

ACTEGA Kelstar Technical Bulletin

Paper Curl

Sheet curling is caused by many different variables. The following is a list of causes and solutions.

Causes:

- Stock absorbs too much water
- Excessive heat
- Mechanical distortion
- Not using a non-curl aqueous coating

Solutions:

- Check moisture content of paper. Stock moisture content should be at least 5-6%. Too low moisture content (<5%) leads to excessive distortion as water is absorbed from the coating.
- Try to use paper stocks of 80 pounds or higher.
- Lessen the coating weight via the metering or lowering the viscosity.
- Use faster setting inks with lower water pick up.
- On heavy coverage, try to reduce water pick up of the ink to minimize size change in stock.
- Run the coating as near the edge as practical to provide a uniform size change in the sheet.
- Check for proper load temperature and do not exceed 105°F.
- Check the setting of sheet guides for correct settings.
- Use a non-curl coating such as Starkote AQ-508 which is formulated to eliminate or reduce paper curl when coating.

Contact ACTEGA Kelstar at 856 829 6300 or info.actega.kelstar@altana.com for additional information or technical assistance.