



Technical Information Bulletin
Double-Coated Tape & Liner Separation
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During the operation of converting a double coated tape, the liner will occasionally exhibit a challenge as it is unwound. The liner may begin separating from the tape and may display "liner confusion" (Diagram A). It is important for a double coated tape to provide a uniform peel-off point during the unwind process. In Diagram A, the unwind roll is threaded around an idler, or drive roll with the adhesive side down. Since the brake is being applied to the center of the roll and is typically not exactly uniform, the peel-off point can shift during the acceleration and deceleration periods of the process. When this occurs, the tape will sometimes separate from the liner while remaining anchored to the liner on wrap below.

To eliminate this "liner confusion" it is recommended that a peel-off roll assembly be added to the unwind (Diagram B). The purpose of the peel-off roll system is to mechanically assure the tape is removed from the roll with a higher tension than that of the liner, thus forcing the tape to follow the top liner. This process prevents the tape/liner separation that is periodically experienced. The pull-off and lay-on rollers should be constructed using a silicone rubber covering with a durometer of 80 to 95. The pressure that is applied to the arm of the lay-on roll should be regulated using precision regulators. Adding a potentiometer to the lay-on roll arm could also be considered. This will be used to adjust the brake pressure automatically as the unwind roll diameter changes.

Diagram A

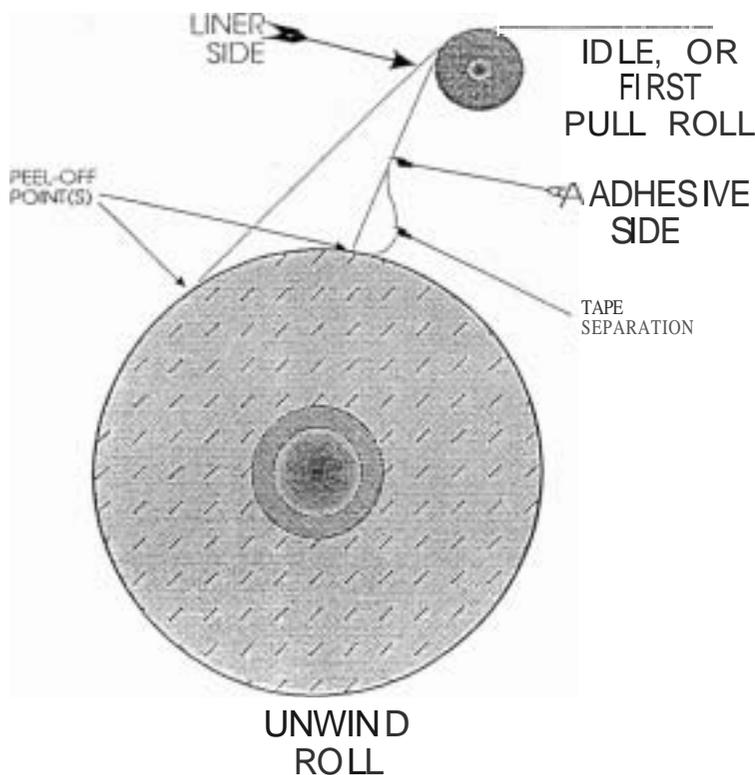


Diagram B

