

SMPTE RECOMMENDED PRACTICE

Dimensions for 70-mm, 65-mm and 35-mm Motion-Picture Film Splices

RP 111-1983



Page 1 of 4 pages

1. Scope

- 1.1 This practice specifies the significant dimensions of splices for 70-mm, 65-mm, and 35-mm motion-picture film intended for projection and exhibition or for laboratory printing.
- 1.2 There are a number of methods for splicing triacetate or polyester motion-picture film that have found practical and commercial acceptance and that meet the operational requirements for the physical strength of the bond. This practice is not intended to recommend one method over another, but rather to emphasize the requirements common to all splices.

2. Applications

- 2.1 Within the motion-picture technology, splices are employed in two different contexts with correspondingly different permissible tolerances:
 - 2.1.1 **Projection Applications.** The film is usually a print and the primary objective is for the splice to be unobtrusive in the projected image and to reproduce sound. Film guiding and positioning are usually achieved through the film seeking an equilibrium position within a system that introduces high tolerance edge guiding for lateral positioning, and perforation reference against a loose-fitting tooth or claw for vertical positioning. The splice used in projection applications will have slightly broader dimensional tolerances than the splice used in laboratory applications.
 - 2.1.2 **Laboratory Applications.** The film may be negative or positive, camera original or intermediate, etc. The primary objective is for the splice to be unobtrusive in the end product achieved through contact or optical printing, special effects, etc. The dimensional tolerances on splices are more readily controlled and the permissible tolerances are tighter than for the projection application in Sec. 2.1.1.
- 3.1 The dimensions shall be as given in the figures and tables and apply to processed films and leaders which contain nominal shrinkage up to 0.2%.
- 3.2 The film width at the splice shall not exceed 1.379 in (35.03 mm) for 35-mm films, 2.561 in (65.05 mm) for 65-mm films, 2.738 in (70.05 mm) for 70-mm films
- 3.3 The angle between the respective edges of the spliced films shall be 180° ± 3°. Thus, the spliced film shall be aligned to the extent that when one portion of the film is placed against a straight edge, the other portion will not deviate more than 0.001 in (0.010 mm) in 5 in (127 mm).
- 3.4 Dimensions of the butt splices shall conform to Dimensions B, E, G, and H, as specified in the tables.
- 3.5 Butt splices shall be made centrally on the frame-line.
- 3.6 The dimensions of the tape applied to secure a butt splice shall not interfere with the film dimensions specified for the particular film type.
- 3.7 The tape shall be wide enough to cover at least half a frame on each side of the splice.
- 3.8 Tape splices shall be made with an optically clear, transparent tape resulting in a splice capable of withstanding tension at least 50% greater than projector gate tension for that film width.
- 3.9 The tape shall adhere uniformly to the film without corrugations or entrapped air bubbles.
- 3.10 The width of the tape used shall encompass the full width of the film on one side, and exclude the perforation area and the area of the magnetic records and balance stripes on the opposite side. Splices with tape on one side only are not functional in projection and are unacceptable. Splices made with tape wrapped around the film interfere with guiding and are unacceptable.
- 3.11 Butt splices shall be made so that the film ends are touching as closely as possible to prevent white light from showing through.

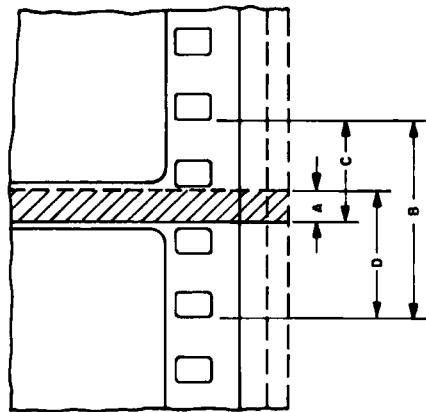


Fig. 1 Splices on 70-mm, 65-mm and 35-mm Films

Table 1 Dimensions of Cement Overlay Splices for 35-mm Motion-Picture Film

Dimensions	Laboratory		Projection Nonamorphobic Prints		Projection Anamorphic Prints*	
	in	mm	in	mm	in	mm
A†	0.019	nom	0.073	nom	1.85	nom
B	0.560 ± 0.002	11.22 ± 0.05	0.561 ± 0.002	11.22 ± 0.05	0.561 ± 0.002	11.22 ± 0.05
C	0.268 ± 0.002	6.81 ± 0.05	0.278 ± 0.001	7.06 ± 0.10	0.268 ± 0.002	6.81 ± 0.05
D	0.311 ± 0.002	8.66 ± 0.05	0.356 ± 0.001	9.01 ± 0.10	0.311 ± 0.002	8.66 ± 0.05

*Notice that the splices on amorphobic films will fall within the projected area, and extra care must be taken in making a clean splice.
 †To minimize projection of splices, the width of the laboratory splice should be no greater than 0.040 in (1.02 mm).

Table 2 Dimensions of Cement Overlay Splices for 70-mm and 65-mm Motion-Picture Films for Laboratory and Projection

Dimensions	Inches		Millimeters	
	in	ref	mm	ref
A	0.067	ref	1.70	ref
B	0.561 ± 0.002	14.25 ± 0.05		
C	0.275 ± 0.002	6.98 ± 0.05		
D	0.353 ± 0.002	8.97 ± 0.05		

Table 3 Dimensions of Weld Overlay Splices on Polyester Motion-Picture Film

Dimensions	AS Perforation		CS Perforation	
	in	mm	in	mm
A	0.020	nom	0.51	nom
B	0.561 ± 0.002	14.25 ± 0.05	0.561 ± 0.002	11.25 ± 0.05
C	0.252 ± 0.002	6.40 ± 0.05	0.254 ± 0.002	6.45 ± 0.05
D	0.329 ± 0.002	8.36 ± 0.05	0.327 ± 0.002	8.31 ± 0.05

Approved 3 February 1983

Copyright © 1983 by the SOCIETY OF MOTION PICTURE AND TELEVISION ENGINEERS 862 Scarsdale Avenue, Scarsdale, NY 10583, (914) 772-6606

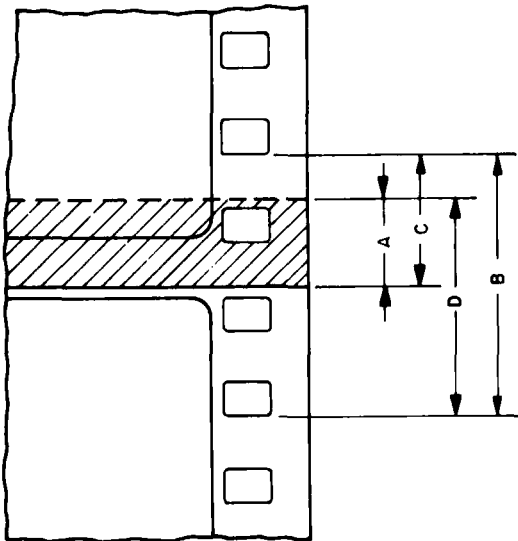


Fig. 2 Full Projection Cement Splices on 35-mm Projection Prints

Table 4 Dimensions of Full Perforation Overlap Splices on 35-mm Motion-Picture Projection Prints

Dimensions	Inches	Millimeters
A	0.136	3.46
B	0.561 ± 0.002	14.25 ± 0.05
C	0.231 ± 0.002	6.12 ± 0.05
D	0.176 ± 0.002	4.48 ± 0.05

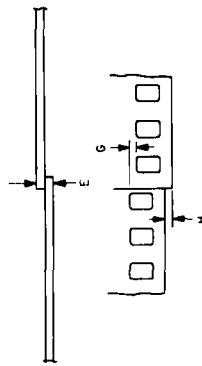


Fig. 3 Dimensions for All Film Widths

Table 5 Dimensions for All Splices

Dimensions	Laboratory		Projection	
	in	mm	in	mm
E (see A4)	0.013 max	0.33 max	0.019 max	0.48 max
G (see A3)	0.002 max	0.05 max	0.002 max	0.05 max
H (see A2)	0.002 max	0.05 max	0.002 max	0.05 max

Appendix

(The Appendix is not a part of this SMPTE Recommended Practice, but is included for information purposes only.)

A1. Maintaining continuity of pitch across the splice requires that the perforation interval within which the splice lies be equal to the perforation intervals in the unspliced portions. This may be difficult to measure, however, inasmuch as the act of forming the bond may slightly distort perforation walls in those perforations nearest the bond (because of solvent, thermal, or mechanical action) and, therefore, introduce uncertainty into the measurement. Consequently, it is not customary to measure the primary dimension, but to measure over two or more perforation intervals.

A2. The lateral alignment that is most significant for the projection and exhibition mode of film use is the avoidance of any large offset of the film edges before and after the splice. Dimension H. Therefore, for projection applications, this is the most convenient control parameter.

A3. The lateral alignment that is most significant for the printing mode of film use is the maintenance of perforation alignment across the splice. Therefore, for laboratory applications, the most convenient control parameter is Dimension G.

A4. The splice joint for triacetate film may be made as an overlap splice using either film cement, thermal fusion, or transparent pressure-sensitive (adhesive) tape applied to both sides. In some cases, the tape is applied for reinforcement during projection to either one or both sides of a cement splice. A butt splice may also be made using thermal fusion or tape. The splice joint for polyester films is usually made as an overlap splice that is physically molecularly welded together by an ultrasonic splicer. Either an overlap splice or a butt splice may be made by applying transparent pressure-sensitive (adhesive) tape to both sides of the polyester film.

There are several methods of forming the film overlap or joint for splices used by laboratories and film exchanges. The most common methods are usually referred to as negative splices, positive splices, full-hole positive splices, and butt splices. In addition, transparent pressure-sensitive (adhesive) tape splices are currently employed on 35-mm films for theatrical projection applications utilizing automated equipment with large reels or horizontal platters. CinemaScope splices can be made with an overlap of as little as 0.030 in (0.76 mm).

If moisture is used to remove the emulsion on triacetate film, the film ends must be dry before applying cement and making the splice.

A5. For the reinforcement of a splice on magnetic striped film, the tape should be applied to the emulsion side of the film to avoid making the magnetic sound tracks. If the splice consists of a tape material only, however, it should be applied to both sides of the film to prevent collapse or hinging during projection.

For optimum results, the reinforcing material (splicing tape) should extend to both edges of the film to include the perforation area. Although tape width is not considered critical, it has been determined that tape 0.730 in (19.05 mm) wide, which includes two perforations on each side of the splice, may adequately reinforce the splice but consideration should be given to the sudden changes in apparent film stiffness at the edges of the splicing tape if tapes on the two sides of the film are exactly superimposed, and to the possible visibility of the tape edges if they appear in the projected image.

Reinforcement tape should be placed on the base side as the preferred side. If magnetic sound tracks are applied, the tape should be on the opposite side.

When a butt splice is made with tape only, care should be taken to tightly butt the two pieces of film with minimal separation with the tape placed on both sides of the film. The spliced film should flex evenly, with no tendency to collapse or hinge.

A6. When overlap splices are made on film which will travel over magnetic heads, the splice should be made so that the trailing film drops onto the scanning head rather than bumps up onto it.

A7. When tape splices are used, care should be taken to keep perforations clear of foreign matter. This requires careful alignment of pre-perforated tape, or clean, precise perforating of the tape by the splicer.

A8. Splices should be inspected frequently for defects including dirt, discoloration, edge lifting, etc. With tape splices, it is important to inspect for stretching, hinging, oozing of adhesive, and width-wise expansion which can cause a hangup in projection.

A9. If the splice consists of a tape material or if tape material is used to reinforce cement splices, it is recommended that consideration be given to the transparency characteristics. All air bubbles should be removed and the edges of the tape should make firm contact. Currently available pre- or post-perforated transparent polyester tape with pressure-sensitive adhesive is recommended.