

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

AN Whitehead



Gravure Trouble Shooting Guide:

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