

Water-activated paper tape

GUMMED KRAFT · PLAIN AND PRINTED · 70 MM

CP-TP-G70 70 mm × 200 m
CP-TP-P70 70 mm × 200 m, 2 colour

There is nothing to assemble. A roll goes into a dispenser, water goes into the pot and strips come out cut to length, so this sheet covers setting the dispenser, judging the strip and getting it onto the seam. The one thing worth learning properly is that the strip is wet when it lands and is working from that second — there is no second attempt at placement, and everything else on this sheet follows from that.

READ FIRST

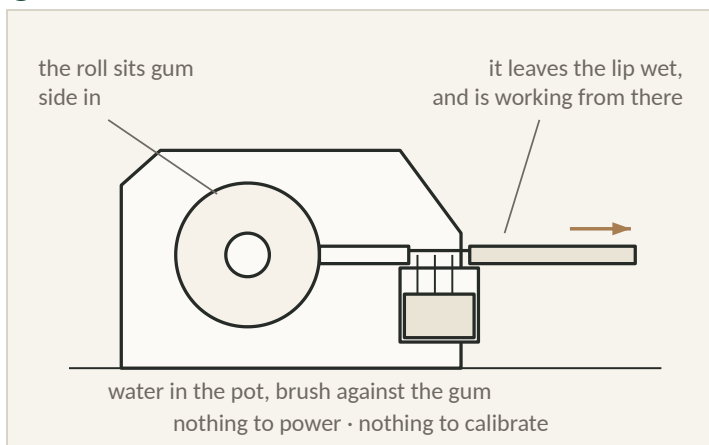
- ! Place it once. A wet strip is bonding the moment it touches board, and lifting it to straighten it takes liner with it and leaves you sealing a damaged seam.
- ! Cut to the seam plus a turn-down at each end. A strip that stops at the edge of the lid peels from the edge of the lid, which is the single most common failure on this family.
- ! Keep the pot topped up and the brush clean. A half-wet strip bonds in patches, and a patchy seal looks exactly like a sound one until it is handled.
- ! Do not tape coated, waxed or laminated board. The gum needs fibre to key into, and a coating is precisely a layer stopping it.
- ! Leave it twenty minutes before it is stacked or thrown. Green tack holds the flaps shut; it is not the bond the spec sheet quotes.
- ! Keep rolls dry and in their carton until they go on. A roll that has taken damp air has already used part of its gum and will block on the core.

AT THE BENCH

Rolls per carton	12
Cartons per pallet layer	24
Tools required	A water dispenser, manual or powered
Required consumable	Water
Sealing time, after practice	7 seconds

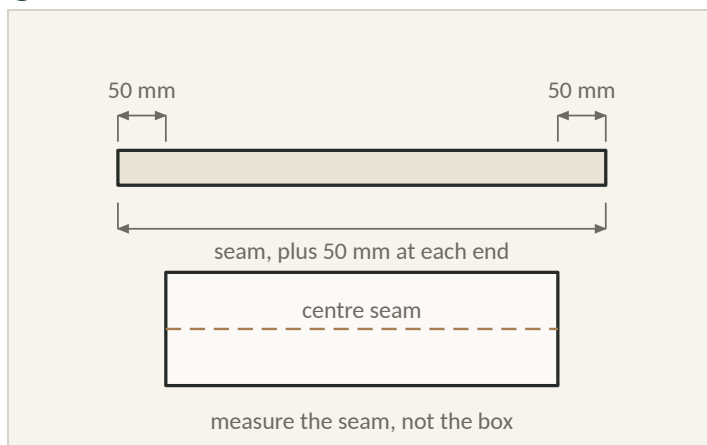
AT THE DISPENSER, STEPS 1 TO 4

1 Set the dispenser and fill the pot



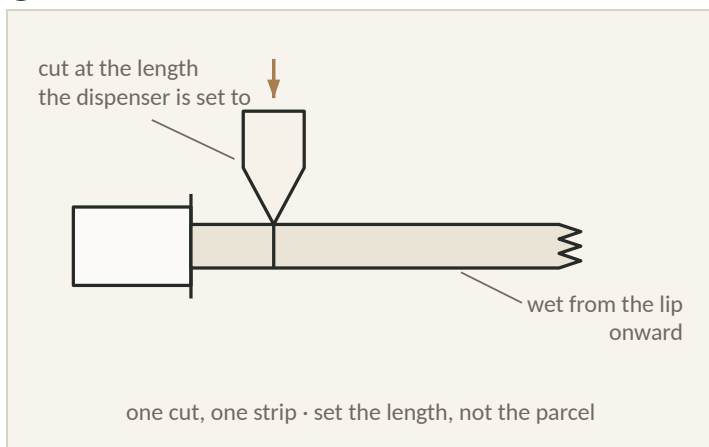
The roll drops onto the spindle gum side in, which is how it is wound and how it must go back. Fill the pot, check the brush is wet across its whole width, and set the length for the carton size on the run rather than for the parcel in your hand. A dispenser that is reset per parcel will be set wrong before the morning is out.

2 Measure the seam, not the box



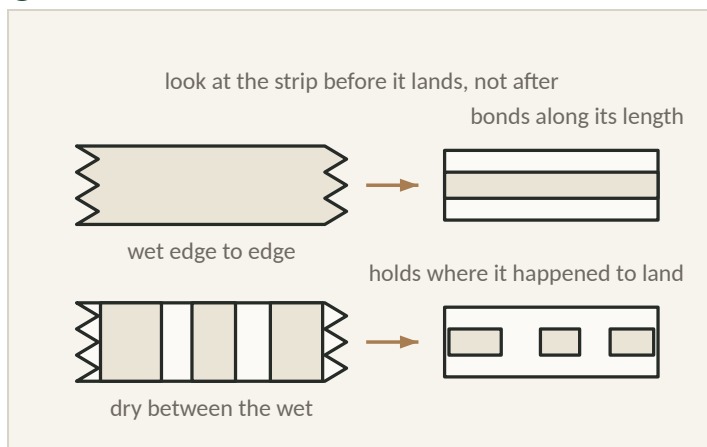
The strip closes the centre seam and turns down over both end faces, so the length is the seam plus a turn-down at each end. Cut to the length of the lid and the strip stops exactly where the peeling starts. This is the one measurement on the sheet and it is worth setting properly once, because the dispenser will then do it for the rest of the run.

3 Cut the strip



One cut, one strip. The strip is dry as it leaves the roll and stays dry until it reaches the pot, so there is no hurry at the blade and no penalty for a moment's pause — all the timing on this family starts after the water, not before it. A powered dispenser does the cutting on the keypad setting; a manual one does it against the lip.

4 Look at the strip before it lands



A sound strip leaves the lip visibly wet from edge to edge. One that is wet in patches will bond in patches, and a patchy seal looks exactly like a sound one until somebody handles the carton. If the wet is breaking up, top the pot and clean the brush before cutting another strip. This is a two-second check and it is the whole quality control on the family.

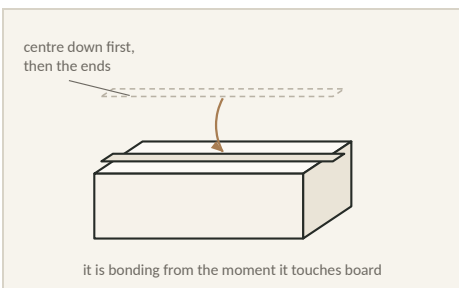
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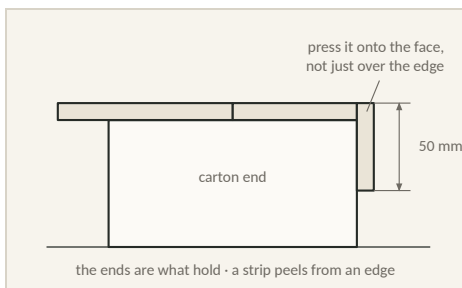
SEALING, STEPS 5 TO 7

5 Land it on the seam, centre first



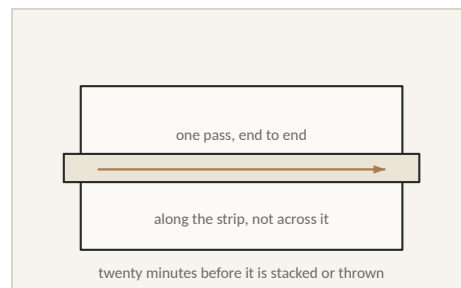
Bring the strip down onto the centre seam flat, middle first, and let the ends follow. A strip laid end first follows whatever angle it started with and there is no correcting it: the gum is bonding from the second it touches board, so the first contact is the placement. If it lands wrong, it comes off with liner attached and the seam has to be sealed over damage.

6 Turn the ends down



Take each end over the corner and press it onto the end face rather than leaving it folded over the edge. A seal peels from an edge, and the turn-downs are what stop it starting. Do one end, turn the carton, do the other. Nothing else is fastened and nothing else needs to be.

7 One pass, then leave it alone



Press along the whole length once, from one end to the other. That is the last thing done to the seal: it is not lifted, not straightened and not laid again, because every one of those takes liner with it. Give it twenty minutes before the carton is stacked or thrown. Green tack holds the flaps shut and is not the bond the spec sheet quotes.

IF A SEAL WILL NOT HOLD

SYMPTOM	CAUSE	FIX
The strip peels at one end	It was cut to the length of the lid, so there is no turn-down holding the end	Cut the seam length plus a turn-down each end and press the turn-downs onto the end faces. The ends are what hold
The seal comes away clean	The board is coated or waxed, or the strip went on dry	Check the pot and the brush first. If the board is coated, this family will not bond to it and no setting will fix that
It bonds in patches	The brush is dry at one end, or the strip is running past it faster than the pot can wet it	Top the pot up and clean the brush. If it persists, slow the feed — the strip has to leave the lip visibly wet
The strip curls off the seam	It was laid from one end and allowed to wander, rather than landed on the seam along its whole length	Bring the strip down flat onto the seam, centre first. A strip laid end first will follow whatever it started with
Rolls block on the core	Damp store. The gum has taken up moisture on the roll and bonded to the turn beneath it	Scrap the roll and move the store. A blocked roll tears rather than unwinds and wastes more than it saves
Seams open in transit but look sealed	The cartons were stacked inside the cure window	Leave sealed cartons twenty minutes before they are stacked or thrown. Green tack is not the bond

WHAT GOES IN WITH IT



CP-CTN-RSC1

Shipping carton, RSC

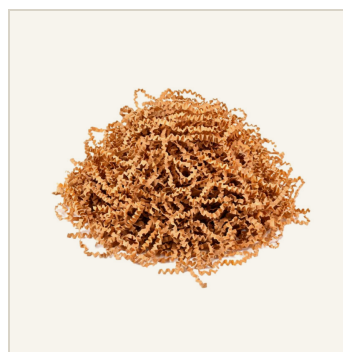
What the strip is applied to. The tape closes the seam; the carton is what the handling happens to.



CP-VF-HC24

Honeycomb wrap

The layer on the item inside. Wrapped in kraft and closed with kraft, the parcel is one material end to end.



CP-VF-CR18

Crinkle void fill

For whatever volume is left round the wrapped item, which is a filling job rather than a sealing one.

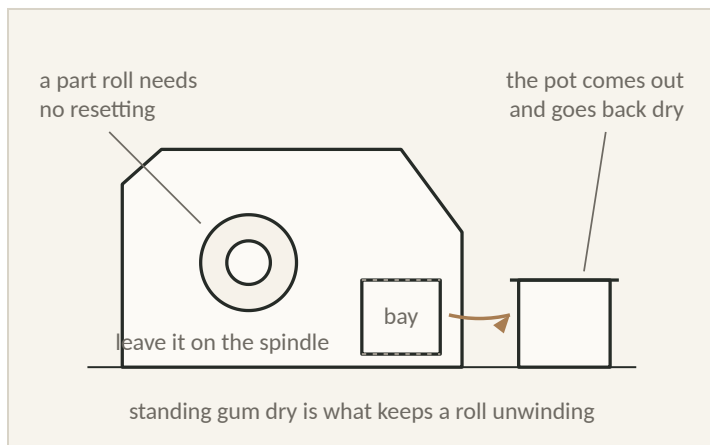
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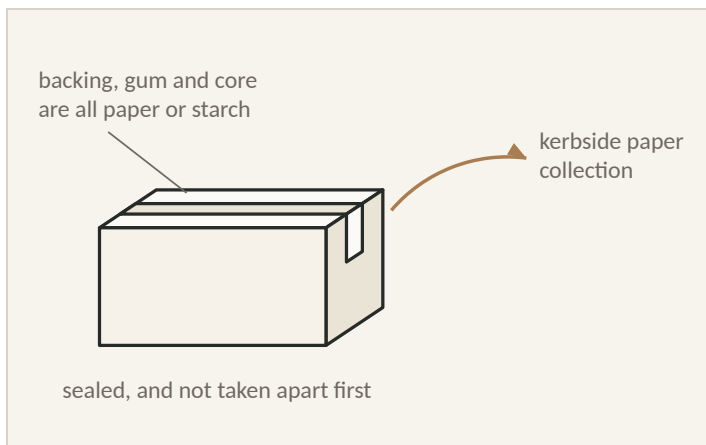
THE PART ROLL, AND THE WAY OUT

8 Leave the part roll where it is



A part roll stays on the spindle and there is nothing to reset for the next order. What comes out at the end of a shift is the pot: standing water in a pot goes stale, and gum left standing wet on a brush dries hard on it. Empty the pot, rinse the brush, leave the roll. A roll that is put away damp is a roll that blocks on its own core.

9 One way out, and the tape goes with it



The backing is kraft, the gum is starch and the core is the same kraft as the backing. A sealed carton goes into kerbside paper collection exactly as it arrived, with the tape still on it and nothing stripped off first. That is the difference from a plastic tape, where the seal has to be removed before the carton can be recycled — a step that in practice nobody takes.

STORAGE

Before make-up

- Store cartons flat and off the floor, no more than two pallets high.
- Keep dry. Damp air is the only thing that spoils this product, and it spoils it on the roll rather than on the parcel.
- Keep rolls in their carton until they go into a dispenser. The carton is doing a moisture job as well as a handling one.
- Twelve months unopened and dry. The limit is the gum's exposure to moisture rather than time on the shelf.

END OF LIFE

After the last trip

- A sealed carton goes into kerbside paper collection with the tape still on it. Nothing is stripped off first, which is the whole point of specifying it.
- The core goes the same way. It is the same kraft as the backing, so there is nothing on the bench that has to be sorted from anything else.
- The plain grade also carries a commercial composting listing, on the term the spec sheet holds. The printed grade does not, and the record on every sheet in this pack says which is which.
- A carton wrapped in honeycomb, filled with crinkle and closed with this tape is one material from the outer inwards. That is the pack this family was drawn for.

Almost every fault on this family is a placement fault, and placement is the one judgement the bench actually makes: the strip is wet and bonding from the second it lands, so there is no second attempt. If seams are opening in transit, watch how the strip goes down and how long the carton waits before it is stacked, before looking at the tape itself.

ROLL HANDLING

Stack height, palletised	2 pallets – the cartons take it
Storage position	In the carton, on the core, off the floor
Opened roll	Leave it in the dispenser; the pot is what is emptied, not the roll
Blocked roll	Scrap it – a roll that has bonded to itself tears rather than unwinds

Check the board before you change the tape. The tape carries one wet-out time, one cure time and one bond figure, and all three are held on the spec sheet. So is the reason a strip will not reposition. Read them there, not from a bench card; a figure copied onto a card is a figure that goes stale.

BENCH SETUP

Working a roll

- Put the dispenser where the sealed carton leaves, not where the empty one arrives. The strip is wet and the carton should move once after it goes on, not three times.
- Set the length once for the carton size on the run, not per parcel.
- Fill the pot at the start of the shift and check it at the break.

SEALING TIME, AFTER PRACTICE

CP-TP-G70, one strip	7 seconds
CP-TP-G70, one strip plus two ends	16 seconds – the ends are most of it
Pressure-sensitive, three strips	12 seconds