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(54) **NON-SLIP HEADER FOR PAPER ROLL, AND METHODS**

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(57) **ABSTRACT**

A paper roll having a non-slip surface on the end(s) of the roll, particularly large paper rolls such as those from a paper making processes. A header, having a non-slip coating on one side and an adhesive coating on the other side is applied to end(s) of the rolled paper. Microencapsulated materials are one suitable class of non-slip materials. The non-slip surface on the header improves stability of the roll, when stood on end, during transport, such as in cargo trucks.

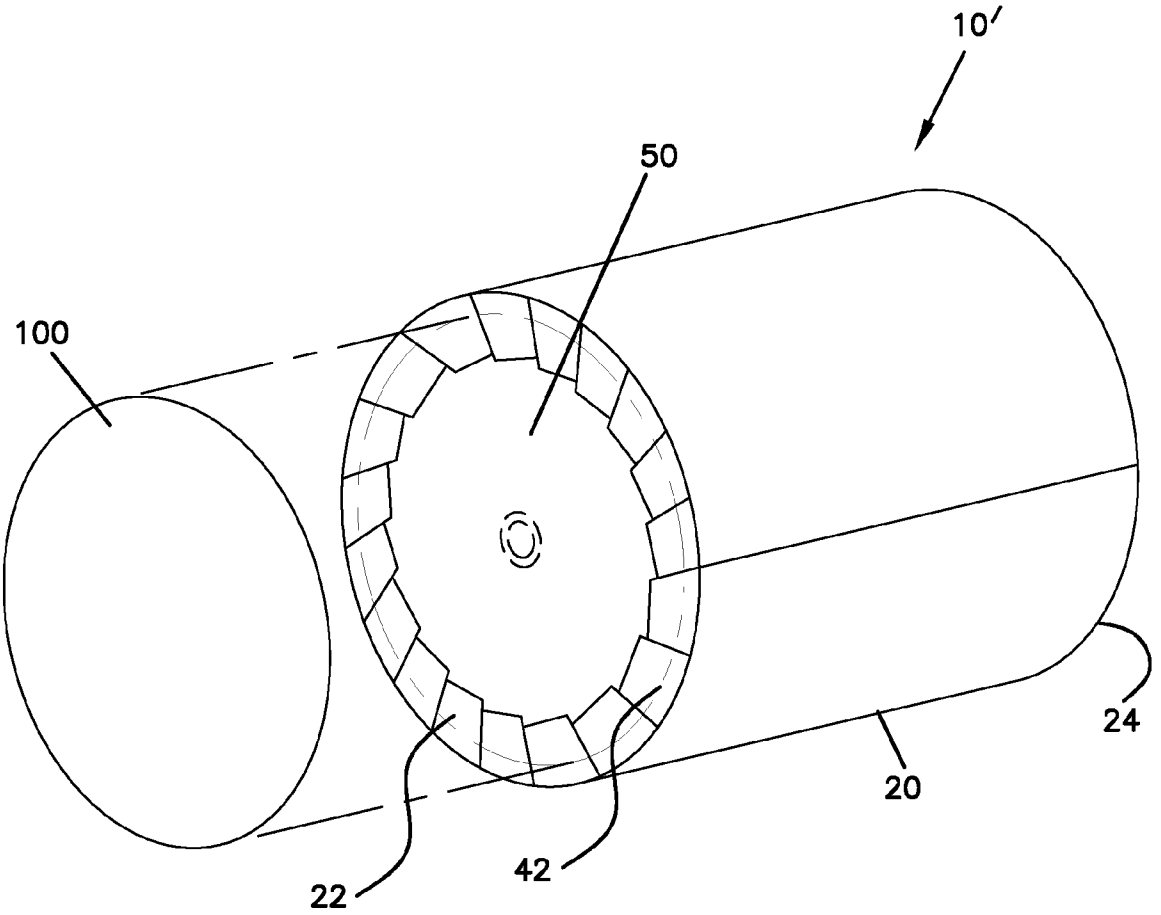


FIG. 1

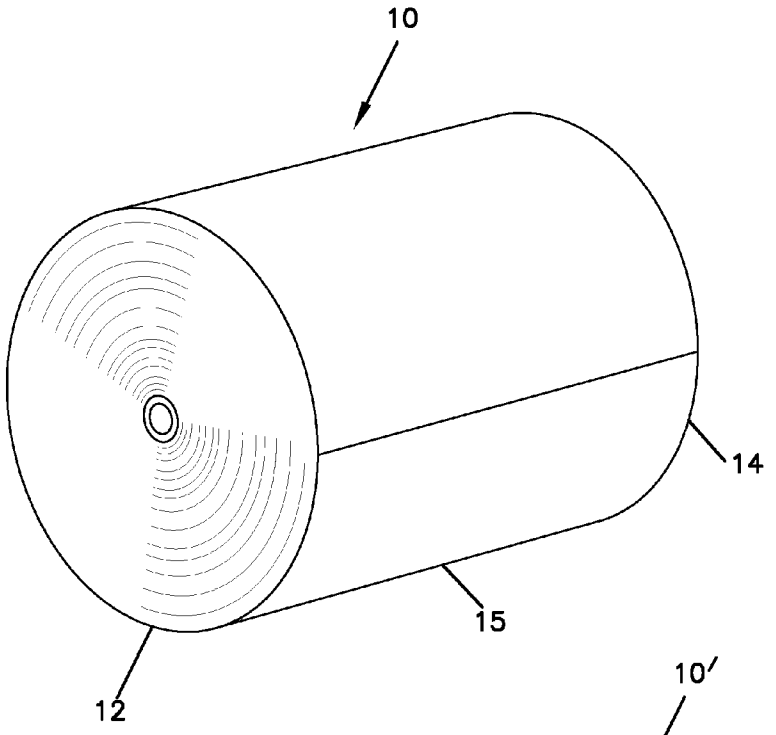


FIG. 2

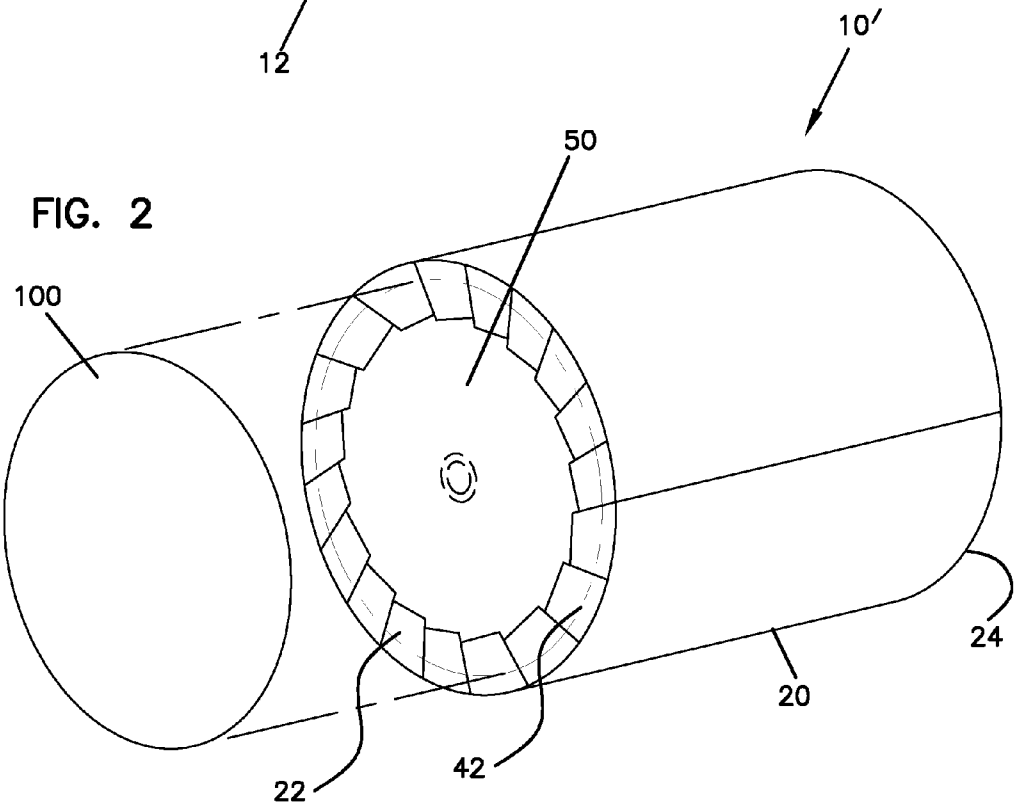
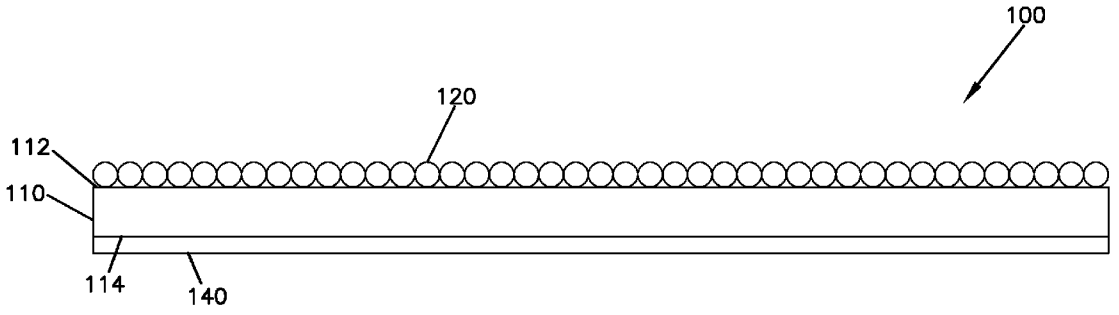


FIG. 3



NON-SLIP HEADER FOR PAPER ROLL, AND METHODS

BACKGROUND

[0001] The present disclosure is directed to paper products, in particular, rolls of paper sheet goods. The disclosure relates to header assemblies for the paper rolls.

[0002] Paper rolls, or other rolls of sheet material, usually have the roll of paper or other sheet material covered with a protective sheet of material (i.e., an outer wrap) wrapped around the circumference of the roll. Any wrap material overhanging the ends of the roll is usually crimped radially inwardly over the ends of the roll. A header assembly is located internally and/or externally of the crimped over projecting wrap portion at each end of the roll. This protection system is often called a "roll wrap" or variation thereof.

[0003] The roll wrap protects a roll of paper throughout the distribution process. Once a roll of paper is formed, it is desirable to wrap the paper roll sufficiently to protect the paper roll until it is used so that the paper is not damaged.

[0004] Paper rolls, whether or not protectively wrapped, are usually stored and shipped in a standing-on-end orientation. Sometimes, depending on the size of the rolls, the rolls may be stacked one on top of the other to reduce the floor space used. The standing orientation of the rolls, whether or not stacked, is unstable due to their size and weight, and is especially precarious during shipment, when the location where the rolls are standing (e.g., a truck bed, a boat hold, rail car, etc.) is moving.

[0005] Improvements in load securement are always desired for transport.

SUMMARY

[0006] The present disclosure provides a header assembly, for use with a paper roll or other rolls of sheet material, which is particularly adapted to decrease the slippage of the rolls during transport and to assist with load securement. Generally, the header assembly provides sufficient friction that, in order to move the roll having the header assembly, a force of at least about 80% of the weight of the roll is needed.

[0007] In one particular embodiment, this disclosure is directed to a header for use in protecting paper rolls. The header includes a base sheet with a non-slip coating on a first side and a coating, such as an adhesive coating, on the second side. The non-slip coating can be formed from encapsulated material. In some embodiments, the non-slip coating is activated, e.g., by the application of heat and/or pressure, prior to attaching the header to the paper roll or during the process of attaching the header to the roll. The coating may be solvent based or may be a hot-melt material, and may be activated prior to attaching the header to the paper roll or during the process of attaching the header to the roll.

[0008] In another particular embodiment, this disclosure is directed to a paper roll having an outer header present on an end, the outer side of the header having a non-slip coating thereon. The outer header is adhered to the paper roll by way of an adhesive coating present on the header on the opposite side of the non-slip coating. The opposite end of the paper can have a similar non-slip header thereon. Present between the outer header and the paper roll may be an inner header.

[0009] In yet another particular embodiment, this disclosure is directed to methods of protecting a paper roll by wrapping the roll with an outer wrap and applying a header. The method includes providing a paper roll, such as from a paper manufacturing process. The roll is wrapped with an outer wrap, with a portion of the wrap extending over an end of the roll. The wrap extension is crimped against the end of the roll. A non-slip out header, having a non-slip coating opposite a coating on a base sheet, is attached to the end of the roll so that the coating adheres to the crimped wrap extension.

[0010] If the header assembly includes an inner header, the inner header is applied to the end of the roll prior to crimping the wrap end.

[0011] These and other embodiments are described in the present disclosure.

BRIEF DESCRIPTION OF THE DRAWING

[0012] FIG. **1** is a perspective view of a paper roll;

[0013] FIG. **2** is a partially exploded, perspective view of a paper roll having an outer protective wrap, an inner header, and an outer header according to the present invention; and

[0014] FIG. **3** is an enlarged side view of the outer header according to the present invention.

DETAILED DESCRIPTION

[0015] The present disclosure is directed to providing a non-slip surface on the end(s) of a paper roll, particularly large paper rolls, such as those from a paper making processes. The size of these rolls is often 30-60 inches in diameter, 30-100 inches in height, weighing from less than a ton to as much as 5 tons, although smaller and larger rolls are also common. Often used terms for these rolls include trim, master and roll stock.

[0016] Referring to FIG. **1**, a standard, unprotected trimmed roll of paper is illustrated at reference numeral **10**. Paper roll **10** has a first end **12**, an opposite second end **14**, and an outer surface **15** that extends between ends **12** and **14**. Paper may be wound on a core or be wound in a coreless manner to form roll **10**. The paper of paper roll **10** may be any conventional or otherwise known paper, and of any basis weight that can be wound into a roll, such as kraft paper, newspaper, or other. The paper may be bleached or unbleached, or colored. The paper may be in any stage of processing, for example, ready for printing, ready for slitting, already slit to the desired size, or ready for any other converting process. Methods for forming paper roll **10** are well known.

[0017] Rolls **10** are often moved from one location to another for storage. To protect rolls **10** during handling and storage, various protective elements are added to roll **10**.

[0018] FIG. **2** illustrates wrapped paper roll **10'**, which is roll **10** having various protective elements present. In particular, wrapped roll **10'** includes an outer protective wrap **20** that extends around the circumference of paper roll **10**. Outer protective wrap **20** preferably extends axially over ends **12**, **14** of roll **10** to form covered end **22** and covered end **24**, respectively. The portion of wrap **20** that extends over ends **12** to form covered end **22** is crimped or folded to form portions **42**. Covered end **24** has a similar overlap of wrap **20**, but is not seen in FIG. **2**. Outer protective wrap **20** and methods of applying to roll **10** to form crimped portions **42** over covered ends **22**, **24** are well known.

[0019] It is also well known to apply a header assembly to one or both ends **22**, **24** of wrapped roll **10'**, to protect the edge of the rolled paper. The header assembly often includes an inner header, positioned between the rolled paper and crimp portions **42**, and an outer header, positioned over crimp portions **42**. In some assemblies, only one header is present. FIG. **2** illustrates an inner header **50** at end **22** present between the rolled paper and crimp portion **42**. A comparable inner header can be present at end **24**.

[0020] The present disclosure provides a non-slip header assembly, particularly, a non-slip outer header. The non-slip outer header of the invention increases the coefficient of friction on the end of roll **10**, which in turn, improves stability of the roll, when stood on the header end. For example, during transport, such as in a cargo truck, a paper roll having the inventive outer header has less tendency to slide on the truck floor, as compared to a roll with a conventional header placed on the truck floor. One attempt to decrease the sliding of paper rolls having conventional headers has been to place a liner or friction mat material on the truck floor to increase the coefficient of friction. The liner, however, is large, bulky, and often difficult to handle. The liner also has a tendency to bunch up, wrinkle, tear, or otherwise become damaged by the fork trucks that load the paper rolls and by the paper rolls slipping while on the liner. Additionally, some liners create a trip hazard for persons walking on the liner. The non-slip header assembly of this invention provides improvements over known products and methods.

[0021] As provided above, the non-slip header assembly of this invention increases the coefficient of friction on the end of roll **10** by provided a non-slip surface on the end of roll **10**. FIG. **2** illustrates wrapped roll **10'** having the non-slip header assembly of the present invention.

[0022] The present invention includes outer header **100**, having a non-slip surface. In FIG. **2**, outer header **100** is illustrated removed from end **22**, to facilitate understanding of the placement of outer header **100** on wrapped roll **10'**. Header **100** is typically circular, to match the shape of end **22** of the paper roll. The outer perimeter of header **100** may extend short of the outer perimeter of end **22** and wrap **20**, thus leaving exposed a portion of crimped portions **42**, or, outer header **100** may cover the entire end **22** and crimped portions **42**.

[0023] The details of outer header **100** are illustrated in the enlarged view of header **100** in FIG. **3**. Header **100** includes a base sheet **110** having a first surface **112** and an opposite second surface **114**. A non-slip coating **120** is present on first surface **112**. When installed on roll **10**, header **100** is positioned so that first surface **112** and non-slip coating **120** are exposed; that is, first surface **112** and non-slip coating **120** are on the exterior of roll **10**.

[0024] Base sheet **110** can be any suitable material but is usually a paper product, such as kraft paper or paperboard. Polymer based materials, which may be a laminate of paper and polymer, or all polymer, are also suitable materials for base sheet **110**. Base sheet **110** may be flat or may be a corrugated sheet. Although one example of a suitable base sheet **110** is 42 pound unbleached kraft paper (i.e., a 1000 square foot ream weighs 42 pounds), base sheets of 10-100 pounds per 1000 square foot ream could be used. In some embodiments, base sheet **110** has a basis weight of 15-70 pounds per 1000 square foot ream. A 69 pound kraft paper is another example of a suitable base sheet **110**.

[0025] Non-slip coating **120** can be any coating of material that provides a static coefficient of friction of at least 0.5 and preferably at least about 1.0. In some embodiments, the static coefficient of friction is at least 2.0, and even at least 3.0. As a comparative, untreated or uncoated kraft paper, which is typically used as an outer header, has a static coefficient of friction in the range of 0.3-0.5, but is usually about 0.4. Static coefficient of friction can be measured, for example, using TAPPI test method 816 entitled "Coefficient of Static Friction of Corrugated and Solid Fiber Board (Horizontal Plane Method)".

[0026] Generally, the static coefficient of friction provides sufficient friction that, to move roll **10'** having header **100** with non-slip coating **120**, a force of at least about 80% of the weight of roll **10'** is needed. For example, at least 800 lbs force is needed to move (e.g., slide) a 1000 lb roll of paper; in many embodiments, at least 85%, i.e., 850 lbs force, is desired. It is understood that larger and smaller rolls would require greater and lesser amounts of force, but that the percentage would be the same.

[0027] Although various materials can be used to increase the static coefficient of friction, encapsulated materials (which includes microencapsulated materials) is one class of suitable, and preferred, materials. As a simple description, encapsulated materials have a shell or capsule surrounding a frictional material, such as a polymeric material.

[0028] To form header **100**, encapsulated adhesive material is applied to base sheet **110**, i.e., to first surface **112**, and then activated, e.g., burst, by the application of heat and/or pressure.

[0029] Encapsulated materials and methods for making them are well known. For example, U.S. Pat. Nos. 2,730,456, 2,800,457, and 2,800,458 describe methods of capsule formation. Other useful methods for microcapsule manufacture are described in U.S. Pat. Nos. 4,001,140, 4,081,376 and 4,089,802, which describe a reaction between urea and formaldehyde; U.S. Pat. No. 4,100,103 describes a reaction between melamine and formaldehyde; British Patent No. 2,062,570 describes a process for producing microcapsules having walls produced by polymerization of melamine and formaldehyde in the presence of a styrenesulfonic acid. Microcapsules are also taught in U.S. Pat. Nos. 2,730,457 and 4,197,346. Microcapsules from urea-formaldehyde resin and/or melamine formaldehyde resin are disclosed in U.S. Pat. Nos. 4,001,140, 4,081,376, 4,089,802, 4,100,103, 4,105,823, and 4,444,699, and alkyl acrylate-acrylic acid copolymer capsules are taught in U.S. Pat. No. 4,552,811. U.S. Pat. No. 4,622,267 discloses an interfacial polymerization technique, and a similar technique is disclosed in U.S. Pat. No. 4,547,429. Numerous other methods of encapsulation are described in U.S. Pat. No. 4,552,811, U.S. Pat. Nos. 4,001,140, 4,087,376, and 4,089,802, U.S. Pat. No. 4,100,103, U.S. Pat. No. 4,221,710, and in U.S. Pat. Nos. 4,251,386 and 4,356,109. Encapsulation using gelatin is also well known; see for example, U.S. Pat. Nos. 2,800,457 and 2,800,458 and U.S. Pat. No. 2,730,456. Each patent named is incorporated herein by reference to the extent each provides guidance regarding encapsulation processes and materials.

[0030] Other classes of suitable materials for non-slip coating **120** include those generally described low-tack adhesives or pressure-sensitive adhesives, which could be encapsulated.

[0031] The encapsulated material may be water based or solvent based. In some embodiments, the encapsulated material may be a 100% solids material.

[0032] One particular example of an encapsulated material is commercially available from Press Color, Inc. of Appleton, Wis. under the designation "Stop Slip", which is generally described as a thermo expandable waterborne ink.

[0033] Non-slip coating **120** may include filler materials or other additives. For example, silica, talc, calcium carbonate or other particulate material could be added to non-slip coating **120** to increase the static coefficient of friction.

[0034] The materials that form non-slip coating **120** can be applied to first surface **112** by conventional coating processes, such as by flood coating, saturation coating (e.g., with a metering rod), knife coating, gravure coating, reverse angle gravure coating, printing, and the like, and then appropriately dried or cured. A size coat or other undercoating may be present on first surface **112** prior to applying non-slip coating **120**. Coating speeds for non-slip coating 120 of 100 ft/min to even 1000 ft/min can be obtained. Coating **120** may be a solid coating across header **100** or may be a pattern coating. Whether a solid or pattern coating, it is preferred that the density or weight of the material is generally consistent across base sheet **110**.

[0035] The amount of material applied to first surface **112** is an amount sufficient to provide a non-slip coating **120** having a weight of about least 1 pounds per 1000 square foot ream, often at least about 2 pounds per 1000 square foot ream, but generally no more than about 15 pounds per 1000 square foot ream. Although sample ranges of coating weights for non-slip coating **120** are provided, it is understood that any weight of coating **120** suitable to obtain the desired coefficient of friction would be suitable. One exemplary weight range is about 3-6.5 pounds per 1000 square foot ream, and one exemplary weight is about 5 pounds per 1000 square foot ream.

[0036] The activation of the non-slip properties of the coating materials, e.g., the encapsulated material, to form the increased friction surface, can be done before or after applying header **100** to wrapped roll **10'**. Encapsulated materials are preferred for the reason that they are inactive (e.g., non-adherent) until activated, whereas pressure sensitive adhesives and low-tack adhesives are typically adherent upon drying of the material. Many encapsulated materials can be activated by the application of heat and/or pressure.

[0037] Returning to the drawing of header **100** in FIG. **3**, on second surface **114**, header **100** can include an attachment mechanism, such as coating **140**, which can be an adhesive coating. Coating **140** provides an attachment mechanism to hold header **100** onto second end **12** of roll **10**. Typically, coating **140** attaches to end **22** on top of crimped portions **42**. Coating **140** may also attach header **100** to any inner header **50** that is positioned between crimped portions **42** of protective wrap **20** and the paper roll. For rolls lacking inner header **50**, coating **140** may attach header **100** to crimped portions **42** and to the edge of the rolled paper.

[0038] In some designs, coating **140** provides additional features to header **100** in addition to providing an adhesive surface. For example, coating **140** may increase the physical stability of header **100**, by providing a moisture-barrier that inhibits seepage of moisture into base sheet **110**. Additionally or alternatively, coating **140** may inhibit moisture passage into the paper roll via the roll edge.

[0039] Coating **140** can be any coating of material that provides sufficient adhesive properties to hold header **100** onto wrapped roll **10'**. Numerous adhesives are suitable for the application. The adhesive material may be water based or solvent based, or may be a 100% solids material, often referred to as a hot-melt. U.S. Pat. No. 6,505,459 describes the use of a hot melt adhesive for applying an outside header. The material may be a thermoplastic, a thermoset, or a blend thereof. Exemplary thermoplastics that can be used to provide a heat seal include polylactide, polyethylene, polypropylene, and polyvinyl. Exemplary patents describing the use of thermoplastics for heat sealing include U.S. Pat. No. 5,090,566 and U.S. Pat. No. 4,820,374. The material may be radiation (e.g., UV) curable, moisture-curable, condensation-reaction curable, or merely cured or dried by the removal of solvent. The adhesive may be high-tack, low-tack, pressure-sensitive, a self-seal (i.e., it only readily sticks to itself) or any other level of adhesive that is sufficient to hold header **100** onto crimped portions **42** and wrapped roll **10'**. Examples of broad classes of suitable adhesives include rubber-based adhesives, acrylate-based adhesives, and silicone-based adhesives. One example of a suitable adhesive for coating **140** is polyethylene, especially low density polyethylene (LDPE). Another example of a suitable adhesive for coating **140** is a self seal adhesive, such as one of those available under the name "Resyn Self Seal" from National Starch, "Nip-Weld" and "Turbo Seal" from Bostic, and "Robond" from Rohm & Haas. If coating **140** is a self seal adhesive, it is preferred that inner header **50** also includes that adhesive, to facilitate adherence of header **100**.

[0040] The adhesive for coating **140** can be applied to second surface **114** by conventional coating processes, such as by flood coating, saturation coating (e.g., with a metering rod), knife coating, gravure coating, reverse angle gravure coating, printing, and the like, and then appropriately dried or cured. Coating **140** may be a solid coating across header **100** or may be a pattern coating. Coating **140** may be present across the entire area of second surface **114** or be limited. For example, coating **140** could be present as an annular coating configured to engage with crimped portions **42**, leaving the center of second surface **114** uncoated, to not adhere, for example, to the edge of the paper when no inner header **50** is present.

[0041] The amount of adhesive applied to second surface **114** should be an amount sufficient to adhere header **100** to crimped portions **42** and any other surfaces.

[0042] Header **100** can be applied to roll **10** by generally any method for applying conventional header elements. Examples of available equipment or lines that can be used to wrap roll **10** to provide wrapped roll **10'** are available from companies such as Lamb, Valmet, and Symatec. Care should be taken, however, to assure that when applying header **100** to roll **10**, header **100** is positioned so that non-slip coating **120** is on the exterior and coating **140** is against the paper roll. A liner or slip sheet may be positioned between stacked headers **100** to inhibit coating **140** from sticking to the adjacent non-slip coating **120**.

[0043] One exemplary method for producing header **100** is described below.

[0044] A web of material, i.e., material that forms base sheet **110**, is provided to a coater or coating line. Typical widths for the base sheet web are 15 to 80 inches, although webs as wide as 140 inches could be used. A preferred web is unbleached 42 pound kraft paper.

[0045] Encapsulated adhesive material, to form non-slip coating **120**, is applied to first surface **112** of the web. An aqueous mixture of about 45% solids encapsulated material, available from Press Color, Inc. of Appleton, Wis. under the designation "Stop Slip", is applied to first surface **112** by a saturation coating technique using a smooth applicator roll and metering rod positioned below the web surface being coated. The aqueous mixture is transferred from the applicator roll to the surface **112** at a thickness that, when dried, provides a weight of about 15 pounds per ream.

[0046] The aqueous mixture is dried by passing the coated web over two sequential heated can rollers and under one heated can roller, to provide a web temperature of about 190° F. At this temperature, the mixture is dried and the encapsulated material is activated, by bursting of the capsules. In preferred embodiments, the burst material does not stick to various process equipment (e.g., platen) during the process of putting the header onto the roll, which is described below.

[0047] Coating **140** may be previously applied, i.e., present on second side **114** of the web, prior to feeding the web into the coater applying non-slip coating **120**. In another embodiment, coating **140** may be applied to the web simultaneously, i.e., on the same coating line, as non-slip coating **120**. In yet another embodiment, coating **140** may be subsequently applied on a separate coating line.

[0048] After non-slip coating **120** and coating **140** are present on the web, the web is die cut to circles of the desired size.

[0049] One exemplary method for producing wrapped roll **10'** is described below.

[0050] Roll **10** is provided by conventional paper making processes. Roll **10** is wrapped with outer wrap **20** by conventional roll wrapping processes. Various equipment designs are available for wrapping paper rolls. Examples of available wrapping systems or lines that can be used to wrap roll **10** to provide wrapped roll **10'** are available from companies such as Lamb, Valmet, and Symatec. Also, see U.S. Pat. No. 6,505,459 to Ruohio et al., U.S. Pat. No. 5,642,600 to Hooper et al., U.S. Pat. No. 4,303,462 to Karr, and U.S. Pat. No. 5,960,608 to Ohtonen for various wrapping systems.

[0051] After wrapping, a portion of outer wrap **20** extends over ends **12**, **14** of roll **10**. This extension of wrap **20** is folded or crimped to provide crimped portions **42**.

[0052] In some processes, an inner header **50** is applied to end **22** and the opposite end of the roll prior to crimping wrap **20** to form crimped portions **42**.

[0053] Header **100**, and optionally inner header **50**, can be applied by conventional wrapping equipment, such as by units that use vacuum to apply header **100**. Usually, a heated platen is used to at least partially activate coating **140** and hold header **100** onto the roll end. Care should be taken, however, to assure that when applying header **100** to roll **10**, header **100** is positioned so that non-slip coating **120** is on the exterior and coating **140** is against the paper roll.

[0054] For some embodiments, the heated platen used to apply header to the roll also bursts the encapsulated material, thus activating the non-slip material.

[0055] After application of header **100**, wrapped roll **10'** is stood on end, so that non-slip coating **120** contacts the ground or other surface on which wrapped roll **10'** is positioned.

[0056] The above specification, examples and data provide a complete description of the manufacture and use of the composition of the invention. Since many embodiments of the invention can be made without departing from the spirit and scope of the invention, the invention resides in the claims hereinafter appended.

What is claimed:

1. A wrapped roll or paper or other sheet material comprising:

(a) a roll of paper or other sheet material having a first end and an opposite second end;

(b) an outer wrap of material wrapped circumferentially around the roll and crimped over the first end to form crimped portions;

(c) an outer header adhered to the crimped portions, the outer header comprising a base sheet, an adhesive coating on a first side of the base sheet against the crimped portions, and a non-slip coating on a second side of the base sheet.

2. The wrapped roll of claim **1** further comprising a second outer header adhered to crimped portions on the second end of the roll, the outer header comprising a base sheet, an adhesive coating on a first side of the base sheet against the crimped portions, and a non-slip coating on a second side of the base sheet.

3. The wrapped roll of claim **1**, wherein the non-slip coating has a static coefficient of friction such that, to move the roll, a force of at least about 80% of the weight of the roll is needed.

4. The wrapped roll of claim **3**, wherein the non-slip coating has a static coefficient of friction of at least 0.5.

5. The wrapped roll of claim **3**, wherein the non-slip coating has a static coefficient of friction of at least 2.0.

6. The wrapped roll of claim **3**, wherein the non-slip coating comprises encapsulated adhesive material.

7. The wrapped roll of claim **3**, wherein the base sheet comprises kraft paper.

8. The wrapped roll of claim **7**, wherein the non-slip coating comprises encapsulated adhesive material at a weight of about 1 to about 6.5 pounds per 1000 square foot ream.

9. The wrapped roll of claim **8**, wherein the non-slip coating comprises encapsulated adhesive material at a weight of about 5 pounds per 1000 square foot ream.

10. The wrapped roll of claim **3**, wherein the adhesive is hot melt, water based or solvent based.

11. A method of wrapping a roll of paper or other sheet material, the method comprising:

(a) circumferentially wrapping a wrap material around a roll of paper or other sheet material, with a portion of the wrap material extending axially past ends of the roll;

(b) folding the extending wrap material radially against the ends of the roll to form crimped portions; and

(c) adhering an outer header to the crimped portions, the outer header comprising a base sheet, an adhesive coating on a first side of the base sheet against the crimped portions, and a non-slip coating on a second side of the base sheet.

12. The method of claim **11**, further comprising, prior to folding the extending wrap material radially against the ends of the roll:

(a) applying an inner header to the ends of the roll.

13. The method of claim **11**, wherein adhering an outer header to the crimped portions comprises:

(a) adhering an outer header to the crimped portions having a non-slip coating with a static coefficient of friction such that, to move the roll, a force of at least about 80% of the weight of the roll is needed.

14. The method of claim **13**, wherein the non-slip coating has a static coefficient of friction of at least 0.5.

15. The method of claim **13**, wherein the non-slip coating has a static coefficient of friction of at least 2.0.

16. The method of claim **13**, wherein the non-slip coating comprises encapsulated adhesive material at a weight of about 1 to about 6.5 pounds per 1000 square foot ream.

17. The method of claim **13**, wherein the non-slip coating comprises encapsulated adhesive material at a weight of about 5 pounds per 1000 square foot ream.

18. A header for protecting rolls of paper and other sheet goods, the header comprising:

(a) a base sheet having a first surface and an opposite second surface;

(b) an adhesive coating on the first surface; and

(c) an encapsulated non-slip coating on the second surface.

19. The header of claim **18** being circular and having a diameter of at least 30 inches.

20. The header of claim **18**, wherein the base sheet is kraft paper.

21. The header of claim **20**, wherein the kraft paper has a weight of 10-100 pounds per 1000 square foot ream.

22. The header of claim **18**, wherein the non-slip coating has a weight of about 1 to about 6.5 pounds per 1000 square foot ream.

23. The header of claim **18**, wherein the non-slip coating has a weight of about 5 pounds per 1000 square foot ream.

24. The header of claim **18**, wherein the adhesive is a hot melt, water based or solvent based.

* * * * *