

DSS-R.05.03 | Residue / Film / Adhesion

Neoprene Roller Transfer

Residue/transfer - conveyor/guide rollers, staging cradles; dotty/patchy nodes at roller pitch, smudged linear bands; typically SC-0, localized SC-1 where abrasive dust was present

Diagnosis summary

Neoprene roller transfer is an appearance change on glass caused by contact with neoprene-coated rollers or cradle pads during factory conveying, glass washing, staging, or transport. It presents as dotty or patchy contact nodes repeating at roller pitch, sometimes superimposed on smudged linear bands at consistent elevations. Deposits may include neoprene wear fines, plasticizers, and entrained shop dust.

Field identification cues

- Surface-catch class (MSRT)
- Typically SC-0 (soft transfer on surface).
- SC-1 may present where dust-laden contact or micro-vibration created very shallow micro-texture within the transfer lane; SC-2 suggests misclassification-reassess for M.01 conveyor/belt line scoring.
- Perform one light, non-marring pass on a small revealed test patch (substrate), not across gummy nodes. Use a polymer stylus if a functional coating is suspected. MSRT supports classification only.

Classification, severity and scope

- Assign CAT by visibility at acceptance geometry and MSRT after a controlled reveal. Depth values are indicative-field measurement not required.
- CAT-1 (Benign / non-relief): Faint node lane or light band; SC-0; mainly angle/raking visible. Indicative relief: 0-10 µm (optical film).
- CAT-2 (Light): Persistent node lane with localized SC-1 (dust-assisted micro-texture); limited standard-view impact. Indicative relief: ~10-40 µm.
- CAT-3 (Moderate): High-contrast, wide lane/band legible at standard distance; scattered SC-1 in nodes; multiple lanes or wide coverage. Indicative relief: ~40-120 µm.
- Reclassify when: After true residue lift, linear incisions with chip-flank sparkle or SC-2 persist → evaluate under M.01.04 Conveyor/belt line scoring or M.01 (linear scoring).

Distinguishing criteria

- vs. Roller / handling rail transfer (R.03.03): R.03.03 shows broad level bands without distinct node pitch; neoprene roller shows distinct repeating nodes at constant spacing.
- vs. Suction cup rings (R.03.01): Cup prints are large circles/ovals with lip+puck; neoprene nodes are small, evenly spaced ticks along a lane.
- vs. Paint overspray (R.02.01): Overspray is random speckle lacking constant pitch; neoprene nodes are periodic and align in tracks.

Documentation and inspection

- Photo set (VIS): 12 / 36 / 72 in, normal + oblique; raking macros of node pitch, lane edges, band texture; context frames showing consistent elevation across panes and any.
- MSRT result (substrate): After a small reveal test patch, perform one light, non-marring pass; record SC-class (SC-0/SC-1/SC-2).
- Forms: Pane ID; product family & surface numbering; worked surface Y/N; functional coating present on worked surface?

Safety / repairability boundary: Complete only the non-invasive reveal and inspection steps authorized by the controlling VIS guidance. Classification does not authorize restoration, establish acceptance, or override stop-work, coating, crack, integrity, access, chemical, fall-protection, or project-specific requirements.

Full DSS publication: use the catalog download. Web specification:

<https://a7df714357.nxcli.io/learning-center/resource-center/damage-specification-standards/dss-r-05-03-neoprene-roller-transfer/>