

GLOSSARY OF
LETTERPRESS ROTARY
PRINTING TERMS
USED IN CONNECTION WITH NEWSPAPER
MAGAZINE & SIMILAR MACHINES

B.S. 3814 : 1964

THIS BRITISH STANDARD, having been approved by the Printing, Stationery and Allied Trades Standards Committee, was published under the authority of the General Council on 16th November, 1964.

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The following B.S.I. references relate to the work on this standard:
Committee reference S/31 Draft for comment AB(S) 7865

CO-OPERATING ORGANIZATIONS

The Printing, Stationery and Allied Trades Standards Committee under whose supervision this British Standard was prepared consists of representatives from the following Government department and scientific and industrial organizations:

- *Association of British Manufacturers of Printers' Machinery
- *British Federation of Master Printers
- *British Paper & Board Makers' Association (Incorporated)
- Business Equipment Trade Association
- Electrotyping & Stereotyping Employers' Federation
- Envelope Makers' & Manufacturing Stationers' Association
- Federation of Master Process Engravers
- *H.M. Stationery Office
- National Association of Paper Merchants
- *Newspaper Society
- Periodical Proprietors Association Ltd.
- *Printing, Packaging & Allied Trades Research Association
- Society of British Printing Ink Manufacturers
- Stationers' Association of Great Britain & Ireland

The Government department and scientific and industrial organizations marked with an asterisk in the above list, together with the following, were directly represented on the committee entrusted with the preparation of this standard:

National Graphical Association
Newspaper Proprietors Association

BRITISH STANDARD

GLOSSARY OF LETTERPRESS ROTARY PRINTING TERMS

USED IN CONNECTION WITH NEWSPAPER, MAGAZINE AND
SIMILAR MACHINES

FOREWORD

This British Standard, prepared under the authority of the Printing, Stationery & Allied Trades Standards Committee as a result of a request received from the Printing, Packaging & Allied Trades Research Association, is intended to contribute to the reduction of the confusion which does exist in the terminology at present in use in the rotary letterpress printing industry.

This glossary relates particularly to usage within the British printing industry and attention is drawn to B.S. 3203, 'Glossary of paper, stationery and allied terms', to which reference should be made if problems relating to paper are met with in the course of international trade.

GLOSSARY

PART 1. REEL AND PAPER CONTROL

No.	Term	Definition
1001	automatic reel change autopaster FLYING PASTER	Equipment for attaching a new reel of paper to the old web whilst the web is still running, synchronizing the speed of the new reel with the web which is then severed.
1002	badly shaped reel MISSHAPEN REEL	A reel of paper not truly cylindrical.
1003	belts MOVING BELT BRAKING RUNNING BELT TENSION	Metal, leather or composition strips applied to the outside of the reel of paper to act as a brake on the reel, and thus increase the amount of pull or tension on the web. The belts may be stationary or running.
1004	belts on	See <i>brake down</i> (1007).
1005	brake	The manual or automatic mechanism applied to the reel spindle or reel for controlling the tension of the web of paper when the printing machine is running.
1006	brake bands	Leather, metal or fabric strips applied to a drum or pulley on the reel shaft (see <i>belts</i> (1003)).
1007	brake down	The action of applying extra pressure to the brake to increase the tension of the web.

No.	Term	Definition
1008	brake drum BRAKE CONES	A flat or 'V'-surfaced wheel attached to one end of a reel spindle upon which pressure is exerted to control the tension of the web.
1009	brake hand	The operator on a rotary machine responsible for adjusting the reel brake and reel side margin control. He may also be the <i>controller hand</i> (2041).
1010	brake shoes	Holders for brake linings or brake blocks.
1011	brush	1. A device for pressing the running web against the new reel when the join is made on an <i>automatic reel change</i> (1001). 2. A device for removing surface dust from paper.
1012	butt end REEL END STUB	The unused paper left on the reel centre after the reel has been run to its practicable limit.
1013	calender crease	A crease in the web of paper brought about during the smoothing or calendering process at the paper mill. In extreme cases this may lead to an actual cut in the paper ('calender cuts').
1014	core	See <i>reel core</i> (1037).
1015	detector finger	See <i>web-break detector</i> (1068).
1016	dinky sheet	A web considerably narrower than the full width of the press.
1017	hand pasting	The procedure for manually attaching a new reel of paper to the expiring web.
1018	idler or idling roller PIPE ROLLER	A free running roller.
1019	jockey roller COMPENSATOR SPRING LOADED IDLER DANCING ROLLER COMPENSATING ROLLER	A roller, usually the first to be traversed by the web, mounted to compensate for any uneven tension as the reel unwinds.
1020	join SPLICE	The adhesion between the ends of two webs to ensure the continuous run of paper through the printing machine.
1021	knife	The blade or blades on an automatic reel change that sever the old web after the join has been made. (Also see <i>cut-off knife</i> (3020).)
1022	magazine reel stand	The structure for supporting the reel in running position with one or more reels in the ready position.
1023	mill join	An adhesion between the ends of two similar webs during manufacture to ensure continuous run of web as the reel unwinds. The joints may be marked by the mill for the guidance of the printer.
1024	paper dust or fluff	Fibre (fluff) or loading (dust) which leaves the web as it passes through the printing press or slitters.

No.	Term	Definition
1025	paste	1. The action of operating an automatic paster to replace the old reel with the new reel. 2. Securing two webs of paper together in the run of the press. 3. See <i>join</i> (1020).
1026	paste duct	A container for adhesive.
1027	paste gun	A hand-operated appliance used to facilitate the even distribution of adhesive to the free end of a reel of paper.
1028	paster disc or head	A device for applying a strip or film of adhesive.
1029	paster pump	The means of feeding adhesive to a paster disc or head.
1030	paster tab	A strip of gummed paper with a weakened section or other device which is used to secure the prepared end of the new reel prior to joining it to the old reel on an automatic reel change.
1031	pasting join	See <i>paste</i> (1025).
1032	reel arms	Those parts of the reel stand that support the centre or spindle of the reel of paper.
1033	reel bogie DOLLY TRUCK REEL TRUCK	A truck for transporting a reel of paper.
1034	reel brake	See <i>brake</i> (1005).
1035	reel braking	Applying tension to the web when the machine is running.
1036	reel cone	A metal cone inserted into the ends of the reel core to ensure that it runs concentrically on the reel spindle or between the reel arms.
1037	reel core REEL CENTRE	The tube upon which the paper web is wound.
1038	reel hand	The operator responsible for preparing and loading the reel of paper to run on the printing press.
1039	reel hoist	Mechanism for lifting reels of paper.
1040	reel room	The floor on which the reel stands are located directly under a unit type press.
1041	reel stand	The structure for supporting the reel, or bringing it into position, or both.
1042	rewind	1. The procedure for taking several butt ends of reels of paper and winding them into a reel for use in the press. 2. See <i>re-reeler</i> (2151).
1043	rewind join	The adhesion between the butt ends of two webs which are wound into a reel in the printing works.

No.	Term	Definition
1044	roll stand	See <i>reel stand</i> (1041).
1045	running belts	See <i>belts</i> (1003).
1046	sidelay	The side margin of the work controlled by the lateral position of the web or reel in the press.
1047	sidelay control SIDE MARGIN CONTROL	Means of moving the web or reel laterally.
1048	slack edge	A web which has one edge longer than the other.
1049	slack sheet	1. Distortion in the web causing looseness. 2. A loose web caused by incorrect tension control. 3. See also 2185.
1050	slime holes (SPOTS)	A defect in paper occurring as holes or patches caused by slime growths.
1051	slipping core	1. Loose paper near the reel centre which allows the reel to move on the core. 2. Reel centre rotating on the cones.
1052	shives SLIVERS	Small pieces of wood fibre in the body of the paper.
1053	spider	A multiple arm structure supporting reels of paper.
1054	spindle	The shaft that extends through the core of a reel of paper for running in a reel stand.
1055	spindle up	Preparing a reel of paper for running in a reel stand by inserting the spindle or shaft and engaging the cones.
1056	spindleless reel stand	A reel stand supporting the reel on free-running cones at each side of the reel.
1057	static	An electric charge on paper or press surfaces.
1058	stripping	Removing the outer wrappers and damaged outer layers from a reel of paper.
1059	substructure	That part of the printing machine which supports the main printing units and usually carries the reels.
1060	sub-truck	A movable platform used on the press to transport the reel into the loading position.
1061	superstructure TOP RAIL SECTION	That part of the printing machine which is above the level of the main printing units.
1062	tension control	The means for regulating the application of braking effort to the reel of paper or controlling the feed of paper into the press.
1063	tension roller JOCKEY ROLLER, <i>deprecated</i>	The device which detects variations in the pull on the web and operates the tension control.

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No.	Term	Definition
1064	tight edged	A reel which has dried out at the edges, resulting in a web which is slack in the middle.
1065	top side	The face of the web opposite to the wire side (see <i>wire side</i> (1070)).
1066	web	Paper from a reel that has been threaded through the press.
1067	web-break	The parting of the paper while the press is running.
1068	web-break detector	A device for automatically stopping the press when the web breaks.
1069	web tension	The amount of pull on the web.
1070	wire side	The face of the web in contact with the wire mesh on which the paper is formed during manufacture.

PART 2. PRINTING

No.	Term	Definition
2001	angle bars TURNER BARS	Bars set at an angle to transfer one or more ribbons of paper over each other, or the web from one side of the press to the other or at right angles to its previous flow.
2002	automatic blankets	Felt blankets with a top coating of rubber or plastics material used for covering the impression cylinder.
2003	backing up	1. Printing on the second side of the paper when the first is already printed. 2. See <i>underlay</i> (2219).
2004	banjo	The end adjusting duct screw.
2005	bearer rings BEARERS CYLINDER BEARERS	Circumferential bands fixed to the plate and impression cylinder ends or integral with them. The diameter of these bands provides a datum for cylinder packing and for the exact centre distance of the cylinders.
2006	bed	1. The foundations upon which a printing press is erected. 2. The table carrying the printing surface on certain reel-fed presses.
2007	bed latch	1. The safety catch securing the platform between reel stands. 2. The means of securing the forme on certain reel-fed presses.
2008	bed plate	The bottom section of the frame on which the press is built.
2009	belly	The raised portion of a printing plate that does not conform to the cylinder surface on which it is mounted.
2010	bevel	The angled edge on the plate on which the dogs act.
2011	bill machine	A small rotary or flat-bed press used for printing news content bills.
2012	blacking up	Printing of the non-image areas.
2013	blanket	A textile, rubber, plastics, cork or composition covering for the impression cylinder.
2014	blanket bar	See <i>blanket wind</i> (2018).
2015	blanket clamp	The means used to locate the fixed end of a cylinder packing blanket to the impression cylinder.
2016	blanket pins	Pins used to attach the blanket or canvas to another sheet on the blanket wind.
2017	blanket tail	The piece of blanket which is sewn to the end of the blanket for attaching it to the blanket bar.
2018	blanket wind	The means of tensioning the loose end of a cylinder packing blanket, usually a rotating bar round which the blanket is wound.

No.	Term	Definition
2019	bolster	The high portion or edges of the blanket not compressed by the printing plate.
2020	bolster marks	1. Ink or grease in margins caused by bolsters in contact with the web. 2. Uneven impression produced by printing on previously formed bolsters.
2021	bridge	The detachable support for the dividers or blade adjusting screws of some ink ducts.
2022	bubbling	1. Swelling of rubber blankets or rollers caused by oil or solvent. 2. The effect produced on a printing plate, caused by a defective mould.
2023	buckling	The distortion of a printing plate caused by excessive pressure from a compression type lock-up.
2024	bull horn wrench	A wrench used in connection with a particular form of <i>instantaneous plate lock-up</i> (2099).
2025	captive tapes	Tapes which operate only at slow speeds for the purpose of threading the web.
2026	centre margin ring	The bevelled circumferential strip on a plate cylinder against which the printing plates are locked.
2027	chase	A metal frame in which assembled type matter, furniture, blocks, etc., are made up and locked in position (see <i>forme</i> (2068)).
2028	chattering	The noise made by loosely fitting gears.
2029	circumferential register adjustment	The adjustment of one operation in the press in relation to another in the direction of the run of the paper.
2030	circumferential register screws	Adjustable screws in place of margin strips allowing slight movement of the printing plate around the cylinder.
2031	clamp bar	1. A bar used to lock or unlock the mechanism that holds the plates to the press. 2. A bar used to hold the blankets in position on the pins on an impression cylinder.
2032	colour adjusting	Regulating the flow of ink.
2033	colour control	The maintenance of consistency of the colour.
2034	colour printing	Printing in two or more colours to simulate a design or picture in its original colours.
2035	colour register REGISTERED COLOUR REGISTERED COLOUR PRINTING	The accurate aligning or superimposing of one colour over another in succession on the web.
2036	column screw	A duct adjusting screw which regulates the flow of ink to one column of printed matter.

No.	Terms	Definition
2037	columns across	Printing with the column length imposed across the cylinder.
2038	columns around	Printing with the column length imposed around the cylinder.
2039	compensating plate lock-up	A compression plate lock-up which incorporates resilient means to compensate imperfections in the plate bevel.
2040	compression plate lock-up	A mechanism for locking up printing plates on to the plate cylinder by means of movable dogs which operate on the angle edge of the plate from the side towards the centre of the cylinder. (See also <i>tension plate lock-up</i> (2209).)
2041	controller hand	The operator responsible for operating the warning system and stopping and starting the machine from the main control position.
2042	cover unit	A separate printing unit coupled to the main press for producing the cover of a magazine or paper.
2043	cutting colour	Reducing or stopping the flow of ink.
2044	cylinder brakes	The mechanism fitted to a fast running printing press in order to stop it quickly.
2045	cylinder dressing	1. The combination of the under rubbers and the automatic blankets on the impression cylinder of newspaper presses. 2. Any sheets or packing used to produce the correct height of an impression surface on an impression cylinder.
2046	decks	Pairs of horizontal printing couples arranged one above the other.
2047	distributor DISTRIBUTOR ROLLER	A rubber or composition roller rotating in contact with a distributing drum, and sometimes arranged to move a small distance laterally to spread the ink.
2048	dogs	Bevelled clips which slide in grooves on the plate cylinder holding the plates firmly in position.
2049	dog ways	Slides or slots machined in the plate cylinder in which dogs operate.
2050	double octuple	A newspaper press of double width, four pages wide, eight perfecting units or decks.
2051	double plate	Two sets of plates on a machine so that, for example, tabloid newspapers are produced on a full sheet press (see <i>two set</i> (2215)).
2052	double sextuple	A newspaper printing press of double width four pages wide, six perfecting units or decks.
2053	double width press	A newspaper printing press four standard pages wide.
2054	downer	A sudden breaking of the web while the printing press is in operation.