

SECTION 15 PAPER PRODUCTS (ROLLS)

- 15.1 The Paper Roll
- 15.2 Key Points for Quality Assurance
- 15.3 Paper Handling Equipment
- 15.4 Unloading Rail Wagons
- 15.5 Fork Lift Handling
- 15.6 Stowage of Rolls

This section covers the following products:

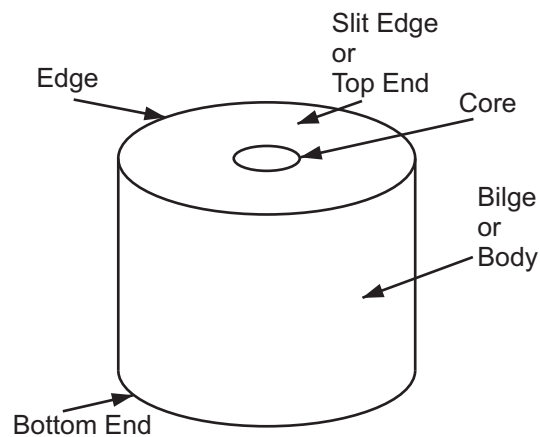
- ➔ Tissue Rolls
- ➔ Pulp & Paper Rolls
- ➔ Newsprint Rolls
- ➔ Quality Assurance

15.1 THE PAPER ROLL

IDENTIFICATION

All rolls are clearly labelled with their unique roll number, order number, customer name, destination, width and weight.

The following sketch identifies standard terms on labels for roll parts. If used throughout this will correctly identify and report on incidences of damage. It will also help remedy handling deficiencies.



PAPER ROLL VALUES

The value of paper rolls varies typically between \$1300 and \$4000.

15.2 KEY POINTS FOR QUALITY ASSURANCE

- ➔ Paper rolls are very sensitive to mis-treatment and therefore good handling technique is important.
- ➔ Paper rolls require careful and specialised handling.
- ➔ Paper loss through handling damage is expensive.
- ➔ A 25 mm (1 inch) cut to the body of a full-size roll could be up to a \$150 loss.
- ➔ A crushed core or a gouge to the bottom end of a roll can render it totally useless.
- ➔ Roll damage can be caused by shunt shock, dropping a roll or excessive clamp pressure.

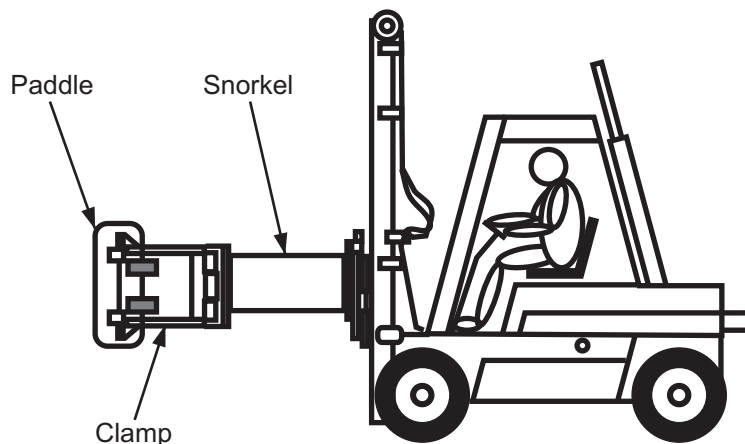
DO...

- ✓ Minimise these risks by minimising the number of times you handle a roll.
- ✓ Use only correct and certified handling equipment..

15.3 CLAMP EQUIPMENT FOR HANDLING PAPER ROLLS

SPECIALISED ITEMS

The following diagram identifies the specialised items on the clamp.



EQUIPMENT CHECK

DO...

- ✓ Lubricate all working parts regularly. Ensure excess oil/grease is wiped away as it may transfer to the roll and cause damage.
- ✓ Check that paddle return springs are operating properly and clamp paddles are not bent.
- ✓ Check that paddle blades are in vertical alignment and are free from any protrusions, loose nuts or bolts, cracked or fractured welds.
- ✓ Ensure clamp pressure for handling newsprint rolls is set at between 1.4 and 1.6 kg/cm². KiwiRail have a manometer for checking this pressure.

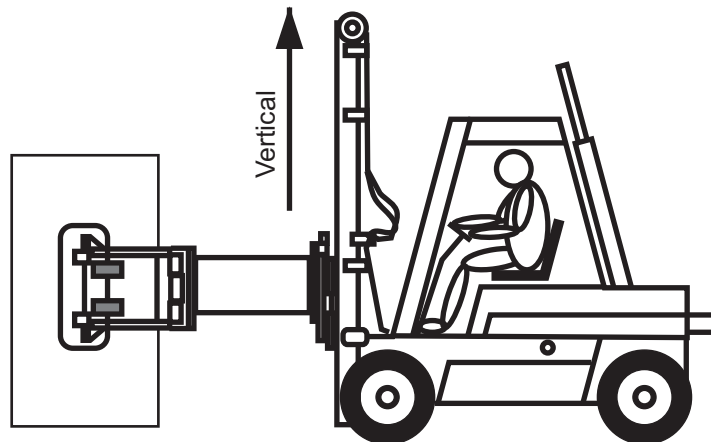
DO NOT...

- ✗ DO NOT use the roll clamp blades to open or close wagon doors.

15.4 UNLOADING RAIL WAGONS

DO...

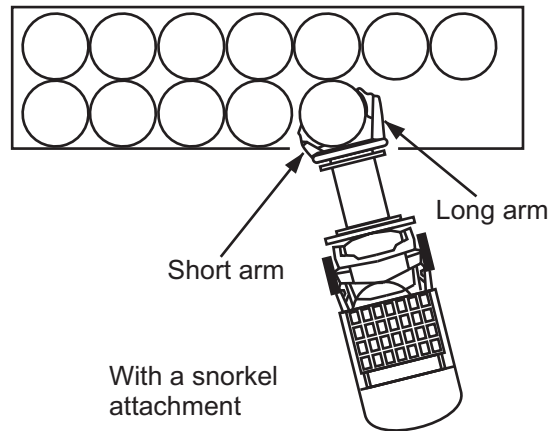
- ✓ Keep forklift towers vertical with a snorkel attachment.



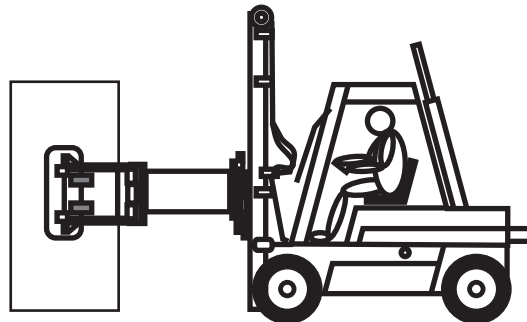
This allows correct 'pick-up' and placement of rolls. It also allows correct clamping of the paddle shape on the sides of the roll.

DO...

- ✓ Use the offset (long and short) arm clamps properly—the long arm always to the more open side of the roll.

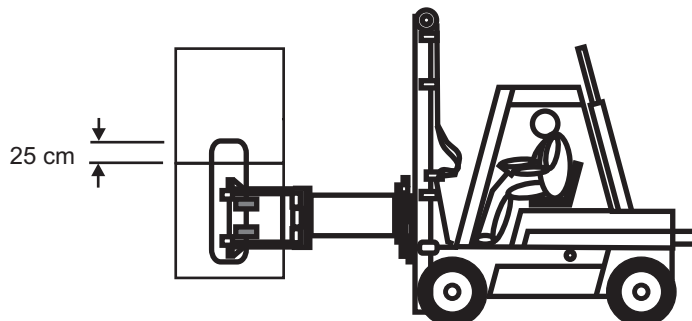


- ✓ Centre the clamp when handling full-size and three-quarter-size rolls.



- ✓ Place the major portion of the paddles on the lower roll when handling half-size rolls.

- ➔ Need to have at least 25 cm of the top roll clamped
- ➔ Only half rolls are to be carried 2 high.



15.5 FORKLIFT HANDLING

'ON-END' HANDLING

DO...

- ✓ Keep forklift towers **vertical**.
- ✓ Always use **correct clamps** to load and unload.
- ✓ Place paddles in **centre** of roll except when handling two rolls.
- ✓ Apply the major portion of the paddles to the **lower** roll when handling two rolls.-
Approximately 25 cm clamp overlap.

DO NOT...

- ✗ DO NOT lift **more than two half rolls** at the same time.
- ✗ DO NOT carry $\frac{3}{4}$ or main rolls 2 high.

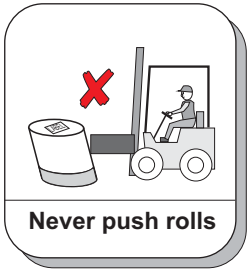
'ON-BILGE' HANDLING

DO...

- ✓ Use **spikes** where provided, or
- ✓ Use **well-radiused inner-edged tynes** on the forklift, or
- ✓ Use overhead **clamps**.
- ✓ Use **chocks, chock paddles** and **lever bats** when unloading **two-high** bilge rolls.

These points are summarised in Diagram 15.1

DIAGRAM 15.1 GUIDELINES FOR FORKLIFT HANDLING WITH CLAMPS



CHECKLIST

Don't Push

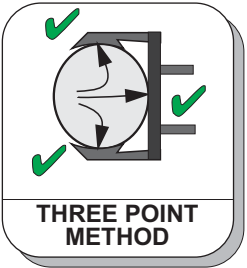
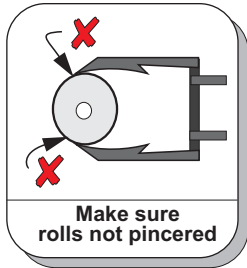
Never lift more than two at once

Don't Pincer

Always stop & lower before releasing

Always put paddles on the lower reel

Use the **THREE-POINT** method



USE OFFSET ARM CLAMPS CORRECTLY

Always keep the **long** arm on the more **open** side of the roll.

Always keep the forklift towers **vertical**.

15.6 STOWAGE OF ROLLS

- ➔ Rolls can be stowed vertically or horizontally..
- ➔ Vertical stowage is called 'on end'.
- ➔ Horizontal stowage is called 'on bilge'.

Diagram 15.2 illustrates some of the following points.

When stowing 'on end'.

DO...

- ✓ Stack rolls top end up
- ✓ Stack rolls vertically and straight, with no overlapping.
- ✓ Use edge protection if using chains or strops.

DO NOT...

- ✗ DO NOT overlap the edges.
- ✗ DO NOT store newsprint rolls on bilge.
- ✗ DO NOT put different diameter rolls on the same stack.

NOTE

Rolls with a diameter less than half their width should not be loaded on end, unless strapped in pairs or in groups, otherwise they could tip over.

When stowing 'on bilge'

DO...

- ✓ Put the core across the deck.
- ✓ Chock the rolls..
- ✓ Secure with chain or strop through the core
or
Secure with a locking roll.
- ✓ Use core protection if securing with chains.
- ✓ Secure and restrain all rolls or groups of rolls of less than 1700 mm wide.
- ✓ Ensure that second-layer rolls loaded on a low-sided vehicle or wagon have the lowest point of the roll a minimum of 150 mm below the upper level of the side.

DO NOT...

- ✗ DO NOT stack the cores lengthwise along the deck.
- ✗ DO NOT stack rolls less than 1000 mm diameter on the lower level.
- ✗ DO NOT place rolls of different diameters in the same pillars.

General Guidelines

Paper storage requires first class housekeeping

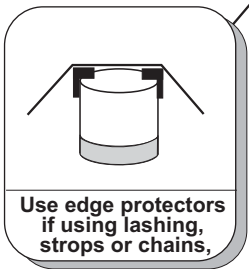
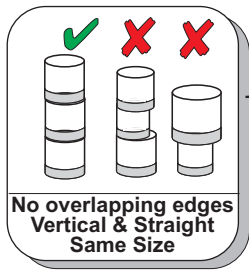
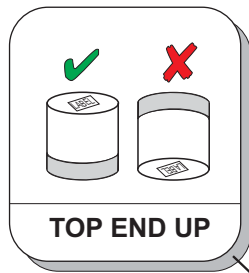
DO...

- ✓ Store in a secure dry area away from any source of dampness.
Clean the floor first. Check for nails, wood chips etc. and remove them. Ensure all wet oily stains are removed or if dry, covered with paper.
- ✓ Store clear of traffic lanes (carrying fork lift trucks and so on) to avoid damage.
- ✓ If storing for more than 7 days, rolls must be covered to prevent damage due to dust, stains and sunlight.
- ✓ Chock rolls stored 'on bilge'.
- ✓ Stow rolls in customer lots (or order numbers and customer sizes).

DIAGRAM 15.2 PAPER ROLL STOWAGE GUIDELINES

'On End'

**VERTICAL
STOWAGE**



'On Bilge'

**HORIZONTAL
STOWAGE**

