

Sheeting Domino CGT Duplex®

Double fly-knife vs. single fly-knife

The older single fly-knife sheeters were not as accurate as the Double fly-knife models. The occasionally had a convex cut on the leading edge and a concave cut on the trailing edge which would mean trouble for the pull-tab manufacturer who needs very strict tolerances. This has substantially improved over the last couple of decades. If the converter has older equipment, it could be suspect. The newer sheeters have virtually eliminated this issue. However, in my opinion, the double fly-knife is more accurate. If they sheet a roll for you, pull samples and turn the black side to the black side. If there is an issue, it will be very apparent.

Sheeting two rolls at one time

Because this grade has a slight shade variance from the beginning of the run to the end of the run due to the normal migration carbon black from one cylinder to the next. It is not advised to sheet two rolls at one time. It could result in a shade variance in every other sheet. By sheeting one roll at a time, the variance is usually indistinguishable.

Sheeting two (or more) sheets out of a roll

Some of the wider sheeters may be able to slit two+ sheets from one master roll at a time. If this is what the converter can do, ask them if they need a slightly wider roll than your sheet size. This should minimize potential out-of-square issues.

It is probably a good idea if you ask if there are splice detectors on the sheeter

In the pull-tab manufacturing process, splices will be problematic, especially if they reach the die-cutting stage in the manufacturing process.

Tolerances of +/- 1/32" is at the high end of most mill capabilities

Paper is hygroscopic meaning it will grow or shrink depending on the ambient conditions. Converters will probably be able to sheet to these tolerances but have no control when they are shipped to other locations. There is an article on my website (www.jbdco.com) entitled, "Relative Humidity and Temperature" under the downloads tab. You may want to download it to understand the phenomenon.

Packaging

Whether or not you use a skid or a pallet, the top of it should be solid and there should be a moisture barrier used to prevent moisture from "green" wood leaching into the paperboard. The skids should be 3/8 to 1/2 " larger than the paper being sheeted.

The top should be 3/8 to 1/2 " larger than the paperboard being sheeted. If to be shipped any distance, they should be banded 4-ways.

Storage

If you or your converter is storing paper in an unheated/cooled warehouse, you should be aware of the need for temperature conditioning of the paperboard before breaking the bands and exposing it to extremely cold (or hot) conditions. I have also included a Temperature Conditioning chart for your information. It can also be found on my website under the "Downloads" tab.

Instructions to the converter

I have attached the form I use which contains the instructions that you might want to accompany your order to sheet your order. Feel free to use this form. It is available on the "Downloads" tab on my website.