

## TROUBLESHOOTING FOR WEB PRESSES

**MARKING** : Streaks, tracks or smudges on web due to mechanical contact.

### CAUSES

1. Grater roller.
2. Web bustle wheels.
3. Improper airflow through oven causing web to flutter and make contact with oven apparatus.
4. Chill roll not cool enough.
5. Web temperature reached in the oven is not high enough to drive off sufficient ink solvents.
6. Dryer does not have capacity to properly handle press speeds reached or type of work printed.
7. Paper is very non-absorbent. Very little ink penetration occurs to provide basis for binding to paper.

### REMEDIES

1. Install grater roller with sharper points. Increase pigment strength of ink so as to allow decrease in ink film thickness carried on web.
2. Move wheels so as to contact non-image areas only. If moving wheel is not possible, apply Teflon tape to lessen abrasiveness of wheel surface.
3. Consult oven manufacturer for proper adjustment or adjust web tension. Balance feed and exhaust.
4. Reduce chill-roll temperature so that post-chill-roll web temperature is 90°F or less. Recommended chill-roll water temperature is 72-75°F.  
Caution: If chill rolls are too cold, condensation can occur. Reduce oven temperature to minimum necessary to get the web through chilling and press folding delivery operation.
5. If flame impingement dryer used, adjust flame tips to impinge properly. If high-velocity forced air dryer used, raise circulating air temperatures. Decrease press speed. Increase air velocity through oven to remove air and vapour layer clinging to moving web. Consult ink manufacturer to obtain faster drying ink.
6. Reduce press speed to facilitate proper drying.
7. Consult paper manufacturer. Change paper.

(continued on the next page)



**MARKING** : (continued)

**CAUSES**

8. Ink film thickness is too great.

**REMEDIES**

8. Raise air temperature circulating in dryer. Reduce press speed to increase dwell time in dryer. Increase air velocity circulating to help remove solvent vapour layer. Consult ink manufacturer. Change to faster-drying inks. Use a UCR separation.