



## About This Helpful Hint

This "Helpful Hint" is intended to address "Cutting Problems". The problems one might encounter during or after cutting can be devastating to their customer and cause the customer to consider an alternate supplier. Gaska Tape wants to take a proactive position in an effort to help circumvent problems before they occur. Your loss is our loss.

## Considerations

- **Paper Problems** - Paper and water don't mix. Therefore, when we cut material that has a paper liner we have to control the amount of water used for lubrication. On some special occasions we don't use any water at all. We use a light mist of silicone spray for lubrication.
- **Blade Maintenance** - Sharpening after every cut, removing nicks, blade run out, and cleaning the blade can prevent rough cuts resulting in a customer complaint.
- **Ordering The Correct Type Of Blade Is Critical** - The thickness of the blade, the bevels and angles are very important when buying blades. Some blades just don't cut very well at all, especially as they get smaller. This is why Gaska Tape sells cutting blades that meet our stringent requirements.
- **Cycle Speeds** - Chuck and blade speeds may need to be varied to produce an optimum cut (a suggested starting point is 300 rpm).

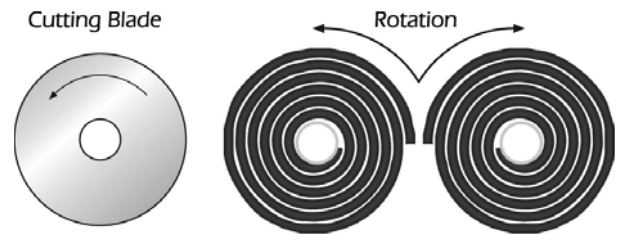
Another very important factor in successful cutting is statistical process control (SPC). Are your machines capable of holding a given tolerance? Gaska Tape has determined that the semiautomatic Lever machines will hold a tolerance of +/- .063 on standard logs with adhesive (the computer controlled Cevenini's will hold a tolerance of +/- .031 on standard logs with adhesive).

Some problems can come from the type of equipment that is being used for cutting. Gaska Tape uses semi-automatic Lever machines as well as computer controlled Cevenini's. This allows Gaska Tape to produce consistent high quality cut rolls. Our machines play a major part of producing high quality, but are not the only reason for our success. We have also learned a few good lessons over our 25-year history.

- **Cycle Time** - The time it takes to make a high quality cut has several variables:
  - Density - the heavier, the longer it takes.
  - Width - the wider, the longer it takes.
  - Diameter - the larger, the longer it takes.
  - Carrier - paper takes longer to cut than film.

*Example: A short, narrow, low density roll on film may take 20 seconds to cut. A wide, high density roll on paper may take 90 seconds to cut.*

- **Blade Rotation** - The direction of the material and mandrel are extremely important in preventing a separation from the core or from the cut rolls falling apart (see diagram below).



Larger master rolls or rolls without exposed adhesive may have higher tolerances (due to increased blade deflection or material movement respectively). Also, don't confuse material tolerance with the much lower machine tolerance, which is based on core cutting only. Please feel free to contact us with any questions or comments.