# 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 link 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 link 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 link flow valve open too wide		Adjust fountain away from cylinder Close valve slightly
PICKING	link not dryling 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 Notity maintenance Decrease press speed
	High link 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 durameter Dirty impression roller Defective / uneven impression roller	measure nip flat area measure nip flat area durrometer Tester	Decrease roller pressure lincrease 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	Notity maintenance

# **Gravure Trouble Shooting Guide**

**RJ Shavelson** 

**Gravure Trouble Shooting Guide:** 

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