



Billerud Documentation Requirements

QUALITY CONCERN	ROLL/SKID NUMBER	PRODUCT LABELS	QUALITY REPORT	UNPRINTED SAMPLES	PRINTED SAMPLES	TAPE PULLS	BLANKET SAMPLES	TEMPERATURE RH READINGS	PHOTOGRAPHS	COMMENTS
Baggy Roll	•	•	•	•	•				•	Photos, 12 printed samples, and Schmidt Hardness test results if available.
Blanket Smashes	•	•	•		•	•	•		•	Evidence of defect and the blanket, tape pulls and photos. Printed samples prior to and after the damage.
Blistering	•	•	•	•	•					12 (8 ½" x 11") sheets of white paper sealed in a plastic bag. Printed samples depicting problem. Press conditions (web exit temp, details regarding speed, ink coverage, dryer temp, type and length of dryer, pressroom RH and temp).
<i>Contamination – Listed below are some of the more common causes of contamination type defects.</i>										
Hickeys	•	•	•	•	•	•				12 sheets white paper, tape pulls on acetate, printed sheets with the problem, and the original pick-out. Do not affix tape pulls to anything except acetate. Be sure to indicate which units are showing the problem.
Pick-outs	•	•	•	•	•	•				
Piling	•	•	•	•	•	•	•		•	
Coating Streaks/ Lumps	•	•	•	•	•	•				
Surface/Slitter Dust	•	•	•	•	•	•			•	
Cracking-at-fold	•	•	•	•	•			•		12 (8 ½" x 11") sheets of white paper sealed in a plastic bag. 12 printed samples of the problem. Web exit temp, competitive samples, type of folder, information on fold process (scores, pre-moisturizing units), time between printing and folding, storage conditions.
Curl	•	•	•	•	•			•	•	Press and skid RH and temperature readings, photo and printed samples.
Delamination	•	•	•	•	•			•		15-20 printed consecutive sheets that exhibit the defect along with 15-20 unprinted consecutive sheets.
Mottle	•	•	•	•	•					12 sheets white paper, the color sequence, 12 printed sheets, single color progressives, flipped sheets and competitive samples, if available.
Mis-Register/Slur	•	•	•	•	•			•	•	15-20 printed sheets that exhibit the issue along with 15-20 consecutive unprinted sheets.
Offsetting/Blocking	•	•	•	•	•			•	•	20 consecutive sheets that exhibit the defect.
Off Size/Square	•	•	•	•						12 consecutive unprinted sheets. Skid – roll identification.
Splice Breaks	•	•	•		•					Collect the paper from where the break occurred and try to locate the splice for Billerud Customer Technical Service Representative inspection.
Surface Defects	•	•	•	•	•					Evidence of defect, 12 unprinted sheets, printed samples.
Tight/Wavy Edges	•	•	•	•	•			•	•	Press and skid RH and temperature readings, photo and printed samples. For wavy/tight edges, mark the unprinted paper samples in the area the defect appears.
Web Breaks	•	•	•	•	•					Evidence of defect, roll numbers and remaining roll weight, if known. Or supply remaining roll diameter and width in inches.
Wrinkling	•	•	•	•	•			•		15-20 printed sheets with the wrinkle, along with 15-20 consecutive unprinted sheets.