

## TROUBLESHOOTING FOR SHEETFED AND WEB PRESSES

**DRYING TOO SLOW:** Ink remains tacky during press delivery and bindery operations, resulting in set-off, marking or blocking.

### CAUSES

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

### REMEDIES

1. Drain circulation tank and make a fresh mix with correct amounts of etch and alcohol/alcohol substitutes.
2. Substitute stock with one that has a correct moisture content. Allow stock to acclimatize.
3. Use a higher pigmented ink or consider a UCR separation.
4. Check with manufacturer for correct ink. Inks with high vegetable oil content never dry hard.
5. Increase dryer temperature to specification level.
6. Run less ink or consult ink manufacturer to increase strengths for this purpose.
7. Increase velocity of air in air-knife scavenger at dryer exit.
8. Lower chill-roll temperature.  
(Caution: Watch for chill-roll condensation.)
9. Consult ink manufacturer for proper adjustment.
10. Keep dampeners clean and free from accumulated dirt. Prevent drafts, check windows, vents and forced-air systems.
11. Reduce speed of press. Adjust oven temperature.

(continued on the next page)



**DRYING TOO SLOW** : (continued)

**CAUSES**

12. Ink films do not dry at normal dryer temperatures.

**REMEDIES**

12. Consult ink manufacturer for inks that dry at lower temperatures.