



# Tape Solutions for the Paper Production and Processing Industry

**Adhesive Tapes Division**

**ORAFIX<sup>®</sup>**  
**ORABOND<sup>®</sup>**

**Engineered to Perform Better™**



# ORAFOL Europe GmbH

## ORAFOL's Worldwide Locations





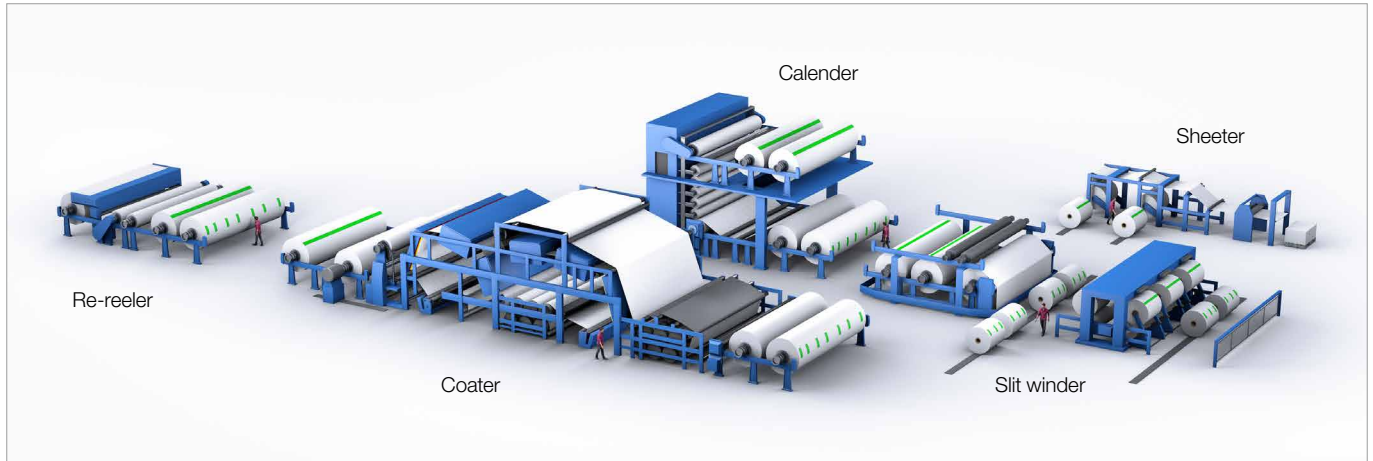
# Tape Solutions for the Paper Production and Processing Industry

## Find the right solution for your needs

ORAFOL Europe GmbH offers a truly comprehensive range of technical adhesive tapes for the paper and printing industry including double-sided and single-sided repulpable tapes, non-repulpable tapes and silicone splice tapes.

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# Repulpable Tapes for Paper and Pulp Industry



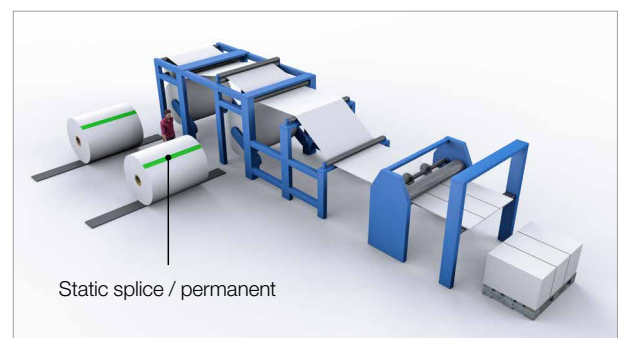
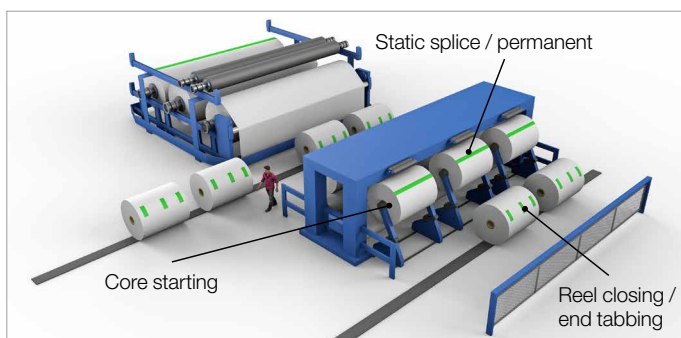
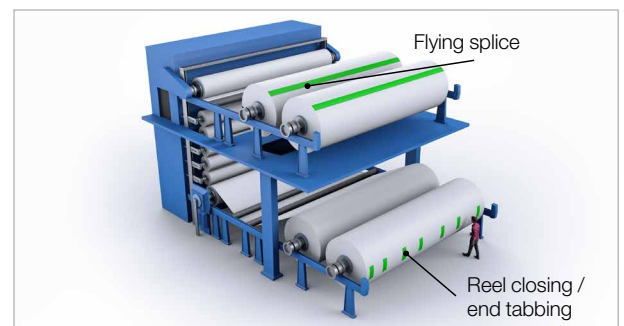
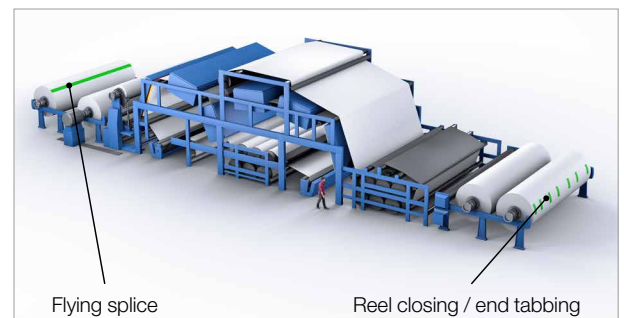
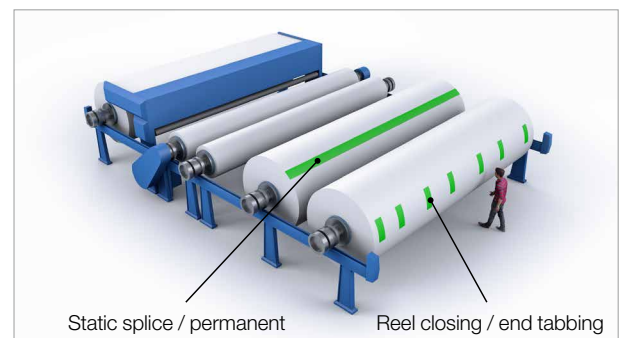
ORAFOL offers a wide range of repulpable splicing tapes for pulp and paper mill industry. The marked proven tapes guarantee secure and reliable splicing performance, no matter what temperatures, widths, machine speeds or web tensions are used. The FDA compliant adhesives used on ORAFIX® repulpable splicing tapes have high tack and shear strength, fast water re-solubility and offer proven repulpability.

ORAFIX® repulpable splicing tapes are designed for every stage in paper making and paper processing, e.g. static and flying splice at calenders, re-reelers, printers, coaters, etc., for core starting and end tabbing as well as for „Quick Splice“ application. ORAFIX® repulpable splicing tapes are available in green adhesive colour as 1290-series or with transparent adhesives as 1280-series. For wasteless production, 1260-series offers repulpable liner.

## Benefits of ORAFIX® splicing tapes

- Secure and reliable splicing performance, at all temperatures and environmental conditions
- Proven repulpability according to TAPPI UM 213 over full pH-range
- Faster water re-solubility of the adhesive layer
- Long lasting tackiness at prepared rolls
- FDA Certification\* available for all products
- Repulpable liner versions for wasteless production available

\* All adhesives are compliant with Code of Federal Regulations, Food and Drugs (FDA), 21 CFR Ch. I, §175.105



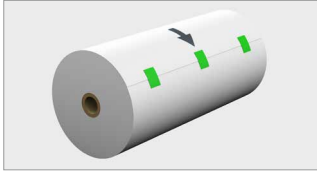


# Repulpable Tapes for Paper and Pulp Industry

ORAFIX® tapes offer reliable adhesion and shear strength for secure reel closing or end tabbing without popping off.

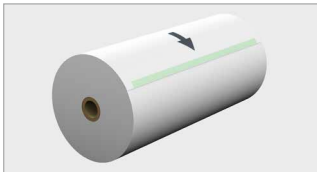
## Reel closing / tabbing

### End tabbing



- **1295** for thin or lightweight paper
- **1296** for most paper grades
- **1297** for heavy or rough paper
- **1299** "creped" paper backing compensates dimensional changes in the paper

### Reel closing

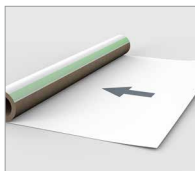
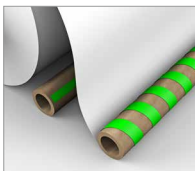


- **1288** splittable carrier for secure roll closing and easy opening for lightweight paper
- **1258** splittable carrier for secure roll closing and easy opening for lightweight paper
- **1282LT** transfer tape for automatic application

ORAFIX® tapes with slip resistant, high tack adhesives for core starting.

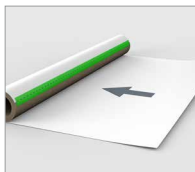
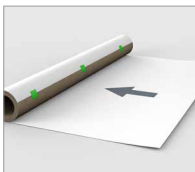
## Core starting

### Double sided tape



- **1258** splittable carrier, cores are reusable without cleaning, for lightweight paper
- **1288** splittable carrier, cores are reusable without cleaning
- **1282LT** transfer tape for automatic application
- **1293** thin tape for most paper grades

### Single sided tape

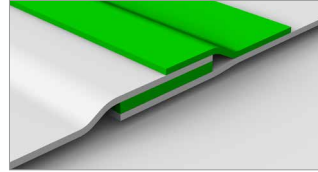


- **1294** for most paper grades
- **1296** for most paper grades
- **1297** for rough or heavy paper

ORAFIX® tapes are the best choice for secure processing without adhesive bleeding and with strong shear resistance.

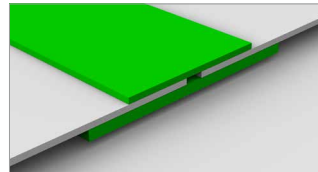
## Permanent / static splice

### Overlap splice products



- **1260** stiff carrier prevents tape from twisting even on wide paper reels, repulpable liner
- **1290** for permanent splices of most paper grades
- **1293** thin tape for reliable splices
- **1282LT** for thin or lightweight paper

### Butt splice products



- **1294** the standard tape for butt splicing
- **1294SL** slit liner for easy application
- **1295** as cover tape, for lightweight paper
- **1296** for most paper grades
- **1297** for rough or heavy paper, high tensile strength

ORAFIX® Quick Splice tapes are designed for quick and easy roll preparation as well as reliable splicing performance at highest speeds. ORAFIX® double sided tapes are ideal for permanent overlap splicing of coated and uncoated papers.

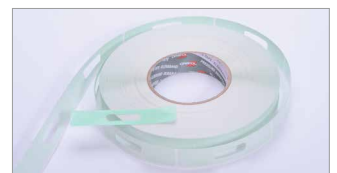
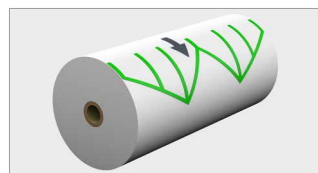
## Flying splice

### Quick splice products



- **1250QS** for high speed splicing
- **1251QS** black adhesive for optional detection
- **1490QS** non-repulpable, red adhesive for optical detection

### Traditional pattern



- **1260** for flying splice with repulpable liner
- **1290** for flying splices of most paper grades
- **1291** for high speed flying splices of heavy or rough paper
- **1293** for high speed flying splices of most paper grades
- **1294BF** "Butterfly" tabs for top sheet fixing

## Double-sided repulpable tapes

Product	Application	Carrier	Colour	Thickness (micron)
<b>ORAFIX® 1290</b>  FDA	Permanent splices	Tissue paper	green	90
<b>ORAFIX® 1291</b>  <b>ORAFIX® 1281</b> FDA	Flying splices	Tissue paper	green	100
			white	
<b>ORAFIX® 1293</b>  <b>ORAFIX® 1283</b> FDA	Flying splices or core starting of lightweight papers	Tissue paper	green	60
			white	
<b>ORAFIX® 1260</b>  FDA	Permanent splices	Paper	white	130
<b>ORAFIX® 1261</b>  FDA	Flying splices	Tissue paper	green	100
<b>ORAFIX® 1263</b>  FDA	Flying splices or core starting of lightweight papers	Tissue paper	green	60
<b>ORAFIX® 1282LT</b>  FDA	Core starting, reel closing, static splicing of thin papers, Automatic application	none	white	30
<b>ORAFIX® 1258</b>  FDA	Core starting, reel closing	Splittable paper	white	220
<b>ORAFIX® 1288</b>  FDA	Core starting, reel closing	Splittable paper	white	180



Features	Heat resistance	Tack (1 = low, 4 = high)	Adhesive
-	up to 200° C	2	RA 3
-	up to 200° C	4	RA 2
			RA 4
-	up to 200° C	3	RA 2
			RA 4
Repulpable liner	up to 200° C	2	RA 5
Repulpable liner	up to 200° C	4	RA 2
Repulpable liner	up to 200° C	3	RA 2
Transfer tape	up to 200° C	3	RA 4
Low opening force	up to 200° C	4	RA 5
High opening force	up to 200° C	4	RA 4

## Single-sided repulpable tapes

Product	Application	Carrier	Colour	Thickness (micron)
<b>ORAFIX® 1294</b>  FDA	Butt splices, core starting	Paper	green	110
<b>ORAFIX® 129408</b>  FDA	Butt splices with optical detection	Paper	black	110
<b>ORAFIX® 1295</b> <b>ORAFIX® 1285</b> FDA	Butt splices, cover tape or end tabbing of lightweight papers	Paper	green	55
			white	
<b>ORAFIX® 1296</b> <b>ORAFIX® 1286</b> FDA	Butt splices, core starting or end tabbing	Paper	green	100
			white	
<b>ORAFIX® 1297</b>  FDA	Butt splices, core starting or end tabbing for heavy or rough paper	Paper	green	190
<b>ORAFIX® 129702</b>  FDA	Butt splices or end tabbing for heavy or rough paper / cardboard	Paper, brown	green	190
<b>ORAFIX® 1299</b> <b>ORAFIX® 1289</b> FDA	End tabbing	Paper, creped	green	125
			white	
<b>ORAFIX® 1294SL</b>  FDA	Butt splices, core starting	Paper	green	110
<b>ORAFIX® 1294BF</b>  FDA	Butterfly tabs for top sheet fixing at flying splices	Paper	green	110





Features	Heat resistance	Tack (1 = low, 4 = high)	Adhesive
Printable and coatable backside	up to 200° C	4	RA 2
Optical splice detection Printable and coatable backside	up to 200° C	4	RA 10
Printable and coatable backside	up to 200° C	4	RA 2
			RA 4
Without liner	up to 200° C	4	RA 2
			RA 4
High tear resistance Without liner	up to 200° C	4	RA 2
Brown backing Without liner	up to 200° C	4	RA 2
High elongation Without liner	up to 200° C	3	RA 2
			RA 4
Center slit liner Printable and coatable backside	up to 200° C	4	RA 2
Butterfly die-cuts, based on 1294	up to 200° C	4	RA 2

# ORAFIX®

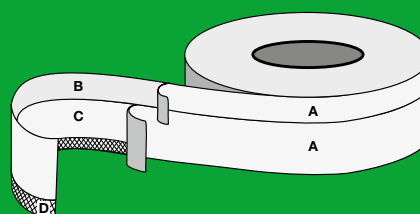
## Quick Splice Tapes



The innovative design of ORAFIX® 1250QS offers “Quick Splice” preparation combined with secure roll closure during high speed splicing operations, thus avoiding problems such as pre-opening of the splice and air traps in the rolls.

- Easy to use, with reduced risk of any splice failures
- Quick splice preparation
- No need for speed reduction
- No risk of air pockets caused by acceleration
- Eliminates the need for splicing tabs
- Available roll sizes: 38 mm x 33 m, 50 mm x 33 m, 63 mm x 33 m, 75 mm x 33 m

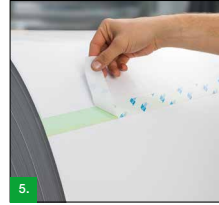
A = Release liner B = Reel closing adhesive  
C = Flying splice adhesive D = Splittable strip



Product	Application	Carrier	Colour	Thickness (micron)
ORAFIX® 1250QS  FDA	Flying splices	Paper	green	110
ORAFIX® 1251QS  FDA	Flying splices with optical detection	Paper	black	110
ORAFIX® 1490QS	Flying splices with optical detection for paper printing industry	Paper	red	120

## Performance Characteristics - Quick Splice Tapes

### Easy steps to a perfect quick splice:



**Figure 1 + 2:**  
Apply the tape under the top layer of the paper roll.  
Remove the upper part of the liner to expose the adhesive.

**Figure 3:**  
Attach the paper top layer  
onto the exposed adhesive  
part of the tape.

**Figure 4:**  
Fold back and remove  
excess paper tail.

**Figure 5 + 6:**  
Remove the lower part of the liner from the tape before  
accelerating the reel.



Features	Heat resistance	Tack (1 = low, 4 = high)	Adhesive
Quick splice preparation, repulpable Roll closing by integrated splittable strip For machine speeds up to 1600 m/min	up to 200° C	4	RA 3
Quick splice preparation with optical splice detection, repulpable Roll closing by integrated splittable strip For machine speeds up to 1600 m/min	up to 200° C	4	RA 10
Non-repulpable Quick splice preparation with optical splice detection Roll closing by integrated splittable strip For machine speeds up to 1600 m/min	up to 200° C	4	AM 17

# ORABOND®

## Non-repulpable tapes

Product	Application	Carrier	Colour	Thickness (micron)
<b>ORABOND® 1346</b> FDA	Splicing of paper, cardboard and film	Tissue paper	translucent	110
<b>ORABOND® 1459</b> FDA	Splicing of PE coated paper, film and cloth	Tissue paper	translucent	140
<b>ORABOND® 1259</b> FDA	Core starting, reel closing	Splittable paper	white	220
<b>ORABOND® 1301</b> FDA	Splicing of paper with optical detection	Tissue paper	red	90
<b>ORABOND® 1396LT</b> FDA	Splicing at high temperatures	Tissue paper	translucent	90
<b>ORABOND® 1396TM</b> FDA	Splicing at high temperatures	Tissue paper	translucent	130
<b>ORABOND® 1397PP</b> FDA	Splicing tape with extreme shear resistance	PET film	translucent	210

# ORAFIX®

## Silicone splice tapes

Product	Application	Carrier	Colour	Thickness (micron)
<b>ORAFIX® 1206</b>	Butt splices, core starting or end tabbing of siliconised papers and materials	PET film	transparent	90
<b>ORAFIX® 120705</b>	Butt splices, core starting or end tabbing of siliconised papers and materials with optical detection	PET film	green	90
<b>ORAFIX® 1305</b>	Butt splices, core starting or end tabbing of siliconised papers and materials	PET film	transparent	60



Features	Heat resistance	Tack (1 = low, 4 = high)	Adhesive
Hand tearable	+100° C	4	AD 3
Hand tearable	+70° C	4	SR 5
Low opening force	up to 200° C	4	AM 2
Hand tearable with optical splice detection	+140° C	4	AM 7
Hand tearable	+140° C	4	AM 2
Hand tearable	+140° C	4	AM 2
Extreme shear resistance, tear resistant PP liner	+160° C	4	AM 2



Features	Heat resistance	Tack (1 = low, 4 = high)	Adhesive
Without liner No backside siliconisation	up to 180 °C	3	Sil
Without liner No backside siliconisation Optical detection	up to 180 °C	3	Sil
Siliconised backside Crepped liner	up to 180 °C	4	Sil

# Prime applications

Application type	<b>ORAFIX®</b> Double Sided Splice Tapes							<b>ORAFIX®</b> Single Sided Splice Tapes					
	1260	1290	1291 green 1281 white 1261 repulpable liner	1293 green 1283 white 1263 repulpable liner	1282LT	1258 splittable	1288 splittable	1294	1294SL	129408	1295 green 1285 white	1296 green 1286 white	
Static splice / permanent	•	•		•	•			•	•	•	•	•	
Flying splice	•	•	•	•									
Core starting				•	•	•	•	•	•			•	
End tabbing											•	•	
Reel closing					•	•	•						
Optical detection										•			
Heavy duty													
Splicing of newsprint paper	•	•	•	•	•			•	•	•	•	•	
Splicing of paper	•	•	•	•	•			•	•	•	•	•	
Splicing of cardboard													
Splicing of film / aluminium													
Splicing of PE coated paper													
Splicing of siliconised paper and film													

## Adhesives

Name	Type	Properties & Features
AM 2	Modified solvent acrylic	High shear, high tack adhesive with excellent balance of properties for use in high performance bonding applications. This product features good adhesion to low surface energy plastics.
AM 7	Modified solvent acrylic	High shear and high tack adhesive with good temperature performance for paper and board splicing. The adhesive is coloured red for visual splicing applications.
AM 17	Modified solvent acrylic	High shear, high tack adhesive with excellent balance of properties for use in high performance splicing applications. The adhesive is coloured red for visual splicing applications.
AD 3	Modified dispersion acrylate	General purpose medium tack adhesive with good ageing performance on EPDM and other critical foams.
RA 2	Repulpable modified acrylate	Repulpable adhesive with good shear and temperature performance for paper and board splicing. Meets TAPPI requirements.
RA 3	Repulpable modified acrylate	Drier version of RA 2 to avoid bleeding problems. Meets TAPPI requirements.
RA 4	Repulpable modified acrylate	Repulpable adhesive with good shear and temperature performance for paper and board splicing. Meets TAPPI requirements.
RA 5	Repulpable modified acrylate	Drier version of RA 4 to avoid bleeding problems. Meets TAPPI requirements.
RA 10	Repulpable modified acrylate	Black version of RA 3. Meets TAPPI requirements.
Sil	Silicone	Adhesive with good adhesion to siliconised surfaces.
SR 5	Synthetic rubber	General purpose high tack adhesive for splicing and lamination applications.



**ORAFIX®**

Single Sided Splice Tapes

**ORAFIX®**

Quick Splice Tapes

**ORAFIX®**

Silicone Splice Tapes

**ORABOND®**

Non-repulpable Tapes

	1297	129702	1299 green 1289 white	1294BF	1250QS	1251QS	1490QS	1206	120705	1305	1346	1459	1259 splittable	1301	1396LT	1396TM	1397PP
	•	•						•	•	•	•	•		•	•	•	•
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