Our guide to tape

consists of three chapters:

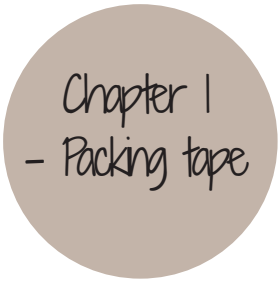
1. **Packing tape – the art of choosing the right tape**
2. **Handling tape – things to consider**
3. **Printed tape – benefits and opportunities**

The Little Tape School is divided into three parts, and the purpose is to help you understand how tape works so you can more easily choose the right tape.

The choice of tape is governed by several parameters, such as the packing environment and the material to be sealed. However, the purpose of the tape is also an important factor to consider. Should the tape adhere to a smooth or rough surface, and is it in a cold or warm environment? In this tape school, we will guide you through three chapters to help you choose the right tape.

Chapter 1 – Packing Tape

The art of choosing the right tape



The choice of packing tape is determined by several factors, such as the packing environment and the material to be sealed. By understanding these parameters, the risk of making the wrong choice and the tape not performing as intended is minimized. The right solution also reduces the risk of complaints.

DIFFERENT TAPES FOR DIFFERENT PURPOSES

Choose your tape based on the purpose, and consider the environment where it will be used.

PP PACKING TAPE

Characterized by light to medium unwinding with high elasticity. Many PP tapes are UV-resistant outdoors and often more environmentally friendly than PVC tapes.

PVC PACKING TAPE

Characterized by medium to heavy unwinding with low elasticity and a more matte surface. Adheres well in humid environments.

STRAPPING TAPE

A strong tape with high tensile strength, used for sealing heavier goods, bundling, securing, and transport stabilization.

DOUBLE-SIDED TAPE

Adheres to most surfaces and can be used for many different purposes. Available in various thicknesses and with different adhesives.

MASKING TAPE

A reliable tape with versatile functionality, often used for surface protection and painting. Many masking tapes have good adhesion even on uneven surfaces.

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Chapter 1
– Packing tape

√ APPLICATION IN COLD ENVIRONMENTS
Choose an easy-to-unwind tape with a thick layer of adhesive, preferably a rubber-based adhesive.

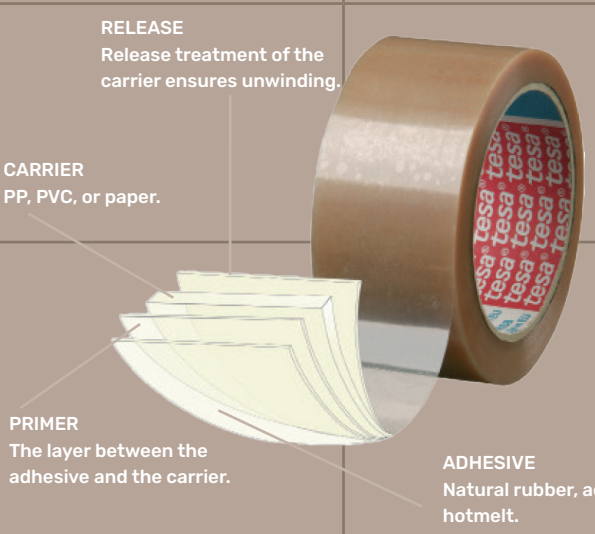
√ APPLICATION IN WARM ENVIRONMENTS
Choose a PP tape, which can withstand temperatures between 120-150°C.

√ APPLICATION IN HUMID ENVIRONMENTS
PVC tapes with slow unwinding

QUICK GUIDE TO PACKING TAPE

The carrier material, together with the adhesive, determines the properties of the packing tape. The right combination ensures a stable and secure seal.

TYPE / ADHESIVE	PP PACKING TAPE (best in warm environment)	PVC PACKING TAPE (best in cold environments)	PAPER TAPE (best for the environment)
	- Easy to medium unwinding - High elasticity - Glossy surface	- Medium to slow unwinding - Low elasticity - Matte surface	- Easy and smooth unwinding - High adhesive strength
NATURAL RUBBER	√ Cost-effective with good sealing properties. High tensile strength and sealing capacity. X High tensile strength and sealing capacity.	√ Good formability and sealing quality, withstands shock loads. X Relatively slow unwinding.	√ Low elasticity under high loads, can be torn by hand. X Limited temperature resistance.
ACRYLIC	√ Good aging resistance and silent unwinding. X Lower initial adhesive strength on cardboard.		
HOTMELT	√ Cost-effective with good sealing properties. High tensile strength and sealing capacity. X High tensile strength and sealing capacity.		



Chapter 2 – Handling Tape

Things to consider

Chapter 2 – Handling tape

DIFFERENT TAPES FOR DIFFERENT SUBSTRATES

The choice of packing tape for sealing corrugated boxes depends on the quality and thickness of the corrugated cardboard. If the cardboard mainly consists of recycled fibers/testliner, packing tape with rubber adhesive is recommended.

For boxes with virgin fiber, packing tape with acrylic adhesive is often sufficient.

SINGLE-WALL CORRUGATED CARDBOARD

Characterized by light to medium unwinding with high elasticity. Many PP tapes are UV-resistant outdoors and often more environmentally friendly than PVC tapes.

DOUBLE-WALL CORRUGATED CARDBOARD

For medium to heavy goods, boxes made from double-wall corrugated are suitable. The pressure on the carton flap is higher and requires stronger tape.

TRIPLE-WALL CORRUGATED CARDBOARD

If the goods are extremely heavy or hazardous, most corrugated boxes are made from triple-wall corrugated. The carton flap is exposed to high pressure, and the tape must have high adhesive strength.

Chapter 2 – Handling Tape

Things to consider

Chapter 2 – Handling tape

SEALING

When applying packing tape, there are several questions that can guide how the application should look:

- What is being packed?
- How should it be packed?
- What is important for transport and storage?

L-SEAL

For lighter goods.

U-SEAL

For lighter goods and longer transports, or for heavier goods.

U & L-SEAL

For heavy goods and longer transports.

H-SEAL

For extremely heavy goods.

IF THE TAPE COMES LOOSE

There are various reasons why the tape comes loose:

- Cold/heat
- Working/storage temperature
- Incorrect application
- Stretching during application

! ! Storing in containers under direct sunlight can also cause problems.

STORAGE

Tape should be stored lying on its cut edge at a temperature between 15-22°C.

Preferably, keep the outer packaging around the tape, as it protects against UV, dust, and moisture. Store the tape in a dry place and not in direct sunlight. Tape has a limited shelf life, so use the oldest tape first.

WE RECOMMEND

PVC + Rubber Adhesive

For demanding closures and very heavy cartons, when there are no environmental requirements.

PP + Acrylic Adhesive

For demanding closures and (very) heavy cartons, when environmental requirements are in place.

PP + Acrylic Adhesive

For medium-weight cartons, when environmental requirements are in place.

PP + Hotmelt Adhesive

For simpler closures.

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Chapter 3 – Printed tape
benefits and opportunities

Chapter 3 – Printed tape

Many companies recognize the advantage of branding their tape with the company's logo.

Custom tape guarantees quality and security. It becomes harder to tamper with the packaging without it being noticed when it's sealed with a customer-specific tape. There are many advantages to custom printed tape – brand building, theft protection, identification, technical information, etc. The list goes on. We are happy to assist you.

POSITIVE OR NEGATIVE PRINT?

Positive print generally gives the best result as images and text are printed directly with the ink color you have chosen. In negative print, it's the opposite: everything except the text and image is filled with ink.

A general rule is that the distance between the prints should be the same as the width of the tape. The print length, i.e., the length of the printed image, can be a maximum of 600 mm.

It is important to remember that the ink color must always be darker than the background, and color variations may occur depending on the color of the tape itself.

PRINT COLORS

When printing, colors from the PMS scale are used, and it helps if you can provide PMS codes during the proofing process.

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Chapter 3 – Printed tape
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Chapter 3 – Printed tape

There are many different printing options, but we recommend keeping the design of the printed tape simple. A clean print image without too many details and fine text works best.

DIE-CUTTING

Customizing the tape for different applications sometimes requires die-cutting. You can tailor it to a specific size and shape for various purposes such as sealing packages, marking areas, or other industrial applications.

The color of the print must be adapted to the base color of the tape

PRINTING METHODS FOR PP/PVC

There are two ways to print on tape: surface printing and reverse printing. As it sounds, this means printing on the top or bottom of the tape.

Printing on PP Tape
- Only reverse printing
- Creates the effect of a varnished print
- Suitable for larger volumes

Printing on PVC Tape
- Only surface printing
- Provides a very nice print; PVC reproduces colors very well
- Suitable for smaller volumes

BEST RESULTS

For the best results, the file should be a vectorized ai, tif, eps, or pdf file. However, we can also use letterheads, business cards, other tape samples, etc.
You will, of course, receive a proof for approval before printing begins. There, you can see how the print will look and have the opportunity to make changes.

Sealing guide

There are several ways to seal goods, and the choice of sealing method depends on factors such as the working environment, volume, materials, etc. The following guide applies to sealing with packing tape (PP & PVC), staples, and strapping (PP, PET & VG).

	PACKING TAPE - PP & PVC	STAPLES	STRAPPING - PP, PET & VG
	• Fast and easy • Brand building • Manual or machine application	• Works in-depth • Environmentally friendly • Strength and stability STRENGTH + STABILITY	• For individual and palletized goods • Fixation & load securing • Printable
SUBSTRATE / MATERIAL	It is important to understand the substrate. Is the box made of recycled fibers or virgin fibers? A box made of recycled fibers requires stronger adhesive, and we recommend tape with natural rubber adhesive.	Stapling works in-depth, penetrating all layers, resulting in a box with strength and stability.	Quick and flexible sealing of both individual and palletized goods. With a strapping machine or tool, you can adjust the strap tension according to the characteristics of the goods, creating a neat and secure seal.
WORK ENVIRONMENT	Choosing the right tape depends on the working environment where the application occurs. If it's hot, cold, humid, or dusty, this determines which tape is most suitable. For high temperatures, for example, certain tapes work better. Stapling works in-depth, penetrating all layers, resulting in a box with strength and stability.	Stapling is a method that is entirely unaffected by external conditions. It works even if the working environment is humid, dusty, cold, or warm. Additionally, it takes up no storage space.	Strapping can be done in most conditions and is unaffected by external factors. PP packing tape is the best choice.
BRANDING	There are many advantages to custom printed tape – brand building, theft protection, identification, advertising opportunities, technical information, etc. EXCELLENT BANDING	A stapled box does not obscure advertising messages or logos, resulting in a neatly sealed package.	Strapping can also be printed for branding, but it can also serve as a security seal, making it easy to see if the package has been tampered with.
CONSUMPTION	Tape is available for both machine and manual sealing. For large volumes, a tape machine is a good choice. There are options for both top and bottom sealing. For machine sealing, a tape with easy unwinding is required.	You don't need to be a high-volume user for it to be cost-effective to seal with staples. Even at 30-40 boxes a day, it's worth calculating the material costs and the time spent on sealing.	Our range of strapping machines and tools includes everything from manual solutions for smaller volumes to automatic, fully integrated systems. Strapping is suitable for all types of goods, from light to heavy, individual items to palletized goods. FITS ALL TYPES OF GOODS
SUSTAINABILITY	PP (polypropylene) is the most environmentally friendly film. In combination with water-based acrylic and hotmelt adhesives, PP film is the best environmental option, as these adhesives are solvent-free.	An advantage of staples is that they do not need to be removed when the box goes to recycling. Staples are made of iron wire, and during separation at paper mills, the staples can either be incinerated into slag or melted down. Staples that end up in landfills disintegrate within 1-2 years.	PET is preferable from an environmental perspective, as all material is recycled. The material consumption wh… strapping palletized goods is less compare… to, for example, stretch wrapping.

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