

TROUBLESHOOTING FOR WEB PRESSES

BLOCKING : Undesired adhesion between printed signatures or sheets in a bundle or load, causing them to stick together.

CAUSES

1. Dryer temperature too low for speed of web. Insufficient solvent being released from ink film.
2. Ink film thickness excessive.
3. Inadequate evacuation of solvent vapours clinging to web as it leaves dryer.
4. Chill system not working properly – ink resins are not setting hard enough.
5. Stock is not porous enough or has a water content that is too high.
6. pH/conductivity of fountain solution is incorrect.
7. Ink takes on too much water.
8. Plate dampening is uneven.
9. Ink film is only surface-dried in oven and still wet underneath. After chilling, ink solvent will work its way toward surface causing set-off. Most likely to occur with heavier-than-normal ink film thickness, very non-absorbent stocks, or high oven temperatures.
10. Ink films do not dry at normal dryer temperatures.

REMEDIES

1. Increase dryer temperature to specification level.
2. Run less ink or consult ink manufacturer to increase strengths for this purpose.
3. Increase velocity of air in air-knife scavenger at dryer exit.
4. Lower chill-roll temperature. (Caution : Watch for chill-roll condensation.)
5. Switch stock to correct porosity or water content.
6. Adjust pH/conductivity to proper level.
7. Consult ink manufacturer for proper adjustment.
8. Keep dampeners clean and free from accumulated dirt. Prevent drafts, check windows, vents and forced-air systems.
9. Reduce speed of press. Adjust oven temperature.
10. Consult ink manufacturer for inks that dry at lower temperatures.

