Agenda

- Typical packaging for plastic films
- Cost of packaging
- Types of damage
- Keys to proper roll handling
Suspended Packaging

- Packaging types
  - **Domestic**
    - Single or Double Layer
    - Shipped in Trailer
  - **Overseas**
    - Single or Double Layer
    - Shipped in Container
Vertical Bulk Packaging

- Most Economical for small OD’s and small width’s
- Maximum weight is 50 lbs per roll
Nested Cradle Packaging
# Example of Packaging Costs

The following figures represent a nominal, average cost to package a typical pallet of rolls of OPP film.

<table>
<thead>
<tr>
<th>Description</th>
<th>Cost</th>
</tr>
</thead>
<tbody>
<tr>
<td>4 roll pallet of suspended 23” OD rolls</td>
<td>$50</td>
</tr>
<tr>
<td>1 roll pallet of suspended 32” OD rolls</td>
<td>$34</td>
</tr>
<tr>
<td>4 roll nested cradle pallet 23” OD rolls</td>
<td>$33</td>
</tr>
<tr>
<td>81 roll Vertical Bulk pallet 12½” OD rolls</td>
<td>$60</td>
</tr>
</tbody>
</table>

*This is what it costs to ensure a pallet of rolls will arrive at a customer in good condition.*
Field Problems

- Transit Damage
- Warehouse Damage
- In Plant Damage
- Storage and Handling
Transit Damage
Warehouse Damage

Loose & broke end boards
Keys to Proper Roll Handling

NO Karate necessary

• Avoid kicking the end boards off a slit roll

• Dropping damages slit rolls
  – Causes press problems such as tension variation and tear outs from spot blocking or damage
  – Also causes crushed cores – a problem to chuck

• If a hoist is unavailable, at least cushion the fall with a thick pad

• Never let the top roll on a multi-level pallet drop to the floor
Removing end boards
Damage from Dropping a Roll

Crushed Core
Keys to Proper Roll Handling

Treat your edges with care . . .

- Avoid storing partial or unused rolls on their ends
  - Damage to roll edges causes web breaks and machine downtime

- Avoid pushing on or giving a sharp blow to sides of a slit roll
  - Not a good test for loose wind detection
  - May cause telescoping
  - May damage the slit roll edges
Avoid stacking rolls on their ends

Stacking rolls on their ends may cause damaged edges resulting in web breaks when remounted on the press.
Keys to Proper Roll Handling

Re-palletize partial or rejected rolls

- Avoid allowing slit rolls to sit on floor with end boards removed.

- Avoid unsupported horizontal storage
  - Causes flat spots and or spot blocking

- Avoid laying partial or unused rolls on top of other rolls on a pallet
  - Causes flat spots
  - Web tension variation

- Must return defective film in good condition
  - Allows us to evaluate the defect for corrective action
Flat spots from roll handling cart

Current

Recommended

Note: The larger the diameter of the roll the wider the flat spot
Roll on a flat surface

Starring

Flat spot
Use cradles to restore rolls
Slit roll Abuse

One of the most common causes for material damage is abuse between the warehouse and converting machinery.

Dos and Don’ts

Rolls should never be placed on a pallet unsupported
Rolls should never be rolled on the floor to the machine
Damage from sitting on pallet unsupported
Debris on floor that will damage roll
It required removing 21 lb of film to get to film good enough to convert.
Screw Damage to 1000 lb roll

It required removing ¼-in of film (35+ lbs) to get to film good enough to convert.
Loose debris can contaminate printing plates

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Recap

- Do not roll slit rolls on floor.
- Protect the ends of rolls from damage.
- Keep rolls off of flat surfaces.
- You have control of waste from improper roll handling.
Questions?