

Production of Third Bureau Rotary Press Coil Waste 1918-1922

Purpose of Exhibit: Is to show the production methods and varieties of the rotary press which created the coil waste issues made from the unwatermarked horizontal coils.

Organization: The exhibit is organized by the different steps used to produce the coil waste issues. The different plates and their layout, paper varieties, printing and perforation varieties, and special production varieties.

Importance: The Bureau during this time period experimented with plate layout, printing methods, paper, and construction methods. The Stickney Rotary Press was developed and put into use in 1914. It increased coil production from 1 million per day to 6 million per day, a significant increase. The new production method required a continuous roll of paper to produce coils of 500 and 1,000. The new printing method created another problem for the Bureau. During the production process, an excess amount of stamps came at the end of the roll that didn't have enough to make a coil of 500. Instead of discarding the excess material the Bureau decided to make use of the material and turn them into sheet stamps. This was a cost effective adventure due to the recent war in an effort to save money. This was only done with horizontal coil material. The excess material was perforated vertically and separated into panes of 170. The panes of 170 were awkward to store and eventually the Bureau separated the panes into 100 and 70 subject panes easier to handle and store. The Bureau created four more coil waste issues with the 4th Bureau. These were the last coil waste issues produced by the Bureau. This experiment created a number of interesting varieties and issues to collect

Challenge Factor: The basic stamp material is easy to collect. A great deal was saved by dealers and collectors. The production varieties are quite interesting and more of a challenge. Due to the large size of the panes of 170, few have survived intact. The plate imprint varieties include a few challenges, a plate block with S30 printed in reverse is not too common, and a S30 printed lower than the imprint is very scarce. There are a number of perforation varieties, some more common, and a few others more difficult. The most difficult variety is the 2c Scott 540B imperforate vertically. There are 25 known pairs. The more common rarity is the imperforate horizontally varieties. There were 50 panes of 170 made for the 1c and 2c denominations. Used examples with genuine contemporary cancels are very scarce. Fold overs and misperforations are very scarce. There are a few positional blocks made from the separation of the panes of 170. Blocks with the star imprint and joint line are difficult. Blocks with a straight edge before or after the plate number show how the Bureau separated the panes of 170 into smaller panes of 100 and 70.

New Additions & Changes: This is the fourth time showing this exhibit. The title page has been redone to highlight the differences between the coil waste issues presented in the exhibit. The most notable item is a complete pane of 170 from the 2c Scott 540a, imperforate horizontally. It is a popular perforation error where the sheet was produced with the stamps imperforate horizontally between the designs. There were 4 plates used to produce this order, two of the 1c denomination and two of the 2c denomination. There were 50 panes of each plate number produced. The example in the exhibit may be the only intact pane of the 2c variety. It has survived over 100 years while most of the coil waste panes of 170 produced have been broken up into smaller pieces. Originally, the order was supposed to be panes of 170 with just the top and bottom margins imperforate. Another key piece is a plate block of the last coil waste issue, the 1c Scott 545. The plate block is an example of the very first plate used to produce the scarce variety perforated 11 x 11.

Exhibit Highlights: The exhibit is very comprehensive and contains many of the rare production varieties of the rotary press coil waste material. The only production variety missing is the S 20 plate number block of the rare Type II Scott 539. Complete panes of 170 are very scarce since most all of them have been broken up over the past 100 years. The exhibit has a complete used pane of the 1c Scott 538, most likely a postage due payment. The exhibit also has a complete pane of the 2c Scott 540a, an important perforation variety. There were 50 panes for two plate numbers. It is most likely the only surviving intact pane. The exhibit has all the other known imprint varieties including the reverse S30 block and the lower S30 marking in a block. A lower block of six with double paper, or paper weld, from when the paper was in pulp form during production.

- 1) Complete used pane of the 1c Scott 538.
- 2) A block of six with double paper, or paper weld.
- 3) A 2c Scott 540 plate block with the S 30 being lower than the imprint.
- 4) A 2c Scott 540 plate block with the S 30 reversed.
- 5) A 2c pair Scott 540b imperforate vertically, 1 of 25 known pairs.
- 6) Three different fold overs with misperforations.
- 7) A complete set of plate blocks for the imperforate top and bottom varieties, four plates for each denomination.
- 8) A double weight cover with a bottom pair of the 2c imperforate margin at the bottom.
- 9) A used block of the 2c Scott 540a, imperforate horizontally, with a contemporary cancel.
- 10) A complete pane of 170 of the 2c Scott 540a, imperf horizontally between designs.
- 11) A plate block from the very first plate used to produce the scarce 1c Scott 545.
- 12) The EDU for Scott 545, the last Third Bureau Rotary Press coil waste produced by the Bureau. One of 11 documented covers.

Production of Rotary Press Coil Waste Third Bureau Issues 1919-1922

Purpose of Exhibit: Is to show production examples of the Third Bureau coil waste issues including plate layout, marginal markings/imprints, and perforation varieties.

Key Items are Matted in Red

Exhibit Plan

- I. Production of Coil Waste
 - A. Plate Layout
 - B. Imprints & Marginal Markings
 - C. Perforation Varieties
 - D. Epilogue

Rotary Press Coil Waste Plates

- A total of 89 different plates are documented as being used for the first 1 cent coil waste.
- A total of 272 different plates are documented as being used for the first 2 cent coil waste.
- There are only 20 different plates documented as being used for the 3 cent coil waste.
- The 3 cent issue was short lived due the war ending soon after it was issued.

The Bureau only produced coil waste issues in three denominations, three design types, and two perforation varieties. They only used left over coil stock from horizontal rotary press coils.

Coil Waste Issues Were Produced From These Rotary Press Coils

Perforated 11x10

Perforated 11x11



The Type II variety is one of the scarcer rotary press coils printed from the S 20 plates. The coil waste variety is also the scarcest of the coil waste issues.

Type II



Type III



The Type I Three cent coil waste issue had a very short use for the war rate. They had the fewest plates used to print this issue.

Type I