

TROUBLESHOOTING FOR SHEETFED AND WEB PRESSES

PILING: Ink builds up on areas of the rollers, blankets and/or plate, creating a dry accumulation known as “caking” or “piling.”

CAUSES

1. Pressure between plate and blanket incorrect.
2. Rollers of wrong durometer, improperly set.
3. Ink is poorly ground.
4. Running improper ink/water balance.
5. Ink train too cool.
6. Ink tack too high.
7. Running too thin an ink film.
8. Ink pigment piling. Ink lacks sufficient lubrication to transfer properly, or there is heavy, opaque pigment in the ink.

REMEDIES

1. Blanket and/or plate under-packed causing poor transfer and piling. A .004” to .006” (0.10mm to 0.15mm) pressure is required for proper transfer.
2. Use proper rollers, check roller settings.
3. Check grind of ink, re-grind if necessary.
4. Adjust ink/water balance.
5. Adjust ink train temperature (25° to 27°C, 77° to 81° F) to recommended level.
6. Reduce tack only enough to eliminate piling – excessively low tacks will cause other problems.
7. Weaken ink to increase ink film thickness.
8. Small amount of boiled linseed oil added to the ink may help this. Contact ink supplier if problem persists.

