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54 **Web forming method and apparatus.**

57 A method for forming a paper or paperboard web from a fibrous material in the wire section of a paper making machine or equivalent machine comprising a bottom wire loop (2;102) with the main portion of its top run being horizontal or substantially horizontal, and a top wire loop (10;110) working in conjunction with the bottom wire loop; wherein in the method fibre slurry coming out of the headbox (1;101) of the paper making machine is fed to the first part (2a; 102a) of the top run of said bottom wire loop (2;102), which forms the first dewatering zone after which the partly formed fibre layer is led to the second dewatering zone, in the area of which said top wire loop (10;110) moves to cover said partly formed fibre layer in such a way that water removal from the fibre layer continues at least in two stages in the area of said second dewatering zone, whereupon the top wire loop (10;110) is separated from the nearly formed web (W) that is led to follow the run of the bottom wire loop (2;102) forward to the next processing stages of the web (W), wherein the method is **characterized** in that in the single-wired dewatering zone (2a;102a), after the initial water removal is carried out through the bottom wire (2;102), water removal through the bottom wire (2;102) is prevented by means of an element group (9; 109) operating in contact with the inner surface of the horizontal top run of the bottom wires; that in said

water-removal prevention area water is removed from the web (W) through the top wire in the first stage or stages of the double-wired second dewatering zone, which stages comprise a relatively long, planar wire table extending from the headbox to the forming roll (6 in Fig. 1), or from the headbox to the last supporting element (109 in Fig. 2); and that after the first dewatering stage or stages of the double-wired zone water is removed in a curved double-wired dewatering zone (b) (Fig. 1) or zones (R₀, C) (Fig. 2), after which the web (W) is led to follow the bottom wire (2;102).

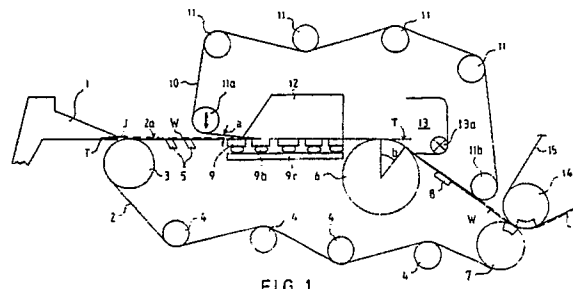


FIG. 1



EP 89 31 2431

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
A	EP-A-136000 (BELOIT) * the whole document * ----	1-4, 9	D21F1/48 D21F9/00
A	DE-A-2808939 (VOITH) * the whole document * ----	1, 2, 7	
A	DE-A-3315023 (VALMET OY) * the whole document * ----	1, 2	
A	FR-A-2510153 (FELDMUHLE) * the whole document * ----	1, 6	
A	WO-A-8303109 (VALMET OY) * the whole document * ----	1	
A	DE-A-3329833 (AHLSTRÖM OY) * the whole document * ----	10	
P,A	WO-A-8904397 (SULZER-ESCHER WYSS) * the whole document * -----	1, 2, 7, 9	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			D21F
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 21 SEPTEMBER 1990	Examiner DE RIJCK F.
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