



The

Stock Doctor

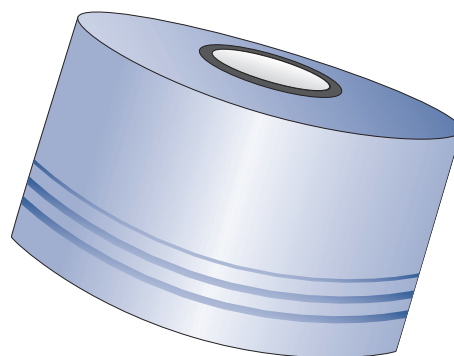
with helpful tips from your manufacturer

Issue 5

“Gauge bands are slight variations in film caliper that occur during the manufacturing process of the raw film. Gauge bands appear as a darker region in the overlamine rolls and typically run in the machine direction.”

Gauge Bands

Although film manufacturers monitor these very closely, occasional gauge bands are inherent to the film manufacturing process and are not entirely preventable. Gauge bands are typically less than one half inch wide but on occasion may be larger due to natural variation in the film manufacturing process as the material is “stretched” to the desired point creating film gauge and material width.



Is a Gauge Band a Defect?

Gauge bands are often believed to be an area of too much or insufficient coating due to a darker appearance that typically runs in machine direction. Gauge bands carry a steady amount of adhesive coating and do not present an issue in a single layer through the coating, converting or label production process. In a single layer a gauge band will laminate well and will actually be clearer in the region of the gauge band prior to lamination due to increased internal roll pressure in that area.

Many times gauge bands are not visible through the manufacturing process but become visible over time after the converting process. This occurs due to the good winding tension of the slit material. Slit rolls are closely monitored for good winding profile as this will help create optimal clarity of the overlamine in a single layer. As occasional gauge bands are inherent to the film manufacturing process and do not lead to defective printed label material, they are not considered to be a manufacturing or material defect. Overlamine rolls exhibiting a gauge band can be processed through the label production process and yield the desired end result.