HEPI

Trouble shooting Guide

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Part 1. Flexography

Defects	How Recognized	Probable Cause	Suggested Remedy
Poor adhesion	1. Ink Fail Rub – test. 2. Ink fails to adhere to adhere to material. 3. Fails crinkle test. 4. Fails scuff test.	1. Improper ink formula. 2. Ink thinned too much. 3. Insufficient heat; too low web temperature. 4. Lack of treatment of some materials. 5. Surface of stock may be contaminated.	1. Make certain you have the correct ink for the kind and grade of stock being run. 2. Restore and hold ink. viscosity at optimum point. Add fresh ink or resin binder. 5. Increase heat and/or air volume. 6. Check surface of the material for adequate treatment. 7. Check with supplier of stock, check advisability and effectiveness of applying wash-coat before printing.

Bleed	1. An under-color wetting into an over color. 2. Diffused or migrating colors	1. Under color drying too slowly or over color drying too fast. 2. Effect of some plasticizers of some stocks or materials on dye stuffs.	1. Use faster or slower solvent as required. (Preceding colors must be dry enough to receive subsequent colors laid down.) 2. A void use of dye colorants when unknown plasticizers are likely to be involved.
Blocking	Undesired adhesion between two web surfaces.	1. Improper ink drying. 2. Trapped solvents. 3. Excessive pressure in rewind. 4. Softening of pre applied coatings. 5. Web rewound too warm. 6. Web rewound with excess surface moisture.	1. Proper solvent balance. 2. Effective drying system or solvent balance. 3. Reduce rewind tension. 4. Use solvents that do not attack prior coatings. 5. Reduce web temperature by chilling within 10 F of room temperature or reducing dryer temperature. 6. Avoid rewinding excess surface moisture into finished roll. Avoid over-chilling that condenses moisture on web prior to rewind

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