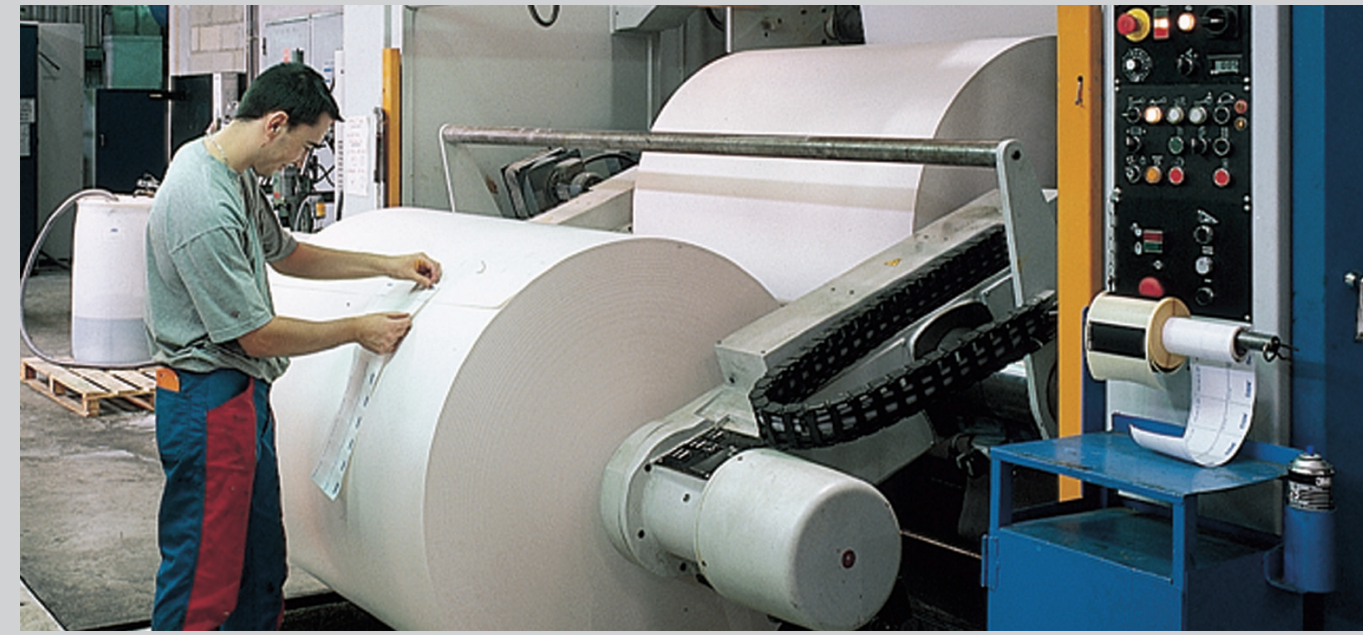


1 REMOVE END COVERS



- ⌚ If a knife is used, care should be taken not to penetrate the roll end.
- ⚠ The cutting action with the knife should always be away from the person using it to minimise the risk of injury if the knife slips. Always return the knife to a scabbard when not in use.
- ⌚ Inspect the roll ends for damage.
- ⌚ Remove core plugs (if fitted) and inspect core for damage.
- ⌚ For pasters with chucks, the outer 10-15 cm (4-6") must be in good condition.
- ⌚ For pasters with shafts, the core must not be crushed or blocked.

3 LOAD ROLL ON TO PASTER



- Safety first
- ⚠ Roll loading safety, check:
 - Roll arms are adjusted to the correct width for the roll.
 - Make sure chucks are fully retracted and free of debris before loading and roll brake switched on.
 - Verify chucks are fully inserted on both sides.
 - Chuck jaws are fully expanded into core. If soft cores are used there is a risk that the chucks will settle into core.
 - If manual expansion tools are used ensure they are removed and replaced in their storage rack immediately after they have been used.
- ⚠ Make sure that the roll unwind direction is correct before loading.
- ⚠ On-paster preparation is recommended if there is no roll handling system installed as this minimises damage, waste and is ergonomically more efficient.
- ⚠ Before operating the paster, all staff must know the manufacturer's safety regulations and operating instructions.
- ⚠ Arm rotation safety: Before splicing, and during manual arm rotation, the operator must verify that rotation path is clear of personnel and foreign objects.
- ⚠ Emergency stop devices: All staff must know their location and function.

■ Chuck pasters

- ⚠ Roll loading safety, check:
 - Roll arms are adjusted to the correct width for the roll.
 - Make sure chucks are fully retracted and free of debris before loading and roll brake switched on.
 - Verify chucks are fully inserted on both sides.
 - Chuck jaws are fully expanded into core. If soft cores are used there is a risk that the chucks will settle into core.
 - If manual expansion tools are used ensure they are removed and replaced in their storage rack immediately after they have been used.
- ⚠ Make sure that the roll unwind direction is correct before loading.

■ Expanding shafts

- ⚠ Expand the shaft before the roll is loaded on to the paster otherwise the roll will be off centre.
- ⚠ Off centre rolls generate vibrations and tension variations during unwinding causing increased risk of web break, creasing and miss register.

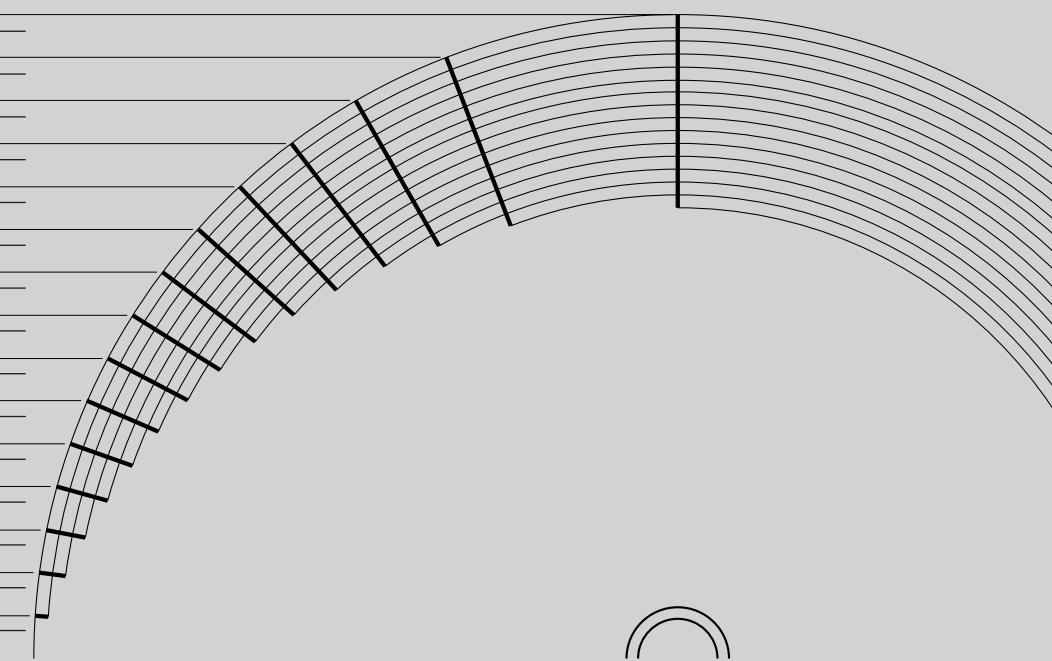
5 SLAB OFF WHITE WASTE, RECORD & DISPOSE

■ Stripping waste as % of total paper on roll

Frequently more layers are stripped off than are really necessary.

- ⌚ Pull individual wraps from the roll, inspecting the edges and belly for damage as you do so. If both are OK, prepare the splice. If further stripping is needed, tear the top layers by hand before introducing the stripping tool. Once the roll is damage free, prepare the splice.
- ⚠ Failure to identify end damage may result in a web break during production.
- ⚠ Risks to accidental damage to the white paper are increased.
- ⚠ Over zealous use of the stripper will result in unnecessary waste.

DEPTH OF DAMAGE	ROLL 1000 MM/40"	ROLL 1250/50"
100 mm 3,94"	36,36%	29,63%
90 mm 3,54"	33,09%	26,90%
80 mm 3,15"	29,74%	24,12%
70 mm 2,76"	26,39%	21,28%
60 mm 2,36"	22,79%	18,40%
50 mm 1,97"	19,19%	15,46%
45 mm 1,77"	17,36%	13,97%
40 mm 1,57"	15,52%	12,47%
35 mm 1,38"	13,65%	10,96%
30 mm 1,18"	11,76%	9,43%
25 mm 0,98"	9,85%	7,89%
20 mm 0,79"	7,92%	6,34%
15 mm 0,59"	5,97%	4,77%
10 mm 0,39"	4,00%	3,19%
5 mm 0,20"	2,01%	1,60%



2 RECORD INFORMATION

■ Read bar code and weigh



This information provides essential data on paper use and allows rolls to be traced in the event of paper problems.

4 REMOVAL OF WRAPPER



- ⌚ Use plastic/wooden roll stripper when removing the belly wrapper (do NOT use a knife). Dispose wrapper with brown waste.
- ⚠ Removing the belly wrapper with a knife is less controllable and can result in excess stripping.

When unwrapped the roll acts like a released spring and will tend to loosen. This phenomena will put additional tension on to splices prepared in advance. Cold rolls tend to expand more when warming up.

- ⌚ Premature removal of the wrapping increases the risk of dimensional instability from atmospheric variations, and accidental damage to the white paper.

During the splice cycle there will be a change in tension profile and any weak spots in the web or splice will be subjected to extra stress and a web break or splice failure may occur.

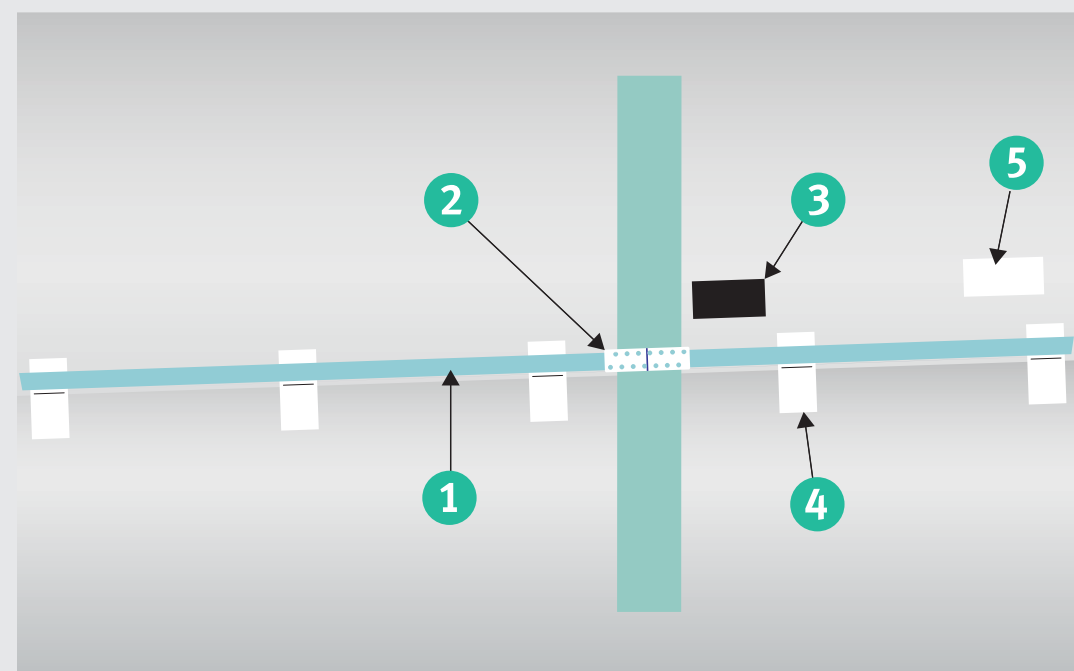
- 1 **Burst splice:** When the new roll bursts open prior to splicing.
- 2 **Failed splice:** When the new roll does not paste to the expiring web.

Mis-splices: Any failure of the splice during the cycle from when the splice arms start to move for zero speed festoon begins to fill to the moment the splice leaves the folder, without disturbing the web, causing a press stop or excessive waste.

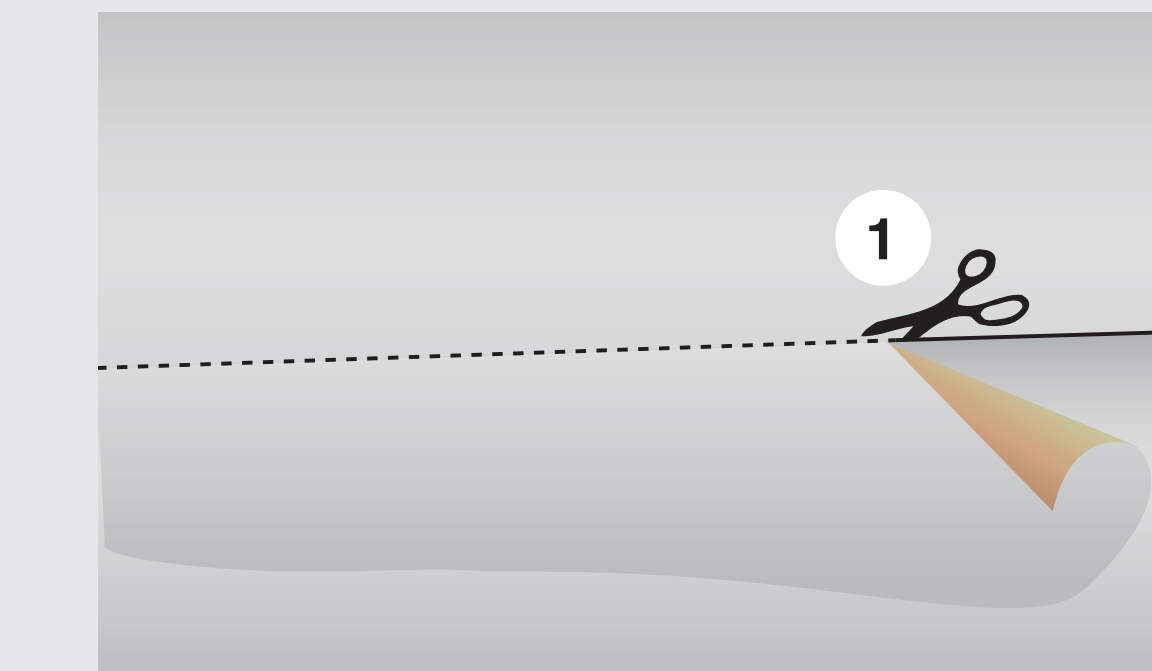
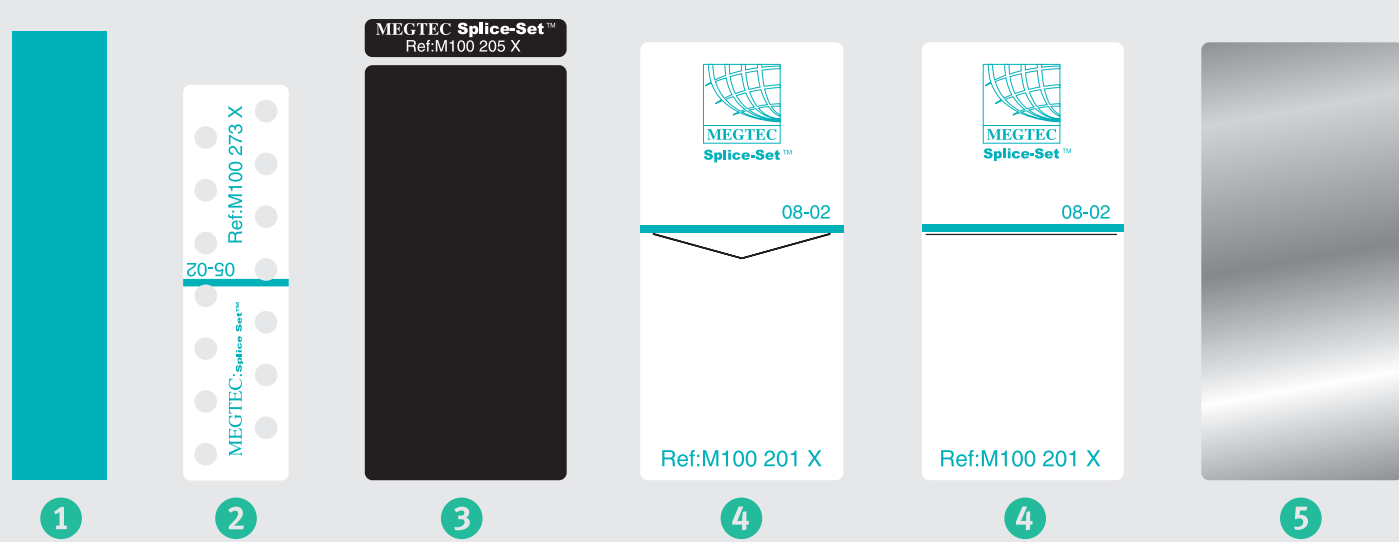
6 FLYING PASTER STRAIGHT SPLICE PREPARATION

Tape and Tab selection

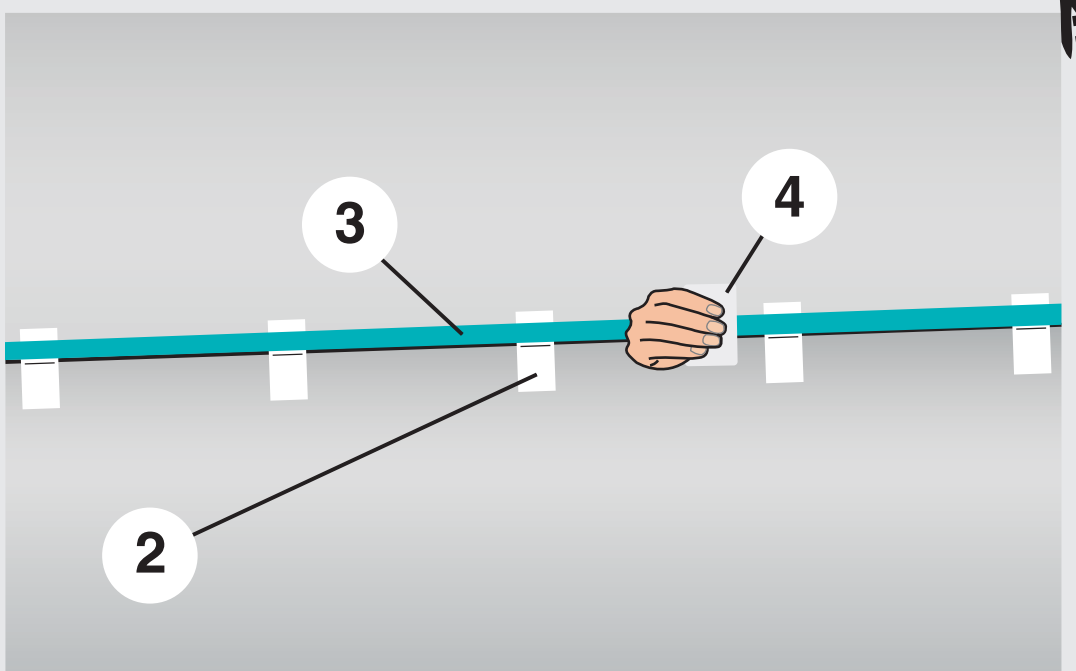
- 1 Double sided PSA tape
- 2 Belt bridges
- 3 Splice detection tabs
- 4 Splice rupture tabs
- 5 Folder exit detection tabs



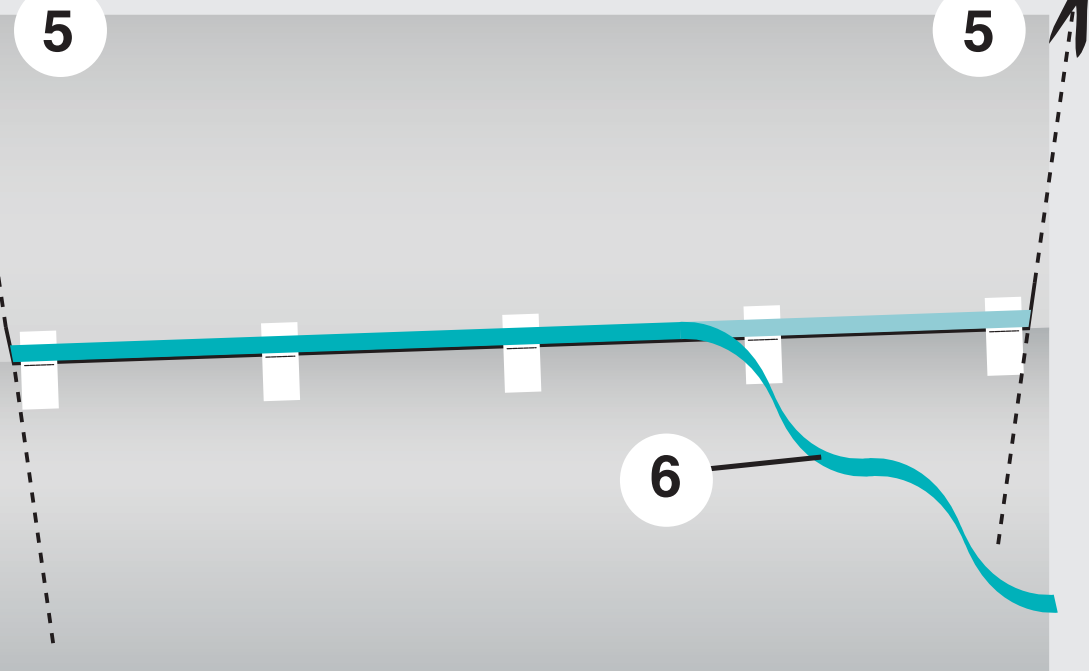
Type of plice tapes and tabs.



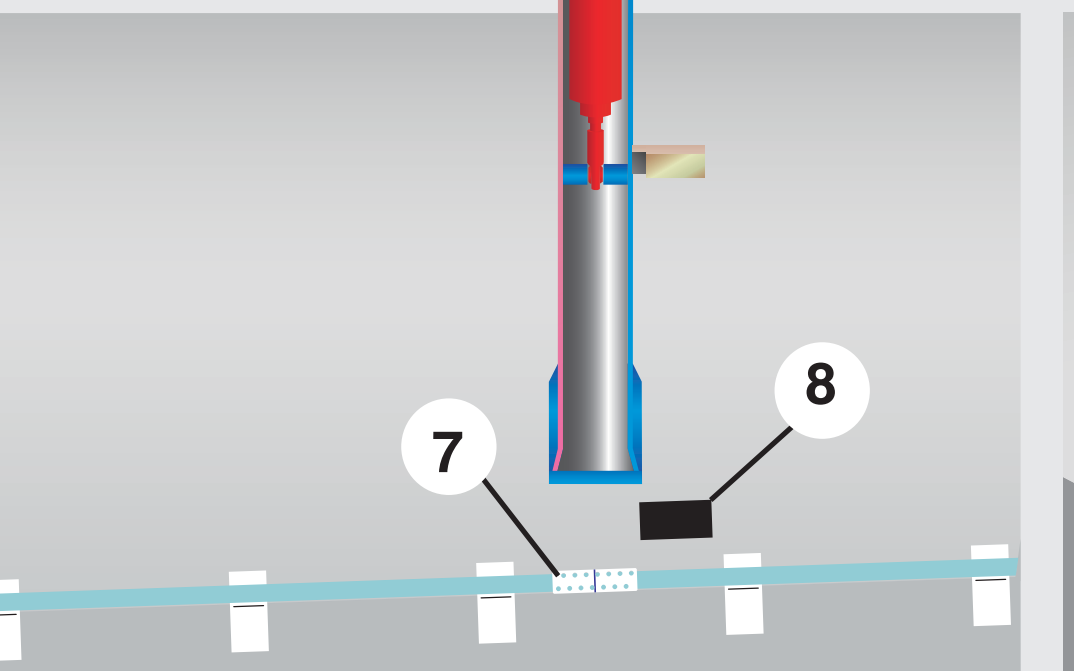
- 1 Apply the brake as required to stop the roll rotating during preparation. Cut out the splice profile in the first paper layer (spire). Bend the first paper layer (spire) and slit along the folded edge. Expel air between the outer and inner spires so that they lie smoothly.
- 2 Wrinkles cause tearing and separation of the top layer from the surface during acceleration.
- 3 Use rupture tabs to close the roll system.
 - ⌚ Do not apply tabs too tightly or they may break in advance of splice.
 - ⌚ Always close the top of the splice pattern to prevent creating air pockets which can cause splice failure.
 - ⌚ Incorrect rupture tab position increases breaking strength and may result in a failure to open.
 - ⌚ Use line printed on the tab to position adhesive-free zone under the line pointing to the inner spire of the roll for easy opening at pasting.



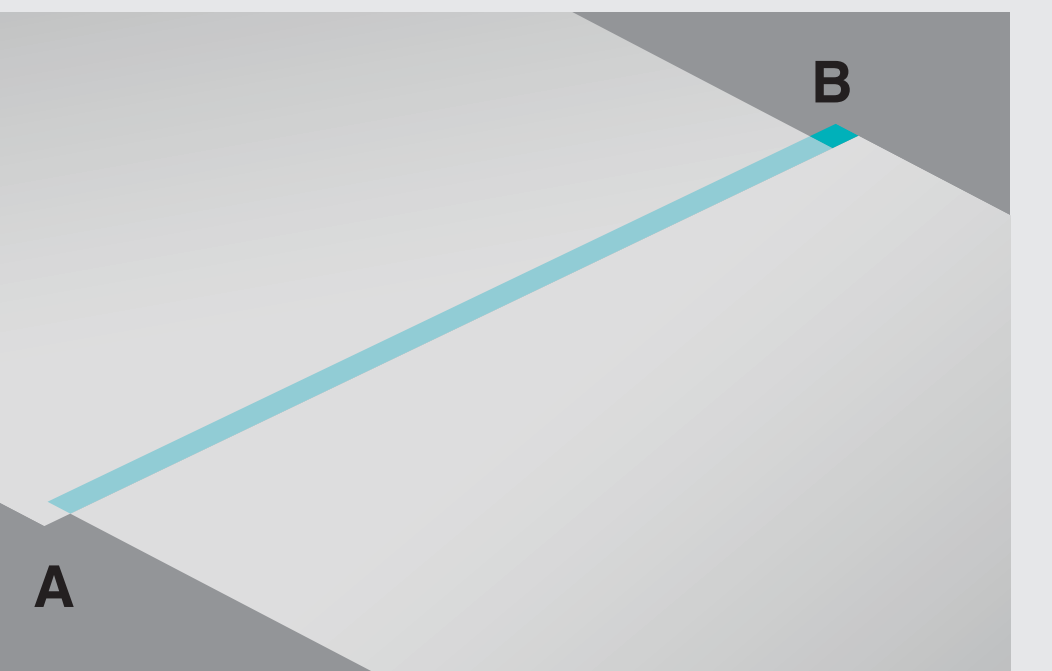
- 1 Apply the tape along the splice profile 2mm (0,08") from the edges on all three sides.
 - ⌚ Do not remove protective cover of tape.
 - ⌚ Optimum adhesion requires pressure to be applied across the total width and length of the tape after positioning. Use a tape applicator (plastic card) to assure correct pressure.
 - ⌚ Do not allow tape to overhang the roll edges.
 - ⌚ Do not apply tape in the acceleration belt area width +10 mm/0,4" unless using a bridge label to protect the tape.
 - ⌚ Do not apply tape/tabs in the path of folder slitter wheel path (possible web break of a ribbon).



- 1 Use scissors to cut off "ears" of leading edge next to the external tabs to improve edge profile.
 - ⌚ Belt driven pasters: Remove PSA tape protective strip 1 and apply belt bridge tab in path of acceleration belt, make sure tape width is fully covered 2.
 - ⌚ Do not use tape liner cover because its adhesion is so low that it will be torn off by the belt which will then destroy the splice preparation.
 - ⌚ Holes in belt bridge tab allow correct positioning on to exposed PSA tape, the width of which must be fully covered.



- 1 Apply detection label correctly positioned for optimum tail length. Apply aluminium folder exit detection label if required. Release paster brake. Rotate roll to avoid dust and moisture condensation falling on to tape.
 - ⌚ Dust and condensation on the tape surface reduces its adhesive qualities. If possible, only remove the complete protection strip/liner from the adhesive just prior to the splice cycle.
 - ⌚ Set lateral position of new roll to align it with position of running roll to avoid the high-risk of splice failure or web break.



- A- Overlapped paper edge sticks to ink build-up on blanket edge tearing the web.
- B- Exposed adhesive will stick on to rollers or blanket causing a break.

