

GRAVURE TROUBLE-SHOOTING GUIDE

DEFECT	PROCESS PROBLEM	PROBABLE CAUSE	TEST	POSSIBLE REMEDIES
CHATTER	Incorrect blade setting	Blade angle too sharp Too much blade pressure		Flatten blade angle Reduce blade angle
	Blade too sharp	High pigment ink sharpening blade	Solids test	Replace ink if out of spec
INK FLOW	Uneven ink flow from fountain	Dried ink on fountain Fountain set up incorrectly		Clean off the fountain Remount fountain
	Too little ink flow from fountain	Fountain too far away from cylinder Ink flow valve not open enough Ink filter clogged Ink pump not operating correctly Fountain baffles are plugged or bent	Pressure gauge	Adjust fountain closer to cylinder Open valve wider / check for blockage Change ink filter Replace ink pump Clean / adjust baffles
	Too much ink flow from fountain	Fountain too close to cylinder Ink flow valve open too wide		Adjust fountain away from cylinder Close valve slightly
PICKING	Ink not drying completely on web	Low temperature in dryer Low air flow in dryer Low steam pressure to dryer Press speed too high (small dryers only)	heat gun magnehelic	Raise dryer temperature Increase dryer air flow Notify maintenance Decrease press speed
	High ink viscosity	Solvent evaporation from ink	viscosity test	Slowly add more solvent to ink
	Incorrect pressure on impression roller	Too much pressure on impression roller Too little pressure on impression roller Impression roller is the wrong durometer Dirty impression roller Defective / uneven impression roller	measure nip flat area measure nip flat area durometer Tester	Decrease roller pressure Increase roller pressure Change roller durometer Clean the impression roller Change the impression roller
	Chill rollers too warm	Water supply not cold enough / not flowing	heat gun	Notify maintenance

Gravure Trouble Shooting Guide

P. Laden



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