for proper drying. After drying the paper sheet go to pope reel forwinding. After winding, paper contained 5% of moisture. Then the paper rolls are transfer to charka for making paper sheet by manual process.    PM-3:At first we take pulp(NBKP/LBKP) to hydropulper and water for slashing the pulp.We also added dye due to maintain paper shade. After take out the slashing pulp to dump chest by pump. Then the stock is passed throw the high density cleaner and centrifiner.After that it is transferred to mixing chest to added different types of chemicals. After completed chemical mixing it is transferred to holding chest. At holding chest we added some chemicals also. After then it is transferred to machine chest throw refiner. Now the stock is ready for making paper.  After completed the job of stock preparation, stock transferred to fourdrinier to make the formation of paper. Before fourdrinier we added some chemicals.There are some dewatering system of fourdrinier part. After dewatering 20% of water,the paper sheet is transferred to press part from fourdrinier wire. After pressing, paper contain 60% of moister. Then it is transferred to dryer part for proper drying. At the middle of dryer part, there is a size press & paper passed through the size press. We used some chemicals on size press. Again paper transfer to dryer for proper drying. After drying the paper sheet passed throw the calender to pope reel for winding. After winding, paper contained 5% of moisture. Then the paper roll is transfer to Re-winder for making baby rolls. We used paper core, splicing tape & some adhesive to make baby rolls. Some baby rolls directly transfer to ware house and some for sheet cutter for making sheet.    NCR Machine -1& 2 :  At first base paper is collected from PM-1,then it is feed in to unwinder .After this paper wave pass throw the CB coater. In this coater various chemicals are used like micro capsule,modified starch etc. Now wet paper wave pass throw the oven box and dryer cylinder for drying. After drying coating paper pass throw the calender for better smoothness. After completing the one side coating, paper wave pass throw CF coater for coating the another side of base paper. There are various chemicals used in this coater like resin color developer etc. Now  the wet paper wave pass throw the oven box and dryer cylinder for drying. After completing drying coated paper is reeled in to a paper core.    Sticker Paper  Sticker Paper consists two different types of paper a) Released Paper  b) Cast coated paper  **Released paper:**First of all base paper is collected from PM-1 and feed in to lamination machine for one side lamination ( polyethylene ). After completing PE lamination paper reel feed in to silicon coating machine. Paper wave is passed throw silicon coater. Here we use silicon oil. Now the wet paper wave is passed throw oven box for drying and reeled in to core. Now release paper making is complete for sale or further process.  **Cast coated paper :**Base paper is collected from PM-1/3 and then feed in to cast coating machine. The paper pass throw the pre coater ( air knife coater ),in this point various chemical are used such as kaolin clay etc. After then paper wave enter in to oven box for drying. After this paper again pass throw final coater .Some chemicals are used here. Now the wet paper is passed throw oven box & drying cylinder for drying. Then it is reeled in to core.  **Glue coating machine:**To make sticker paper release paper & cast coated paper are sandwiched in glue coating machine. Before sandwiching water gum and some chemical are added in to the released paper.    A4 Cutter :  Operation process of A4 paper cutter involves paper roll loading, electrostatic discharging, paper sheeting and paper piling. Optional items with A4 paper cutter include separating paper sheets into pre-determined quantity.    BBS ( Exercise book ) :  The process of manufacture for exercise books involve the following  operations.   * Line Printing * Cutting of paper * Attaching of cover * wire stitching or punching * Folding * Back pressing * Slitting * Strip binding * Shrink wrapping |  |
| Production Stock Staging |  |
| Process OperationCapacity : **Paper Machine -1:**42 ton/day  **Paper Machine -2:**11.5 ton/day  **Paper Machine -3 :**38 ton/day  **NCR Machine - 1 :**07 ton/day  **NCR Machine - 2 :**13ton/day  **BBS (Exercise book ) – 1 :**10ton/day  **BBS (Exercise book ) – 2 :**20ton/day  **BBS Spiral Machine :** 03ton/day  **A4 Cutter Machine :** 26ton/day  **Sticker Machine :** 12ton/day |  |
| Production Type :Make to OrderMake To Stock |  |
| 7 Major Machinelist : Paper Machine - 01   * Conveyor * Hicon Pulper * Hydro Pulper * High Density Cleaner * Vibrating Screen * Thickener * T.D.R(Tripple Disk Refiner) * Conical Refiner * L.D.C ( Low Density Cleaner) * Fan Pump * Pressure Screen * Head Box * Wire Part * Press Part * Dryer Part * Calender Stack * Pope Reel   Paper Machine – 02   * Conveyor * Hydro Pulper * Beater * Thickener * T.D.R(Tripple Disk Refiner) * D.D.R (Double Disk Refiner) * L.D.C ( Low Density Cleaner) * Fan Pump * Pressure Screen * Head Box * Wire Part * Press Part * Dryer Part(Pre & Post Dryer Group) * Size Press * Yankee * Pope Reel   Paper Machine – 03   * Conveyor * Hydro Pulper * High Density Cleaner * Thickener * T.D.R(Tripple Disk Refiner) * Conical Refiner * L.D.C ( Low Density Cleaner) * Fan Pump * Pressure Screen * Vibrating Screen * Head Box * Wire Part * Press Part * Dryer Part * Size Press * Calender Stack * Pope Reel   NCR Machine – 1 & 2   * Unwinder * Air knife coater * Hot air blower box * Dryer cylinder * Soft calender * Cooling cylinder   Sticker Paper   * Unwinder * Pre-coater * Hot air box * Dryer cylinder * Air knife coater * Extruder   BBS 1 & 2 (Exercise book)   * Unwinder * Printing tower * Cutter * Stiching head * Spiral binding machine * Guillotin Machine * Blower * Silo   A4 Cutter   * Unwinding stand * Slitting & cross cutting knife |  |
| 8 Working hours : 8:00am -5:00pm (General Shift)  6:00am -2:00pm (A Shift)  2:00pm -10:00pm (B Shift)  10:00pm- 6:00am (C Shift)  6:00am – 6:00pm (Morning Shift, AB )  6:00pm- 6:00am ( Night Shift, BC ) |  |
| 9 Wastage |  |
| 10 Rework : **Not Applicable** |  |
| 11Reports :  * Daily Production Report * Monthly Production Report * Daily Chemical Consumption Report * Daily Losstime Report |  |