Valmet Dryer Roll Cover DOH

Release cover for drying cylinders

Valmet Dryer Roll Cover DOH keeps cylinder surfaces clean and provides excellent release and doctoring properties. Cylinder on-site coating is possible, even inside the machine during shutdown.

**Applications**
- Drying cylinders

**Topography options**
- Plain

**Patching and repair**
Patch repair may be considered in the case of smaller surface problems. Please consult Valmet.

**Chemical resistance**
Excellent resistance against all normal process chemicals. Recommended pH range: 4 to 9. Avoid prolonged exposure to strong alkalis and acids or alcohols.

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<table>
<thead>
<tr>
<th>DOH</th>
<th>Cover color</th>
<th>Hardness</th>
<th>Cover thickness</th>
<th>Maximum temperature</th>
<th>Surface roughness</th>
<th>Maximum loading</th>
</tr>
</thead>
<tbody>
<tr>
<td>To keep cylinder surfaces clean</td>
<td>Gray</td>
<td>1,100–1,300 HV0.3</td>
<td>0.1 mm (0.004&quot;)</td>
<td>160°C (320°F)</td>
<td>Ra 0.6 / 0.3* μm (25 / 12* μin)</td>
<td>Not applicable</td>
</tr>
</tbody>
</table>

* When doctored

**Benefits**
- Excellent release and non-stick properties
- Extended lifetime due to superior wear resistance
- Good doctorability, longer doctor blade lifetime
- Excellent corrosion resistance
- Short coating time due to unique polymer composition provides remarkable savings and benefits with on-site coating
Cleaning

Permitted cleaning agents:
• Water (temperature difference in line with cylinder design standards).
• Ethanol for cleaning difficult stains. Rinse with water.
• Mild manual cleaning detergents with neutral pH. Rinse with water.
• Aqueous solutions with modified surfactants, maximum hydrocarbon concentration 2%. Rinse with water.
• Most common ‘ecological’ cleaning agents. Rinse with water.

The following agents are not recommended for surface cleaning:
• All high-pressure washing should be avoided
• Washing with steam/water vapor
• Chlorinated hydrocarbons
• Volatile alcohols
• Volatile esters
• Ketones
• Turpentine

These agents are strictly prohibited:
• Unsaturated chlorinated hydrocarbons
• Strongly acidic solutions (pH 2 or below)
• Oxidizing acids
• Strongly alkaline solutions (pH 11 or higher)

Permitted cleaning instruments include soft applicator spatulas and brushes that do not leave scrub marks or film on the roll surface. Metallic instruments and hard, sharp-edged instruments should be avoided.

Doctoring recommendations
• Blade angle 23° (cleaning positions) or 27° (web takedown positions) while loaded
• Typical blade load: 100–250 N/m (0.6–1.4 pli), depending on application
• Full-carbon Valmet Doctor Blade Carbon VE T10 doctor blades are recommended as startup blades
• Carbon fiber doctor blades are recommended for normal continuous use. Ask Valmet for blade recommendations.
• Valmet tending doctor blades are recommended for situations where special cleaning and improved doctoring are required
• A blade thickness of 1.5 mm (1/16”) is preferable
• Valmet self-profi ling holders are recommended

Cover drying
No specific instructions for these covers.

Transportation and storage
Store in a dry place protected against condensing moisture and water. Avoid large temperature variations. Use cardboard to protect the coating against oil, dirt, dust and damage. Store each roll on its own transport base or support by the journals. Use wooden/plastic saddles when supporting rolls by the shell. Use thick rubber sheets (25 mm/1”) and dry protective cardboard. Lift by the journals whenever possible. When lifting by the shell, protect the lifting points with thick cardboard and use wide and clean lifting straps. Avoid bumping the roll against anything.

Roll cooling
No specific instructions for this coating.

Crowning and tapering
No specific instructions for this cover, usually not crowned nor tapered.