

A Guide to Avoiding Roll Backs and Cigars

What are they?

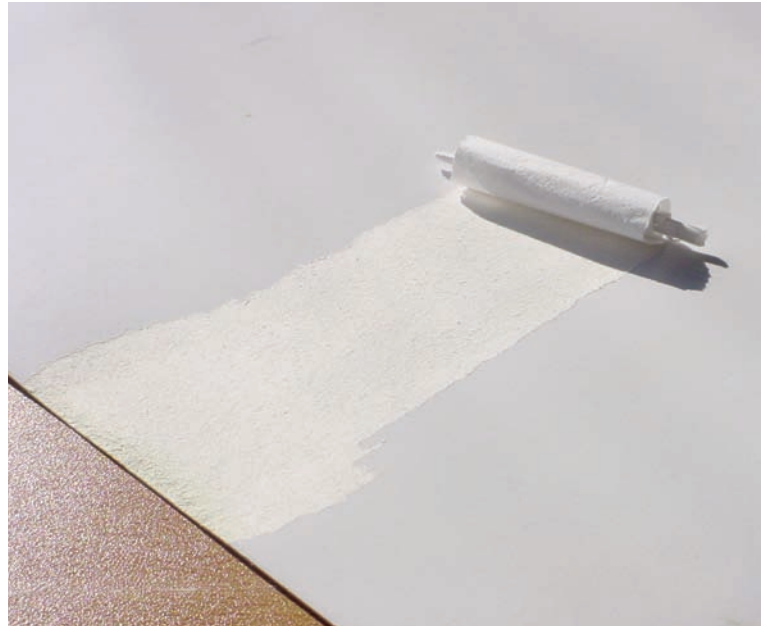
Roll backs or cigar delaminations occur mainly on board weights, particularly multiply products, where a strip of the top or reverse side surface is torn from the edge and tightly rolled back across the sheet.

What can they do?

Sheets with roll backs or cigars invariably damage the offset blankets if they go through the litho press.

How can they happen?

- 1 When manual stacking, the leading edge of the handful being moved can catch the edge of the top sheet on the new stack. It may be the corner or near the middle, where it sags, and there is edge to edge contact over a small area. Either sheet may be damaged on the edge and the forward motion of stacking tears back a strip of the surface into a tight roll.
- 2 When sliding piles across a surface and the bottom sheet catches on a protrusion.
- 3 By a worn guillotine cutting stick where the edge of the bottom sheet is caught in or catches the groove as the pile is moved.
- 4 When anything is pushed into a stack without lifting the pile to allow entry, eg a wedge.



Where do they happen?

Our experience has shown that more potential hazards occur when material is handled before going to press – for example, using a knife to pierce the wrapping, guillotining and re-stacking, loading the press, using wedges and pre-load systems. Roll backs or cigars are unlikely to occur at the mill as most production is fully automated using sheeters instead of guillotines, and stackturners and automatic wrapping machines to avoid manual handling.

What should I do?

Once detected, to avoid further blanket damage inspect the remaining stock before proceeding.