



## TABLE OF CONTENTS

### CHAPTER 1 - ROLL DEFECTS - GENERAL

GENERAL OVERVIEW .....	4
BURSTS - AIR SHEAR.....	6
BURSTS - CORE.....	8
BURSTS - CALIPER SHEAR.....	10
BURSTS - CROSS-MACHINE TENSION.....	12
BURSTS - MACHINE DIRECTION TENSION.....	14
CORE DAMAGE - DELAMINATION.....	16
CORE DAMAGE - SPIN OUT.....	18
CORE CRUSHED - AXIALLY.....	20
CORE CRUSHED - RADIALLY.....	22
CORE - ECCENTRIC.....	24
CORE - LOOSE.....	26
CORE - OFFSET.....	28
CORE - WRONG SIZE.....	30
BODY DAMAGE.....	31
ROLL - CRUSHED.....	32
ROLL - EDGE CRACKS.....	33
ROLL - OUT OF ROUND.....	35
ROLL - END DAMAGE.....	37
SPLICE - POOR.....	39
SPLICE - OFFSET.....	41
SPLICE - STUCK.....	43
START - BAD.....	44
START - SOFT.....	46
ROLL - BLOCKING.....	48
ROLL - INTERWEAVING.....	50
ROLL - KNOTS.....	52
ROLL - PLATING.....	54
ROLL - WITH SCRAP OR TRIM.....	56
ROLL - SLACK WINDING.....	58
ROLL - SLIVERS.....	60
ROLL - STUCK WEB LAYERS.....	61
ROLL - TERMITE HOLES.....	62



# TABLE OF CONTENTS

ROLL - TURNOVER .....	63
ROLL - VIBRATION .....	64
ROLL - WEDGE MARKS .....	66
ROLL - WRONG SIZE .....	67

## CHAPTER 2 - ROLL DEFECTS - WEB PROFILE

PROFILE VARIATION .....	70
GAUGE PROFILE VARIATION .....	74
BAGGY LANES at GAUGE BANDS .....	75
CORRUGATIONS .....	76
RIDGES - PAPER and NONWOVENS .....	78
RIDGES - FILM .....	80
WEB BUBBLE AHEAD of NIP .....	82
HARD EDGES .....	84
SOFT EDGE .....	86
TIN CANNING .....	87
STARRED ROLLS .....	89
REJECT PAPER .....	91

## CHAPTER 3 - ROLL DEFECTS - EDGE

READING A ROLL .....	94
TROUBLESHOOTING TREE - Core .....	98
TROUBLESHOOTING TREE - Over All .....	100
TROUBLESHOOTING TREE - Random A .....	101
TROUBLESHOOTING TREE - Random B .....	102
ROLL EDGE - SLITTER FLUTTER .....	103
ROLL EDGE - WEB FLUTTER .....	105
ROLL EDGE - SLITTER RINGS .....	106
EDGE OFFSET at LARGE DIAMETER .....	108
EDGE OFFSET - AIR ENTRAINMENT .....	109
EDGE OFFSET - CORDUROY EDGE .....	110
EDGE OFFSET - SAWTOOTH .....	112
EDGE OFFSET - OSCILLATION .....	113
EDGE OFFSET - ACCEL/DECEL or TENSION CHANGE .....	114

# TABLE OF CONTENTS

EDGE OFFSET - LACK of TRIM.....	116
EDGE DISHING - ERRATIC EDGES.....	117
EDGE DISHING - PROGRESSIVE OUTWARD.....	119
EDGE DISHING - STRAIGHT EDGES.....	121
ROLL EDGE - WIDTH GROWTH.....	123
ROLL EDGE - CLOCKSPrINGING.....	125
ROLL EDGE - TELESCOPING.....	126
ROLL EDGE CONING - DURING STORAGE.....	128
ROLL EDGE CONING - VERTICAL STORAGE.....	130
ROLL EDGE CONING - VERTICAL CORE LIFT.....	131
<b>CHAPTER 4 - ROLL AND WEB DEFECTS - WRINKLES</b>	
ROLL AND WEB WRINKLING.....	133
BUCKLES.....	136
ROLL COCKLE.....	138
CREPE WRINKLE - WINDER.....	140
CREPE WRINKLE - REEL.....	142
MOISTURE WELTS.....	144
MD WRINKLES - UNIFOrMLY SPACED.....	145
MD WRINKLES - NONUNIFOrM SPACING.....	147
DIAGONAL SHEAR WRINKLE - SYMMETRIC.....	149
DIAGONAL SHEAR WRINKLE - ASYMMETRIC.....	151
TRAVERSE DIRECTION WRINKLE.....	153
BAGGY LANE.....	155
BAGGY PATCHES.....	157
CURL.....	158
HARD WRINKLES.....	160
CUTTER WRINKLES.....	162
<b>CHAPTER 5 - WEB DEFECTS - PAPER MAKING</b>	
PAPERMAKING.....	165
BAGGY PAPER.....	169
BEAR PAWS.....	171
BLISTER CUT.....	172
CIGARS.....	173



## TABLE OF CONTENTS

COCKLE .....	174
COUCH MARKS .....	176
DANDY LICKS .....	177
DRILLS .....	178
DRY PAPER .....	179
FELT MARKS .....	180
FIBER BUNDLES .....	181
FIBER CUT .....	183
FISH EYES .....	184
GAUGE BANDS .....	186
HAIR CUT .....	186
HOLES .....	189
SLIME HOLE .....	190
OFF COLOR .....	191
PITCH MARKS .....	192
SCABS .....	193
SCALE - PAPERMAKING .....	194
SEAM MARK .....	195
SHIVES .....	196
SLIME .....	197
STICKIES .....	198
STOCK LUMPS .....	199
STRINGERS .....	201
VARIABLE TENSILE MODULUS .....	203
WATER MARKED PAPER .....	205
WET PAPER .....	206
WIRE HOLE .....	207
WIRE MARK .....	208
<b>CHAPTER 6 - WEB DEFECTS - CALENDERING</b>	
CALENDERING .....	210
CALENDER CUTS .....	213
CALENDER MARKS .....	215
CALENDER SPOTS .....	216

# TABLE OF CONTENTS

CALENDER STREAKS .....	217
PUCKER WRINKLE .....	218
SCALE-CALENDERING .....	219
SURFACE MARKS .....	220
<b>CHAPTER 7 - WEB DEFECTS AQUEOUS COATING</b>	
AQUEOUS COATING .....	222
APPLICATOR ROLL PATTERN - CASCADE .....	225
APPLICATOR ROLL EDGE DAMAGE - METERED SIZE PRESS .....	227
APPLICATOR ROLL SPOTS .....	228
APPLICATOR ROLL STREAKS .....	229
BACK FLOW-JET COATER .....	231
BACKING ROLL MARK .....	233
BACKING ROLL PATTERN .....	234
BACKING ROLL SPOTS .....	235
BINDER SPECKS .....	236
BLADE SCRATCH: MECHANICAL .....	238
BLADE SCRATCH: RHEOLOGICAL .....	240
BLADE WRINKLE .....	242
BLISTERS .....	244
COATING LUMPS .....	245
COATING PICKS .....	246
COATING PITS .....	248
COATING SKIPS .....	249
COATING SPLASH .....	251
COATING STREAKS .....	253
CRATER-CURTAIN COATING .....	255
FILM SPLIT PATTERN .....	257
FOAM STREAKS .....	259
GROOVED ROLL MARKS .....	261
MISSED COATING .....	262
MISTING-METERED SIZE PRESS .....	263
MOTTLE .....	265
ORANGE PEEL-METERED SIZE PRESS .....	267



## TABLE OF CONTENTS

RAILROAD TRACKING .....	269
SKIP COATING-CURTAIN COATING.....	271
SKIP COATING-JET APPLICATION.....	272
SLIME SPOTS.....	273
SLUDGE BUILDUP .....	274
SPITS - COATING (METERED SIZE PRESS).....	276
WAVY LINES-CURTAIN COATING .....	278
WET STREAKS.....	280
WHISKERING.....	282
WIRE-WOUND ROD STREAKS .....	284

### CHAPTER 8 - WED DEFECTS FILM EXTRUSION AND LAMINATING

FILM EXTRUSION AND LAMINATING .....	286
FILM BREAKS .....	290
UNEVEN GUSSETS.....	291
WRONG GLOSS .....	293
HAZE .....	295
LOW STRENGTH .....	297
LOW ELONGATION .....	299
SHRINKAGE.....	301
GAUGE BANDS - Films.....	302
BLOCKING - Film .....	304
HIGH COEFFICIENT OF FRICTION.....	306
LOW STIFFNESS.....	307
ODOR.....	308
OXIDATION .....	309
DELAMINATION .....	310
POOR ADHESION.....	312
SURFACE ENERGY - Too high or too low .....	314
GELS .....	315
CONTAMINATION .....	317
PLATE OUT .....	319
LENSING.....	321
PITS.....	322

## TABLE OF CONTENTS

HOLES.....	323
WELD LINES.....	324
DIE STREAKS.....	325
SPIDER LINES.....	326
SCRATCHES - Film.....	327
HEAVY EDGES.....	329
EXCESSIVE NECK-IN.....	330
EDGE TEARS.....	331
TD BANDS.....	332
DRAW RESONANCE.....	333
VENETIAN BLINDS.....	335
AIR RING CHATTER MARKS.....	336
KNOTS.....	337
IMPRESSIONS.....	339
MELT FRACTURE.....	340
SHARK SKIN.....	342
EXTRUDATE BUILDUP.....	344
INTERFACIAL FLOW INSTABILITY.....	345
BUBBLES.....	346
MD TUNNELING.....	348
TD TUNNELING.....	350
AIR POCKETS (COLLAPSED).....	352
CHICKEN TRACKS.....	353
EDGE CREASES.....	354
ALLIGATOR HIDE.....	355
CHECKLING.....	356
CENTER BUCKLE.....	357
BUCKLE LANES.....	359
SKEW.....	360
TD COCKLE.....	361
MD COCKLE.....	362
MD CURL.....	363
TD CURL.....	365
TWIST.....	367



## TABLE OF CONTENTS

ANTICLASTIC BENDING .....	368
POOR BARRIER PROPERTIES .....	369
<b>CHAPTER 9 - WEB HANDLING DEFECTS</b>	
WEB DAMAGE AND CONTROL LOSSES .....	372
SCRATCHES - CONTINUOUS .....	376
SCRATCHES - INTERMITTENT .....	378
MICRO-SCRATCHES - MD and ANGLED .....	380
SLIPPING ROLLER .....	381
WEB BREAKS .....	383
TENSION VARIATIONS - TOO HIGH .....	384
TENSION VARIATIONS - TOO LOW, SLACK .....	385
TENSION VARIATIONS - OSCILLATING .....	386
TENSION VARIATIONS - MD .....	388
TENSION VARIATIONS - CROSS-WEB .....	390
WEB WANDER or OFFSET .....	391
OUT-OF-PLANE WEB .....	392
<b>CHAPTER 10 - SLITTING DEFECTS</b>	
SLITTING .....	395
CAMBERED EDGE .....	401
CRACKED EDGE .....	403
DUST IN ROLL .....	404
SLITTER EDGE CURL .....	407
FLARED EDGES .....	409
FUZZY EDGE .....	411
RIPPLED EDGE .....	413
SCALLOPED EDGE .....	415
SERRATED EDGE .....	417
TURNED EDGE .....	419
SLITTER PICKS .....	420
SLITTER RINGS .....	421
SCRATCHES - SLITTER .....	423
SLITTER SKIP .....	424





# TABLE OF CONTENTS

TASK GROUP MEMBERS.....	425
CONSULTING AND CONTRIBUTING EDITORS.....	431
GLOSSARY.....	445
SUBJECT INDEX.....	435

