



What is Remoist Gum?

Re-moist gum, also known as Lick & Stick, Horse Shoe Gum, Goal Post Gum, U Shape Gum, Strip Gum, Stencil Gum is a glue applied to paper or board that once cured dry can later be activated by moisture allowing a further bond to take place with an opposing paper/board substrate.

What part does Packaids do?

We will apply liquid gum as an overall coating or stencil shape to fit as required to your paper or board before or after it has been printed.

If requested, we can then die cut, fold, stitch, trim to finish size, low-tac (such as mailers) or convert (such as envelopes) to the finished item.

For many clients, we will often remoist gum large runs of B1 blank paper with multiple stencils that we then trim down to 1up and return ready for use in digital presses at a later stage.

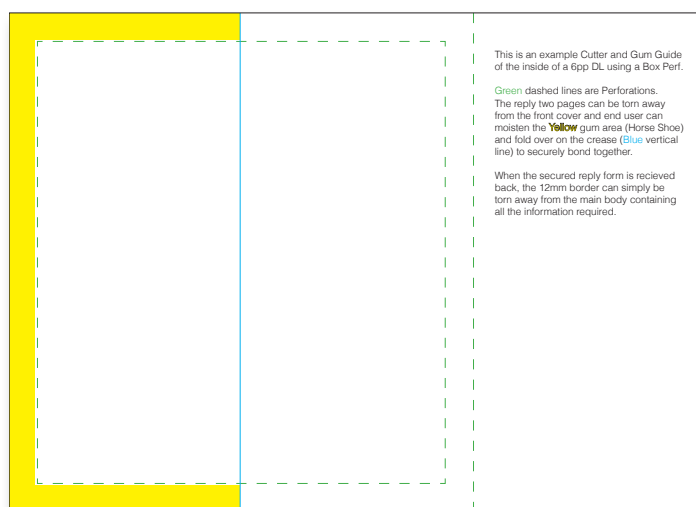
Why Packaids?

Packaids has over forty years experience of putting gum onto paper, we also have five automated presses dedicated to gumming paper sizes from B1 size down to SRA4.

Packaids use specialised radio frequency dryers on all our machines. This gives our clients a better returned sheet as our heating method targets only the water content in the remoist gum which is receptive to the effect of dielectric heating. Being able to heat only the dominant areas which contain the most water (i.e. the gum) means the rest of the printed sheet loses hardly any moisture compared to other drying methods, the sheet also remains cooler which means no unnecessary stress or damage to the paper will occur. The other great advantage to our drying method means that we do not need large percentages of solids in our remoist gum solution, and so we use very clear, clean and transparent gum with a pleasant taste, and on the odd occasion we are asked to we can even apply a coloured gum.

Considerations:

For most reply forms, a horse shoe stencil is usually the perfect solution, if the reply forms being printed are of a large quantity, then perhaps either a 'box perf' or a 'knife gap' would speed things up once the forms are returned.



See page 3 for example cutter guides used for remoist gum in conjunction with a **Box Perf or Knife Gap**.

If the end user is writing confidential details into a reply form, then the more secure the better and we would highly recommend using an uncoated stock with no ink or coatings in the area that we will be applying the remoist gum, printing with a spot sealer can be a good solution.

Packaids recommends a minimum of 6mm wide (after trimmed to size) coverage of gum to be effective, we can go as large as you require (subject to the substrates weight, please see 'Storage and Shelf Life' over).

Advice

Remoist gum works best when set directly onto uncoated virgin fibre, this will ensure fibre tear in most cases. When 'making ready' we always test the bond strength before running, and if a simple horse shoe is not sufficient to create a strong enough bond on the sheet supplied, we will of course query this and recommend a gum to gum

Please see over leaf.



PACKAIDS REMOIST GUMMING



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stencil all the way around (just as with any kind of glue, the surface fibres of the paper need to be a weaker bond than the gums adhesion strength to enable fibre tear, and so coated or sealed items can require additional advice such as a gum to gum solution, this is more typically queried on silk, gloss, or coated sheets.

All of our remoist gum solutions are laser compatible as standard.

Ink

Applying remoist gum to heavy ink coverage areas or is not a problem, however, once the gum is activated and bonded, there will be little fibre tear when pulled apart, as the ink will be pulled off the substrate due to the gum sitting on the ink, and the ink will only have a weak bond to the paper. Solid metallic inks are not recommended.

Storage and Shelf Life

Remoist gummed sheets can be left before activation for over six months.

It may seem an obvious thing to point out, but the gum is activated by moisture!, so if sheets are left in a humid or damp place, the gum can activate and sheets can 'block' solid.

Due to our drying process and specially formulated gum that we use, we are able to bleed the gum off the finished trim size with no issues when guillotining under pressure.

Gummed sheets should be kept in cool, dry conditions and not double stacked.

Other suppliers of remoist gum will state that your sheets will never curl after gum application. This is not true, it is all dependant on the weight of paper against coverage of gum. An 80gsm uncoated paper with 100% gum coverage will end up as bumpy and wavy as bumpy and wavy gets. Any sheet of paper or board which has been applied with any kind of coating on one side which is not equaled on the opposite side will have a stress put upon it and can show this effect.

If Packaids gum one corner of an SRA2 sheet, it

will be apparent in a stack of 3,000 sheets that the gummed corner is higher up than the rest of the sheet, this is not curling, just purely down to the thickness of the paper and gum combined being greater than the rest of the sheet that is not gummed, however this will never be noticeable on individual sheets.

Packaids Sheet Specifications

Maximum Thickness: 3mm

Minimum Weight: 80gsm

Maximum Sheet Size: 1040mm x 760mm

Minimum Sheet Size: A4

(we can run smaller, please call for advice).

Recommended Uses

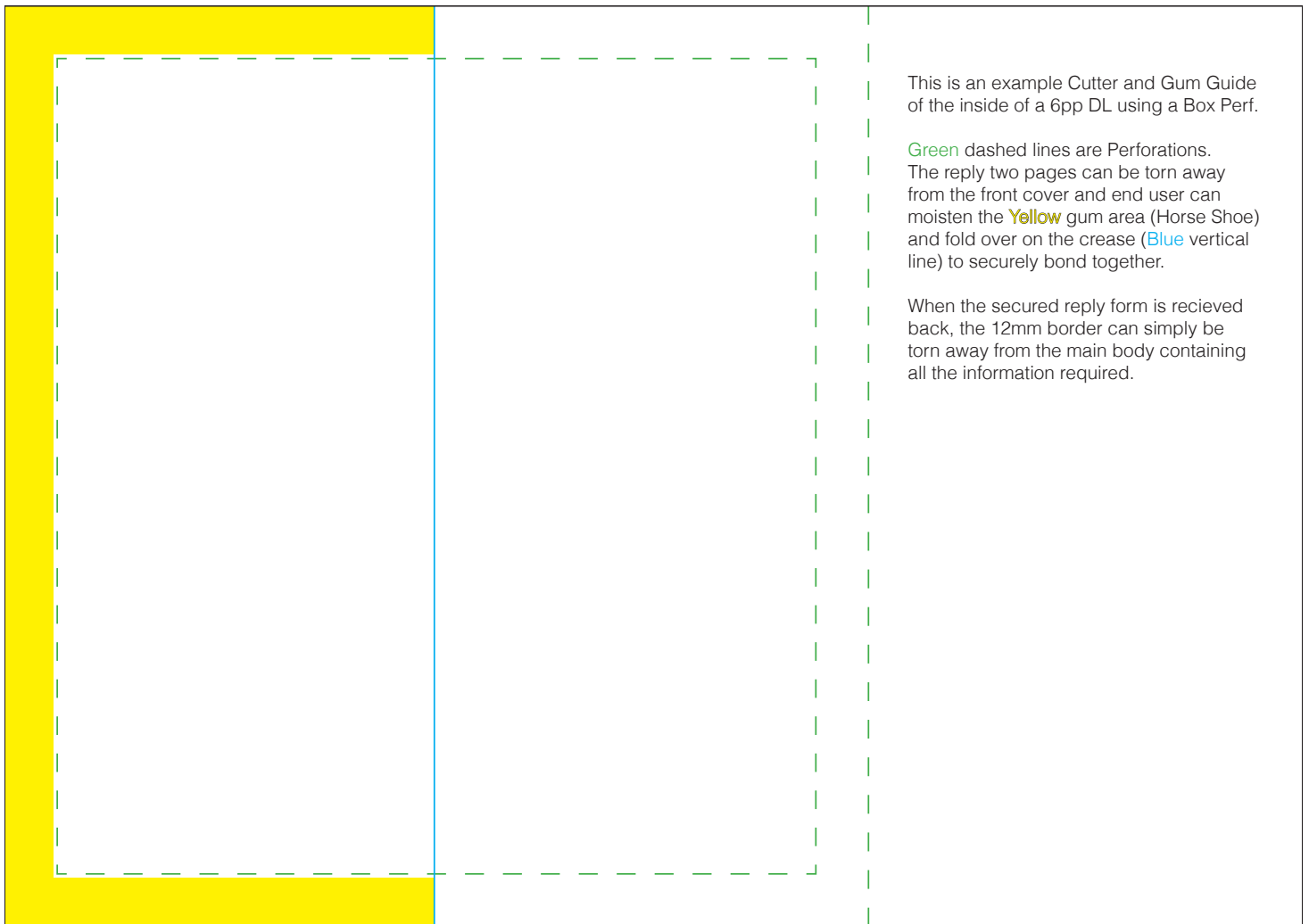
Tear-off Reply Forms, Car Window Parking Notices, Exam Sheet Covers, Bunting, Envelopes, Mail back forms, Application Forms, Pay Slips Security Gumming, Stamps, Bottling labels, Wrist Bands, Personnel Sheet Files, Tear-off Coupon Stamps.

Above: Example of an exam sheet which has remoist gum applied to the corner which will fold diagonally.

Alternatives

Either Peel & Seal Tape or Self Seal Latex are good alternatives. Packaids can apply tape automatically as a good alternative on envelopes, or we can apply Self Seal Latex (Most commonly seen on self seal envelopes) this can be used in most of the above recommended uses for gum.

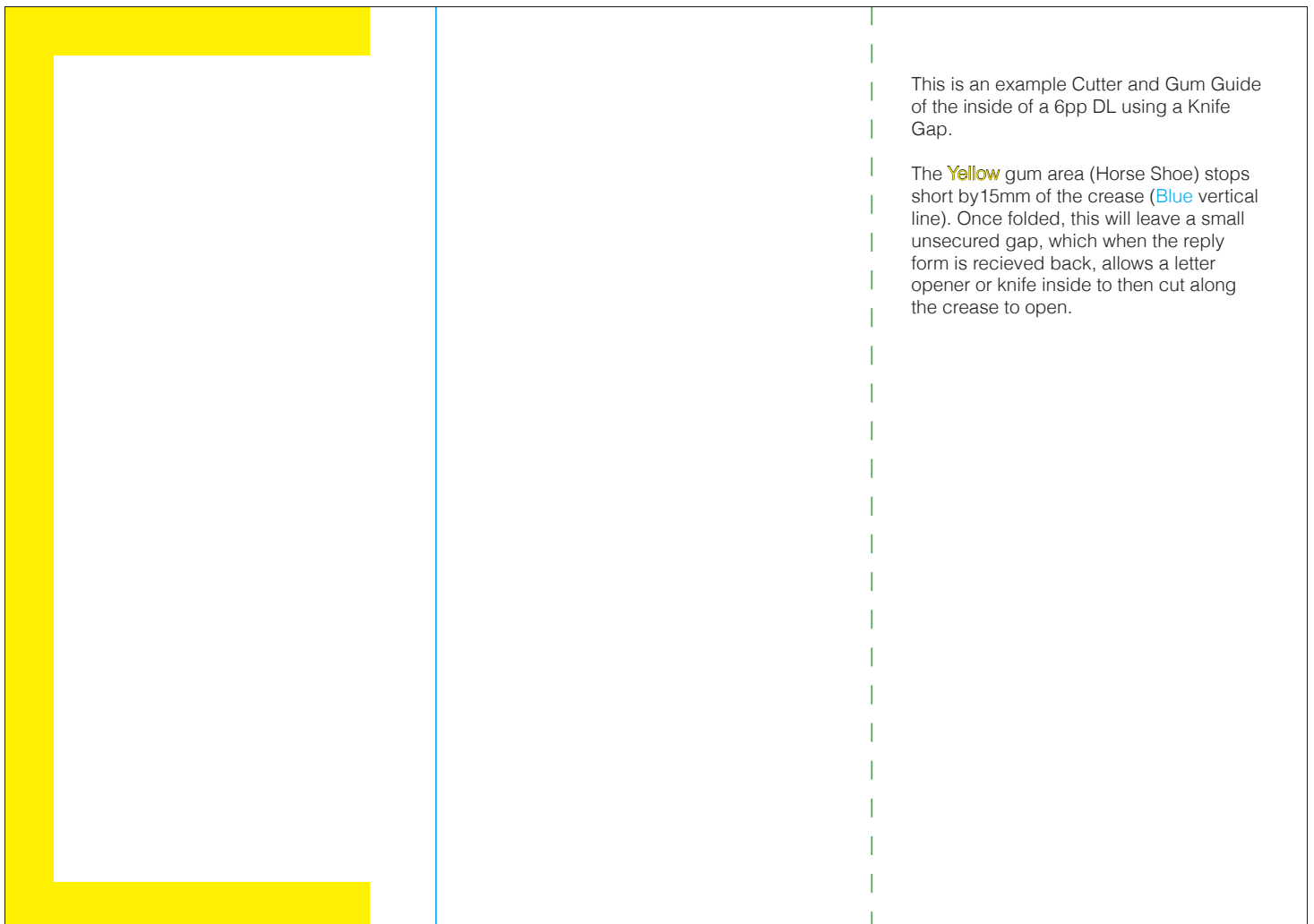
All advice and recommendations are given subject to trial.



This is an example Cutter and Gum Guide of the inside of a 6pp DL using a Box Perf.

Green dashed lines are Perforations. The reply two pages can be torn away from the front cover and end user can moisten the Yellow gum area (Horse Shoe) and fold over on the crease (Blue vertical line) to securely bond together.

When the secured reply form is recieved back, the 12mm border can simply be torn away from the main body containing all the information required.



This is an example Cutter and Gum Guide of the inside of a 6pp DL using a Knife Gap.

The Yellow gum area (Horse Shoe) stops short by 15mm of the crease (Blue vertical line). Once folded, this will leave a small unsecured gap, which when the reply form is recieved back, allows a letter opener or knife inside to then cut along the crease to open.