



## เอกสารแนบที่ 2.2

---

กำหนดการบำรุงรักษาประจำปี 2565  
(Annual Preventive Maintenance Schedule)

Major Shutdown : 4-8 Jul 2021

PAPER SHUTDOWN SCHEDULE PLAN

Section	Location	Work description	Crane	PLAN		3	4-Jul				5-Jul			6-Jul			7-Jul			8-Jul		
				Time	Duration (Hrs.)	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	

Section	Location	Work description	Crane	PLAN			3	4-Jul				5-Jul			6-Jul			7-Jul			8-Jul		
				Time		Duration (Hrs.)	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C	
		Paper Production Shutdown		04/07/2022 02:00	09/07/2022 02:00	120.0																	
		Paper Machine หยุดเครื่อง 4:00 น.		04/07/2022 03:00	04/07/2022 07:00	4.0																	
		WORK PERMIT, LOTO ,LINE BREAK พนักงานผลิตทุกตำแหน่งร่วมเปิด work permit		04/07/2022 07:00	04/07/2022 10:00	3.0																	
		Maintenance time + Function Test		04/07/2022 10:00	08/07/2022 23:00	109.0																	
		Paper Machine Start sequence (On Reel)		08/07/2022 23:00	09/07/2022 02:00	3.0																	
		Winder Production Shutdown		04/07/2022 03:00	07/07/2022 11:00	80.0																	
		Winder Stop		04/07/2022 03:00	04/07/2022 07:00	4.0																	
		Maintenance time + Function Test		04/07/2022 07:00	07/07/2022 06:00	71.0																	
		Winder Start		07/07/2022 06:00	07/07/2022 11:00	5.0																	
		Converting																					
		Loadม้วนเข้า converting ก่อนวันที่ 4/7 เนื่องจากซ่อมเข้าทำงานที่ Slatconveyor และ Uppender1,2		04/07/2022 08:00	04/07/2022 20:00	12.0																	
		Pulp Mold **ไม่กระทบ																					

<u>Paper Machine Critical Jobs</u>	4/7/2022 2:00	9/7/2022 2:00	5.0	Days
------------------------------------	---------------	---------------	-----	------

PD	Chemical	Chemical เตรียมโซดาไฟให้ไว้ Boil out Dryend ตาม Wetend		04/07/2022 01:00	04/07/2022 02:00	1.0																												
PD	Dry End	Temp survey all Dryer roll		04/07/2022 02:30	04/07/2022 03:00	0.5																												
PD	All	Paper machine stop		04/07/2022 02:00																														
PD,Boiler	All	หยุดรับ steam จาก Boiler		04/07/2022 03:00																														
PD	Dry End	หยุดจ่าย steam เข้าระบบ (ปิด Main Steam valve )		04/07/2022 04:00	04/07/2022 05:00	1.0																												
ME	Dry End	เปิดฝา Manhole Dryer		04/07/2022 07:00	04/07/2022 09:00	2.0																												
PD	Dry End	Cool down Dryer + Remove condensate		04/07/2022 09:00	04/07/2022 15:00	6.0																												
PD*	Wet End	Remove Felt Top & Bottom	2	04/07/2022 02:00	04/07/2022 03:00	1.0																												
PD	Wet End	Process Boil out (short loop)		04/07/2022 03:00	04/07/2022 07:00	4.0																												
PD*	Wet End	Remove Wire Top (ถอด) & Bottom (ถอด)	2	04/07/2022 07:00	04/07/2022 11:00	4.0																												
PD	Wet End	Cleaning Wire Headbox (ใช้กรด)		04/07/2022 11:00	04/07/2022 14:00	3.0																												
PD	Wet End	Cleaning Wire part & Press part		04/07/2022 14:00	04/07/2022 15:00	1.0																												
ME*	Wet End	Alignment Forming board		04/07/2022 14:00	06/07/2022 19:00	53.0																												
EI	Wet End	Change cylinder guide plam Top & Bottom Wire	1	06/07/2022 09:00	06/07/2022 13:00	4.0																												
PD	Dry End	Remove canvas group 2 **ส่งเครนวันที่4/7 10.00	3	04/07/2022 09:00	04/07/2022 11:00	2.0																												
ME	Dry End	Change Duo stabilizer remove furniture	3	04/07/2022 10:00	04/07/2022 16:00	6.0																												
ME	Dry End	Change Duo stabilizer	4	04/07/2022 16:00	06/07/2022 07:00	39.0																												
ME	Dry End	Install furniture Duo stabilizer	3	06/07/2022 07:00	06/07/2022 16:00	9.0																												
PD	Dry End	Install canvas group 2	3	07/07/2022 09:00	07/07/2022 11:00	2.0																												
ME	Wet End	Change NipcoP Roll	3	04/07/2022 16:00	05/07/2022 00:00	8.0																												
ME	Wet End	Replace Lead in roll & Guide Roll Top Wire	3	05/07/2022 08:00	05/07/2022 18:00	10.0																												
ME	Wet End	นั่งร้าน Pick up DS,TS		04/07/2022 13:00	04/07/2022 17:00	4.0																												
ME	Wet End	Change hydraulic cylinder Pick up DS,TS	2	05/07/2022 08:00	07/07/2022 12:00	52.0																												
ME	Wet End	นั่งร้าน NipcoFlex		05/07/2022 08:00	05/07/2022 12:00	4.0																												
ME	Wet End	Change hydraulic cylinder NipcoFlex	2	05/07/2022 13:00	07/07/2022 12:00	47.0																												

## PAPER SHUTDOWN SCHEDULE PLAN

## Major Shutdown : 4-8 Jul 2021

[illegible]

## PAPER SHUTDOWN SCHEDULE PLAN

## Major Shutdown : 4-8 Jul 2021

Section	Location	Work description	Crane	PLAN			3	4-Jul				5-Jul			6-Jul			7-Jul			8-Jul		
				Time		Duration (Hrs.)	C	A	B	C	A	B	C	A	B	C	A	B	C				
ME*	Utility	ใส่ Blind หน้า Valve + เชื่อมท่อ valve		04/07/2022 10:00	04/07/2022 11:00	1.0																	
ME	Utility	เปลี่ยน valve + เชื่อมท่อ line น้ำ Absorption Chiller		04/07/2022 11:00	04/07/2022 18:00	7.0																	
EI	Utility	Change Valve cooling return Tank กระทบ Fresh water		06/07/2022 09:00	06/07/2022 12:00	3.0																	
						0.0																	
CRANE NO. 1																							
EI	Stock	Overhual motor screw press x3	2	04/07/2022 09:00	05/07/2022 15:00	30.0																	
EI	Wet End	Change cylinder guide plam Top & Bottom Wire	1	06/07/2022 09:00	06/07/2022 13:00	4.0																	
						0.0																	
CRANE NO. 2																							
PD*	Wet End	Remove Felt Top & Bottom	2	04/07/2022 02:00	04/07/2022 03:00	1.0																	
PD*	Wet End	Remove Wire Top (ถอด) & Bottom (ถอด)	2	04/07/2022 07:00	04/07/2022 11:00	4.0																	
ME	Wet End	Change hydraulic cylinder Pick up DS,TS	2	05/07/2022 08:00	07/07/2022 12:00	52.0																	
ME	Wet End	Change hydraulic cylinder NipcoFlex	2	05/07/2022 13:00	07/07/2022 12:00	47.0																	
PD	Wet End	Install Top & Bottom wire	2	07/07/2022 13:00	07/07/2022 17:00	4.0																	
PD	Wet End	Install Top & Bottom Felt	2	07/07/2022 17:00	07/07/2022 21:00	4.0																	
						0.0																	
CRANE NO. 3																							
PD	Dry End	Remove canvas group 2 **ส่งเครนวันที่4/7 10.00	3	04/07/2022 09:00	04/07/2022 11:00	2.0																	
ME	Dry End	Change Duo stabilizer remove furniture	3	04/07/2022 10:00	04/07/2022 16:00	6.0																	
PD	Dry End	Install canvas group 2	3	07/07/2022 09:00	07/07/2022 11:00	2.0																	
ME	Wet End	Change NipcoP Roll	3	04/07/2022 16:00	05/07/2022 00:00	8.0																	
ME	Wet End	Replace Lead in roll & Guide Roll Top Wire	3	05/07/2022 08:00	05/07/2022 18:00	10.0																	
ME	Dry End	Install furniture Duo stabilizer	3	06/07/2022 07:00	06/07/2022 16:00	9.0																	
		ให้สลับใช้เครนร่วมกับทาง ME																					
EI	Dry End	PM19GG36 change motor 132kw/6pole. (เฉพาะยกเข้า-ออก)	3	06/07/2022 07:00	06/07/2022 20:00	13.0																	
EI	Dry End	PM19GG37 overhaul motor 132kw/4pole.	3	06/07/2022 07:00	06/07/2022 20:00	13.0																	
EI	Dry End	PM19GG38 overhaul motor 110kw/4pole.	3	06/07/2022 07:00	06/07/2022 20:00	13.0																	
EI	Dry End	PM19GG39 overhaul motor 132kw/4pole.	3	06/07/2022 07:00	06/07/2022 20:00	13.0																	
EI	Dry End	PM19GG29 overhaul motor 15kw/6pole.	3	06/07/2022 07:00	06/07/2022 20:00	13.0																	
EI	Dry End	PM19GG26 overhaul motor 15kw/6pole.	3	06/07/2022 07:00	06/07/2022 20:00	13.0																	
						0.0																	
CRANE NO. 4																							
ME	Dry End	Remove Speedflow	4	04/07/2022 08:00	04/07/2022 10:00	2.0																	
ME	Dry End	Change Duo stabilizer	4	04/07/2022 16:00	06/07/2022 07:00	39.0																	
ME	Dry End	Remove Calender1,2	4	04/07/2022 10:00	04/07/2022 16:00	6.0																	
ME	Dry End	Install Speedflow Calender1,2 รวเครนจาก Duo	4	06/07/2022 07:00	06/07/2022 11:00	4.0																	
ME	Dry End	Bow Spreader Roll *checkหน้างาน	4	07/07/2022 08:00	07/07/2022 10:00	2.0																	
ME	Dry End	Paper Roll *checkหน้างาน	4	07/07/2022 10:00	07/07/2022 12:00	2.0																	
CHEMICAL PREPARATION																							
**	Chemical	MAINTENANCE TIME		04/07/2022 07:00	08/07/2022 12:00	101.0																	
STOCK PREPARATION																							

PAPER SHUTDOWN SCHEDULE PLAN

Major Shutdown : 4-8 Jul 2021

Section	Location	Work description	Crane	PLAN			3	4-Jul				5-Jul			6-Jul			7-Jul			8-Jul							
				Time		Duration (Hrs.)	C	A	B	C	A	B	C	A	B	C	A	B	C	A	B	C						
**	Stock	MAINTENANCE TIME		04/07/2022 07:00	08/07/2022 12:00	101.0																						
WET END																												
**	Wet End	MAINTENANCE TIME		04/07/2022 07:00	08/07/2022 12:00	101.0																						
DRY END																												
**	Dry End	MAINTENANCE TIME		04/07/2022 07:00	08/07/2022 12:00	101.0																						
WINDER & ROLL HANDLING																												
**	Winder	MAINTENANCE TIME		04/07/2022 05:00	07/07/2022 00:00	67.0																						