Well; it’s already the second month of the new year and although the pulp & paper business is still a bit slow in my neck of the woods, the first month has gone by quickly. How about you?

There’s only another couple of weeks to submit an abstract for the fall conference this upcoming October 17 – 19 at Reliant Center in Houston. I’ve already submitted two abstracts for the sixth edition of the “Web-Based HMI Panel” and the fifth edition of the Ethernet I/O panel. Think of a hot topic to present and go to the ISA 2006 website and submit an abstract. We’d like to have all three days filled up with pulp & paper sessions again this year, so we need your help.

There’s only another two weeks until the 2006 PUPID scholarship deadline. If you know of any deserving student, urge them to go to the PUPID website look at last years scholarship winners, fill out the application and email it to Mike Waller. UNLESS, of course, the $1000 isn’t worth their effort.

PUPID membership is maintaining the 700 level that it has been for the last couple of years. How can we get back to the 1996 membership level of around 1900 members? We’ve tried to give you a lot of free information relying on “the honor system”; but I guess we’ll have to take it off of the nonmember’s website and put it onto the member’s only website so people can’t get it for free, right? Let the PUPID webmaster, me, know what you think about the content.

The Spring Symposium will be with the IEEE Pulp & Paper IAS and the TAPPI Process Control, Electrical & Information will be June 18 – 23 at the Radisson Paper Valley in Appleton, Wisconsin. (See the papers & presenters later in this newsletter.) Mark it on your calendars.

Again at this year’s ISA Fall Conference, the ISA Joint A&T/I&S Luncheon will be on Tuesday and the PUPID Luncheon will be on Wednesday.

Well, I’ll sign off now until next time; keep watching the PUPID website for upcoming attractions!
Tuning Tip: Mid-Range Control Revisited
(“Coarse/Fine”)  

When a control loop requires high rangeability (maximum controllable flow/minimum controllable flow), a simple valve is not enough. The rangeability of a simple valve rarely exceeds 100 and in most cases, it is not easy to obtain more than 30.

To increase the valve rangeability, one can use 2 valves: a small valve to provide small flow and a large valve in parallel to ensure that high flow can be reached.

The controller (pressure, flow, level, etc.) sends its signal to the small valve. To manipulate the large valve, many strategies can be used but usually, the position of the small valve is selected:

1. Ramp up/down when the small valve is below/above 50%
2. Integral-only controller with SP=50%
3. Switches to start a ramp when the valve is near its limits
4. PID-gap controller

With solutions 1 and 2, the defects associated with the large valve will deteriorate the quality of the control. For example, if the large valve is 10 times bigger than the small one and has a stiction of 0.2%, this stiction will appear as 2% for the control loop.

With solution 3, disturbances in the line will probably be too high or too low.

Finally, with solution 4, the action on the large valve will depend on the process dynamics. Most of the time, the large valve is in a fixed position and moves only when the small one reaches its programmed limits. When this happens, the large valve opens gradually until the small one can fulfill the demand.

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Calendar of Events

Get a quick overview of the ISA PUPID events for 2006 by going to the Calendar at: [http://www.isa.org/~pupid/2006_PUPID_Calendar.htm](http://www.isa.org/~pupid/2006_PUPID_Calendar.htm)

60th Appita Annual Conference and Exhibition
April 3 – 6, 2006
Melbourne Convention Centre
info@appita.com.au

SPCI Conference 2006
January 30 – February 1, 2006
Stockholm University
Stockholm, Sweden
[http://www.spci.se/](http://www.spci.se/)

International Pulp Bleaching Conference
June 14 - 16, 2005
Stockholm International Fairs
Stockholm, Sweden
[http://www.paptac.ca/](http://www.paptac.ca/)

52nd IEEE Pulp & Paper Industry Application Society
June 18 - 23, 2006
Radisson Paper Valley Hotel
Appleton, WI

PIMA Leadership Conference
May 21 - 24, 2006
Disney’s Contemporary Resort
Orlando, FL

ISA President’s Fall Meeting
Houston, TX
October 14 - 16, 2006
Come meet your leaders & get involved!

ISA Expo 2006
Reliant Center, Houston, TX
October 17 - 19, 2006

Upcoming ISA Conferences & Exhibitions

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<tr>
<th>Year</th>
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<td>2007</td>
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<td>2008</td>
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<tr>
<td>2010</td>
<td>October 11 – 14</td>
<td>New Orleans, Louisiana</td>
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Extract from “Fundamentals of Process Control” by Michel Ruel.

This tuning tip was courtesy of Top Control [http://www.topcontrol.com](http://www.topcontrol.com)
ISA PULP & PAPER INDUSTRY DIVISION 2006 CALENDAR

You can see the online calendar at http://www.isa.org/~pupid/2006_PUPID_Calender.htm
WELCOME TO THE 26 NEW ISA PULP & PAPER INDUSTRY DIVISION MEMBERS since NOVEMBER 2005
WELCOME To New PUPID Members

Dr. Ky M. Vu
Ms. Lee Ann S. Hujanen
Pedro Henrique Pereira Rodrigues
Ms. Alpa Ashok Raut
Ms. Mugdha Girish Dalvi
Harshal Anil Bhave
Rajesh Shivaji Hirgude
Gaurav Prakash Vartak
Ms. Trupti Sudhakar Dalvi
Dr. Ky M. Vu
Ms. Lee Ann S. Hujanen
Pedro Henrique Pereira Rodrigues

Shailesh Sanjiva Pujari
Ravish Krishna Kotian
Ms. Pooja Deepak Gavade
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Senthamizh Selvan V
Yohann Gaudreault
Ms. Raja Ramya Nallamalli
B Anand
Keith Barr, Jr.
Shailesh Sanjiva Pujari
Ravish Krishna Kotian
Ms. Pooja Deepak Gavade

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Anthony Joseph Ortolani, Jr.
Edward Mifsud
Farhaan Ajmal Ansari
Dinesh Reddy Mullangi
Scottie D. Smith
James A. Stratton
Ron Mineo
David W. McNaughton
Anthony Joseph Ortolani, Jr.
Edward Mifsud
Where’s The Action? Who’s doin’ anything?

FOXBORO, Mass., Jan. 31, 2006 (Business Wire) - Invensys Process Systems has been selected by Boise Cascade to supply Triconex triple modular redundant (TMR) technology for upgraded turbine generator controls at Boise's DeRidder Packaging and Newsprint mill. Invensys will supply new controls for a GE 62-megawatt captive steam turbine generator, which is a critical power generation source for the pulping and papermaking processes at the mill. Located in Beauregard Parish, Louisiana, the DeRidder mill produces approximately 555,000 tons of linerboard and 448,000 tons or newsprint annually.

Invensys will supply a Triconex TS-3000 system for an integrated steam turbine governor and generator exciter control system for the GE back pressure, single extraction turbine. The control solution also includes the Trilogger event logging and playback station, Wonderware InTouch human machine interface (HMI) software, and a redundant current-sharing Eurotherm-based automatic voltage regulator. These elements comprise a turnkey control retrofit that replaces outdated generator control equipment.

Boise Cascade selected the Triconex solutions based on TMR reputation and reliability in installations across a variety of turbine-related applications. Located in the Mill Utility Department, the new controls will help Boise Cascade optimize the performance of this critical generation asset through high availability and reliability.

UPM selects Voith Paper to optimise coarse screening at Schwedt mill

HEIDENHEIM, Germany, Jan. 31, 2006 (Press Release) - UPM reports selecting Voith Paper to optimise high density cleaning and coarse screening at its Schwedt, Germany mill.

The existing single-stage high consistency cleaning will be modified to the HiPRO Protector system. The special feature of this two-stage system is its reduced sensitivity to process fluctuations. After commissioning in February this year, UPM expects to reduce heavy contaminants in the accepts and fibre losses both by 50%.

To reach the project goals, which call for not just a reduction in fibre losses with a simultaneous improvement in stickies removal but also an increase in production capacity, the coarse screening will be rebuilt to the so-called combi-screening system using the existing machines. With this combined hole and IC slot screening the accepts of the second and third hole stages are subsequently screened in a two-stage slot screening system. This strategy offers cost-efficient use of the technological advantages of IC slot screening in partial flows. Major advantages of this well-proven system philosophy are a high degree of operational reliability together with maximum screening efficiency and low fibre losses.

Voith will supply various screen baskets to reduce existing hole and slot width sizes, a MultiScreen pressure screen equipped with C-bar screen basket and MultiFoil rotor, as well as a Combisorter as final stage hole screen. The Combisorter is combined with a centrifugal cleaner for additional heavy contaminants removal. Two spiral feed screws provide for reject transport.

The scope of supply includes erection supervision and start-up assistance as well as basic process and control engineering.

The UPM Schwedt mill was founded in 1991 in Schwedt/Oder, and in 1993 a high performance Voith paper machine started up, equipped with the latest state of the art for newsprint paper production. Today, the mill belongs to the Finnish forestry and paper group UPM, with about 300 people employed at this location, and an annual production of 300,000 tons of high quality newsprint paper. UPM Schwedt borders directly on the German-Polish National Park "Unteres Odertal" in Uckermark/Brandenburg. An impressive feature of this, Germany's first "greenfield" paper mill, is its environmentally friendly paper production. Largely closed mill water loops, a fully biological effluent treatment plant as well as a modern combined heat and power plant handling residues confirm that industrial plants can safely be operated even in the immediate vicinity of a national park. The Schwedt newsprint is produced from 100% recovered paper.
Where's The Action? Who's doin' anything? (Continued)

Vacon opens new factory in Suzhou, China

VAASA, Finland, Jan. 24, 2006 (Press Release) - Vacon's factory in Suzhou, China, has moved to larger premises. Customers and partners from China and Asia as well as representatives of the Vacon Group's management and personnel attended the grand opening of the new site on January 24, 2006.

Vacon has been operating in Beijing, China, since the year 2000. In 2004, Vacon founded a factory in Suzhou, and the first AC drives were manufactured in March 2005. Along with the growing market potential, the premises soon became inadequate. Larger premises with an area exceeding 5000 m² were found in the neighboring building complex.

With the increasing production capacity at the Suzhou factory, Vacon will respond to the growing demand in Asia and the Far East. At the same time, the company has invested in Finland by increasing the production area at its Vaasa factory. The extension will be complete in February 2006.

Presence on the world's fastest growing market strengthens Vacon's position as a local supplier. The Suzhou factory also houses Vacon Competence Center that provides support, service, spare parts and units as well as training for customers in the Far East.

Managing director of the Vacon China factory, officially called Vacon Suzhou Drives Co. Ltd., is Jari Koskinen. He will also continue as vice president, production, Vacon Group, and as a member of the management team. At the moment, Vacon has more than 60 employees in China.

Metsa Tissue grows in Central-Eastern European markets with Tento acquisition

HELSINKI, Feb. 1, 2006 (Press Release) - Metsä Tissue, part of the Metsäliitto Group, has concluded an agreement to acquire the full ownership of Tento a.s., a leading tissue paper company in Slovakia. The acquisition requires the approval of the competition authorities.

"As manufacturing tissue paper products is one of Metsäliitto Group's core businesses, we are happy that this agreement has been successfully completed," says Kari Jordan, Metsäliitto Group President and CEO, and Chairman of Metsä Tissue Board of Directors.

Mikko Helander, President and CEO of Metsä Tissue, confirms: "The acquisition will strengthen the position of Metsä Tissue in Europe. Tento's local market knowledge and effective manufacturing, combined with our Polish operations, gives Metsä Tissue a strong local presence in the Central-Eastern European region. Together we can serve our customers even better."

"I am very pleased with Tento's progress during the last five years where we have been able to improve our efficiency and quality," says Jozef Antošík, President and CEO of Tento. "As part of Metsä Tissue, Tento will now have more resources to continue developing in the fast growing Central-Eastern European markets. Personally, I am very happy to offer my 25 years experience to support Metsä Tissue's growth in the fast changing European tissue paper market."

Once the acquisition has been approved, Jozef Antošík will own 15% of Metsä Tissue's shares, thus becoming the second biggest owner after Metsäliitto. He will also assume a position as a member of Metsä Tissue Board of Directors.

There are some 150 million consumers in the Central-Eastern European markets using nearly 700,000 tonnes of tissue paper per year. The annual consumption per capita is between 3-7 kg and due to the increase in the standard of living is growing by 5-10% - much faster than in Western Europe.

Tento is one of the leading tissue paper companies in Central-Eastern Europe. Its key products are toilet paper, household towels and handkerchiefs. The Tento brand has a leading position in the Slovakian and Czech tissue paper markets. The company's head office and mill are located in Žilina, northern Slovakia. Tento's turnover is Euro 90 million and it employs 600 people.

Editor’s Note: These press releases were provided by Paperloop at http://www.paperloop.com/
New Solution for Controlling Brown Stock Washers Utilizing Profit Controller Multivariable Predictive Control

By Rick Van Fleet, Honeywell Process Solutions, Phoenix, AZ

The following Powerpoint presentation was presented at the the 92nd Annual EXFOR 2006 Technical Conference at the Palais de Congres in Montreal, Quebec, Canada on Wednesday, February 8.
New Solution for Controlling Brown Stock Washers Utilizing Profit Controller™ Multivariable Predictive Control

Rick Van Fleet, Honeywell Process Solutions, Phoenix
Overview

- Background
- Control problem definition
- Control solution
- Implementation results
- Benefits
- Testimonial
Why Control Brown Stock Washing?

- Optimal washing with minimal shower water
- Minimize soda loss
- Optimize evaporator loading
- Reduce defoamer consumption
- Production increase

$\text{EFFLUENT TREATMENT SYSTEM}$
Brownstock Washing Objectives/Challenges

Objective

Produce clean pulp for bleaching or papermaking by separating black liquor from blown digester pulp. Must accomplish with an acceptable economic balance of:

- Minimal carryover of spent cooking liquor and dissolved lignin in pulp (minimal “soda loss”)
- Maximum solids in weak liquor (H₂O must be evaporated- $$)
- Minimal discharge to sewer (environmental permit issue)
- Minimal use of hot process wash water (energy-$$)
Case Study

- Simpson Tacoma Kraft, LLC Tacoma, WA
  - Nominal production 1100 ADSTD, with a peak of 1400 ADSTD
  - 2 lines of rotary vacuum washers installed in 1962-64.
  - 6m. X 20m. Chemi-Washer™ installed in 1991.
  - MACT requirements of handling HVLC gases meant that a major retrofit of rotary washers would be necessary.
  - Decision was taken to modify the Chemi-Washer to be 9m X 20m.
  - This resulted in shutting down both lines of rotary vacuum washers.
Project Objectives

- Among the typical reasons for selecting a horizontal washer i.e.:
  - Washing efficiency – less water
  - Lower dilution factor – higher solids
  - Reduced energy requirements
  - Ease of maintenance (few parts),
  - there was also a desire to reduce the operator requirements, and at the same time optimize the overall process.
- Automation became a key driver as the “alert operator” approach of constantly adjusting shower flows based on “watching” the conductivity, was not as effective as planned.
- Lack of blow tank level coordination was often limiting production.
- A “swing” set of evaporators was still be used 3-5 days per week.
Control Solutions

**Profit Controller™ – Model-Based Control**

**Range Control Algorithm – Next generation technology**
- Funnel based
- Minimum MV move
- Optimal response trajectories
- Built in robustness and stability
- Ease of tuning, no move suppression

**Built-in Local Optimization**
- linear and/or quadratic objective function
- Optimization speed tuning parameter
- MV/CV economic values
- Accepts ideal target values from outside applications
- Constrained optimization

**“One-knob” tuning**
- Dynamic state estimation capability
- On-the-fly gain updating
Model Identification Tool – Profit Stepper

- Integrated data collection and online model identification
- State-space identification techniques
- Visual indication(s) of test progress
- Multiple disturbance variable handling
- Automated test logging
- Enables targeted and efficient controller maintenance

25 – 60% Reduction in Test Time
Controller Design

- The washing process is inherently a multivariable process.
- Several interactions exist such that normal single loop (PI or PID) strategies, cannot handle the job.
- Two controllers were implemented directly to the washer controls; one to control the stage pressures (13 CVs X 7 MVs) and one to control shower flow and filtrate conductivity (5 CVs X 6 MVs)
- A third controller was also added to the blow tank consistency loop.
Implementation

- Performed baseline variability study
- Checked individual loop performance
  - Tuning performance
  - Valve stiction
  - On-going maintenance
- Performed step or bump tests on process
  - Use product quality and washing efficiency as indicator, as well as liquor solids.
- Operator training was essential
- Training using “warm mode” or simulation
- Commissioning and documentation completed.
Model Structure
Model Structure
RESULTS
Shower Flow Before and After

Before

Avg. 1222 gpm

After

Avg. 1076 gpm
Washing Results

SHOWER FLOW

BEFORE AVG.  1222 GPM
AFTER AVG.  1076 GPM

- additional benefits include:
  - improved operator effectiveness
  - improved evaporator throughput
  - reduced soda carryover
  - less defoamer
  - consistency improvement
Weak Black Liquor Inventory Management

Before

After

EXFOR 2006

Alkaline Pulping
MPC for Brownstock Washing
Benefits of Improved Washing Control

- Reduce operations demand
- Optimize evaporator loading
- Reduce chemical carryover to bleach plant and paper machine
- Minimize chemical losses to sewer
- Lower use of defoamers
- Increase production

Savings in the range of $2.00/ADT
Highlights

- Application of MPC on washer line allowed mill to reduce manpower requirements as projected.
- Rapid implementation (3-4 days) made possible by powerful on-site modeling tool.
- Built in simulator assisted in controller verification and operator training.
- Overall operations showed improvements including a reduction of shower water usage, an increase in solids to the evaporators which resulted in the ability to keep #3 evaporators offline more frequently resulting in steam savings of 60,000 lbs/hr.
- Total project savings at $500,000/yr.
Customer Testimonial

December 22, 2005

Honeywell
First Place Plaza, Suite 150
12503 S.E. Mill Plain Blvd.
Vancouver, WA 98684

Mr. Mike Davis:

Attached are my comments on the use of Honeywell’s Profit Controller in our operation.

“By teaming with Honeywell and applying Profit Control MPC to our Chemiwasher operations, we achieved 2 important goals that otherwise would have not been possible. First, was the reduction in usage of washing water by 105 GPM. This was a 10% reduction in water usage and more importantly resulted in $500k annually of energy savings. Second and equally important, the MPC increased the overall level of automation and controls sophistication of the washing system. The MPC now makes most of the critical control changes that were once relegated to human operators. This has freed up the operator to focus on other activities and allowed the mill to easily achieve labor reductions. I am very confident in the MPC controls and am already planning on teaming with Honeywell on implementation of this technology in other areas of our pulp mill.”

Sincerely,

Matthew Hinck
Fiber Processing Manager
Acknowledgments

* Matt Hinck – Simpson Tacoma Kraft, LLC
  Fiber Processing Manager
* Mike Blitz – Simpson Tacoma Kraft, LLC
  Process Engineer
* Lance Johnson – Honeywell for controller
design and implementation.
Hello and welcome to the first of what will be regular newsletters to keep you aware of what is happening as we prepare for ISA EXPO 2006 this fall.

The program this year will continue the good work that has been done in the past and our surveys both at the event and after indicate is what the people participating would like to see continued/expanded and that is the use of relevant Themes.

As a result we have selected the themes identified on the right for ISA EXPO 2006 and the people listed below each theme have agreed to serve as Committee Chair for that Theme. Each Theme also has an associated committee of “Topic Chairs” to assist them in preparing what promises to be an excellent technical event in October.

In addition to the themes we are also planning several other new activities this year to make your ISA experience that much better. Details will be released on this and the other new activities as these ideas are finalized.

The other BIG change this year is that we are working to have all the presentations have an End User perspective sharing with others how they made technology work.

Lastly, we will also be minimizing the number of parallel sessions being programmed so that those papers you do see will not only be top notch but with a receptive audience.

This newsletter is meant to be a tool to help all of us work together to make ISA EXPO 2006 the best conference and exhibition in years, however to make that happen requires that we all work together in promoting the event. Towards that end, watch for materials you can use in your newsletters on the Newsletter editor resource page.

We also want to be sure that this event is inclusive and recognizes the contribution being made by everyone – especially Divisions so the committee will be sharing more on that with each of you at the A&T/I&S meetings in Orlando this April.

If you have any questions, comments or concerns please contact any of the ISA staff listed or me at iverhappen@member.isa.org.

ISA EXPO 2006 Technical Program Committee

Program Chair
Ian Verhappen

Environmental Controls
Jim Tatera – Tatera & Associates

Industrial Communications
Ian Verhappen – Syncrude Canada Ltd.
Ed Ladd – Hart Communication Foundation

Process Automation
Nicholas Sands – DuPont

Safety & Security
Paul Gruhn – ICSTriplex

Systems Integration
Joe Neyer – Maverick Technologies

We are also well assisted by the following staff at ISA Headquarters:
Dale Lee – dlee@isa.org
Matricia Smith – msmith@isa.org
Tracey Berrett-Noble – tberrett@isa.org

ISA EXPO 2006 Deadlines

Here are the critical dates for this year’s event:
- Issue Call for Papers – February 2006
- Abstracts Submittal – April 2006
- Program Finalized – PSM
- Papers for Review – July 2006
- Final Papers – September 2006
- Conference – October 2006

For more information on the event, visit www.isa.org/isaexpo2006
LETTERS TO THE EDITOR

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Send your comments on this newsletter to the ISA PUPID Technical Discussion Forum & “get something started”!

You can reach the site at http://216.27.72.194/shellcgi/lyris.pl?enter=pupid&text_mode=0&lang=english or by going to the PUPID or the main ISA websites and looking for the “ISA Technical Divisions”

LINKS TO RELATED WEBSITES

ISA PULP & PAPER WEBSITE
http://www.isa.org/~pupid/

ISA PULP & PAPER TECHNICAL DISCUSSION FORUM
http://www.isa.org/scripts/lyris.pl?enter=pupid&text_mode=&lang=english

ISA TECHNICAL CONFERENCE SESSION SCHEDULE
http://www.isa.org/Template.cfm?Section=Conferences_and_Exhibitions&templat e=/taggedpage/conferencesbydate.cfm&icid=61

PULP & PAPER RESEARCH INSTITUTE OF CANADA
http://www.paprican.ca/

TAPPI
http://www.tappi.org/

PIMA
http://www.pimaweb.com/

AMERICAN FOREST AND PAPER ASSOCIATION
http://www.afandpa.org/

NATIONAL SOCIETY OF PROFESSIONAL ENGINEERS
http://www.nspe.org/

SWEDISH ROYAL INSTITUTE OF TECHNOLOGY
http://www.pmt.kth.se
http://www.hut.fi/English/

HELSINKI UNIVERSITY OF TECHNOLOGY
http://www.hut.fi/English/

TECHNICAL ASSOCIATION OF THE AUSTRALIAN AND NEW ZEALAND PULP &AMP PAPER INDUSTRY (APPITA)

AUSTRALIAN PULP & PAPER INSTITUTE

ISO STANDARDS TECHNICAL COMMITTEE LIST
http://www.iso.ch/iso/en/standardsdevelopment/tc/list/TechnicalCommitteeList/

ISA STANDARDS COMMITTEES LISTSERVER
http://www.isa.org/shellcgi/lyris.pl?site=isa&page=topic&topic=standards+committees&text_mode=0&lang=english

QUICKIES

ISA PULP & PAPER TECHNICAL DISCUSSION FORUM
Anybody (not necessarily an ISA or PUPID member) can subscribe to the PUPID Pulp & Paper Technical Discussion Forum. To subscribe, go to the PUPID homepage at http://www.isa.org/~pupid/ , select “Pulp & Paper Technical Discussion Forum” in the pick box, click ”Go”, and enter you email address and a password.

ISA EMAIL ADDRESS FOR ALL MEMBERS
Any ISA member can register for a free email address and online mailbox. If you set it up, your ISA email address will be youname@member.ISA.org. To register, go to http://www.isa.org/membership/benies/ , and follow the registration instructions.

ISA PUPID CALENDAR
Get a quick overview of ISA PUPID events for 2002 by going to the Calendar at:
http://www.isa.org/~pupid/2002_PUPID_Calendar.htm
CANADA CORNER

Nothing from anyone there this time!

CENTRAL & SOUTH AMERICAN CORNER

Nothing from anyone there this time!

FAR EAST CORNER

Nothing from anyone there this time!

FROM THE LAND OF THE MIDNIGHT SUN

Nothing from anyone there this time!
2006 Pulp & Paper Industry Division Officers

Director / Webmaster:
Brad S. Carlberg, P.E.
BSC Engineering
(251) 621-9405
(251) 621-5139
brad.carlberg@bsc-engineering.com

Past Director:
Steve Moon, P.E.
Documentation & Eng’g Services
stevemoon@desllc.net
(205) 822-8787
(205) 822-8637

Former Director:
John Murray
Mead Westvaco Paper
jm9@mead.com
(740) 772-3488

Secretary / Treasurer:
vacant

Standards & Practices
vacant

Advisory Committee Chair
Larry E. Wells, P.E.
Georgia Pacific Corp.
l ewells@gapac.com
(404) 652-4604
(404) 584-1466

Programs / H&A:
Marty Schweers, P.E.
Kellogg Brown and Root, Inc.
marty.schweers@halliburton.com
(251) 450-7721
(251) 450-7247

Education Co-Chairman
Michael H. Waller, P.E.
Miami (of Ohio) University
wallermh@muohio.edu
(513) 529-2205
(513) 529-3841

Education Co-Chairman
Kaichang Li
Oregon State University
kaichang.li@orst.edu
(541) 737-8421
(541) 737-3385

Paper Review Coordinator
Tommy Thompson, P.E.
Simons Engineering, Inc.
tommy.thompson@amec.com
(770) 370-3200
(770) 370-3646

Environmental Chairman
H. Pierce Rumph, P.E.
Orion CEM, Inc.
hprumph@compuserve.com
(770) 458-4535
(770) 451-1512

Advisor
Richard E. Britton, P.E.
Retired – International Paper
richardbritton1@comcast.net
(251) 342-0998
(251) 342-0998

Newsletter Editor
Dr. Leoncio Estevez-Reyes, P.Eng.
Schweitzer-Maudit – Spotswood Mill
(732) 723-6135
leoncio_estevez-reyes@swm-us.com

ISA Pulp & Paper Industry Division
P.O. Box 12277
Research Triangle Park, NC 27709

ADDRESS CORRECTION REQUESTED