

# WELCOME

## GAA 2013 Technical Conference Charlotte, NC

# A Few things you need to know 'bout visitin' NC

1. Possums sleep in the middle of the road with their feet in the air
2. The word "Jeet" is actually a phrase meaning "Did you eat?"
3. It is not a Shopping cart, it is a buggy
4. We use "fix" as a verb. For example: "I'm fixing to go to the store "
5. You know all four seasons: Almost Summer, Summer, still Summer and Christmas.

# A Few Starter Key Points

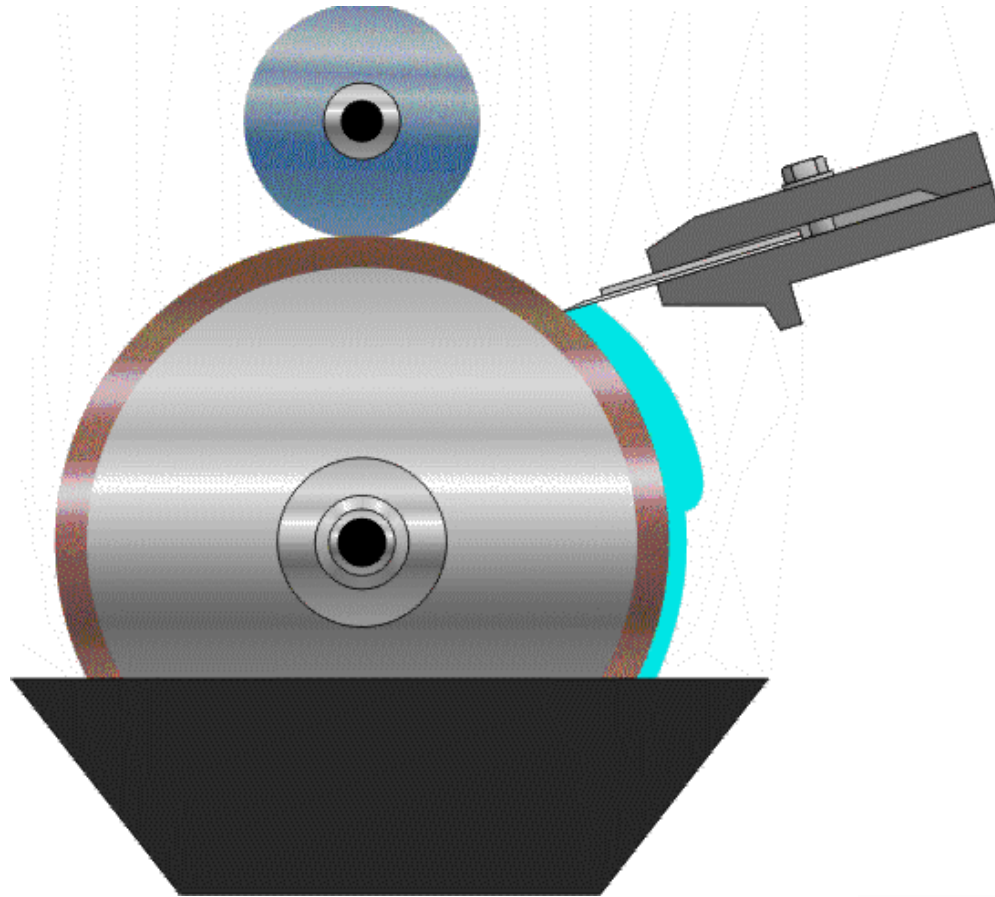
- **The higher/steeper the angle the cleaner the wipe**
  - **Because the contact area is smaller**
- **The lower/flatter the angle the less ink removed**
  - **Because the contact area is larger**
- **The thinner the blade tip the cleaner the wipe**
  - **Because the contact area is smaller**
- **The thicker the blade tip less ink removed**
  - **Because the contact area is larger**

# Bevel & Lamella Tip Thickness

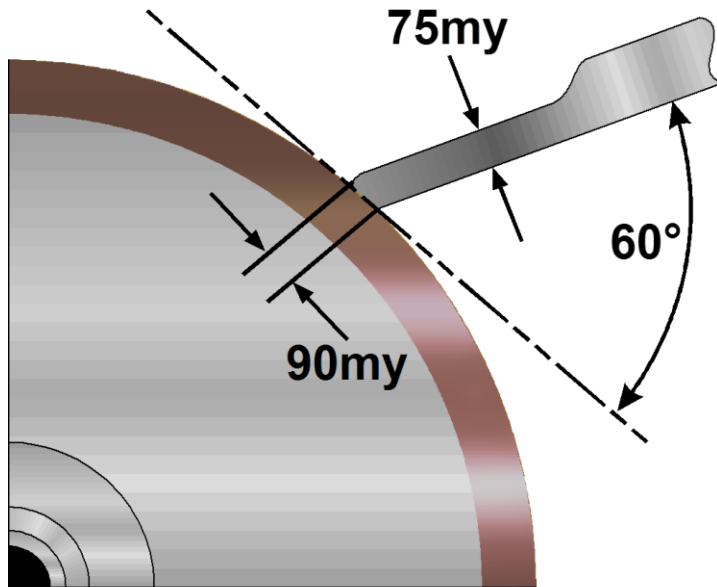


## ***Doctor Blade Angle***

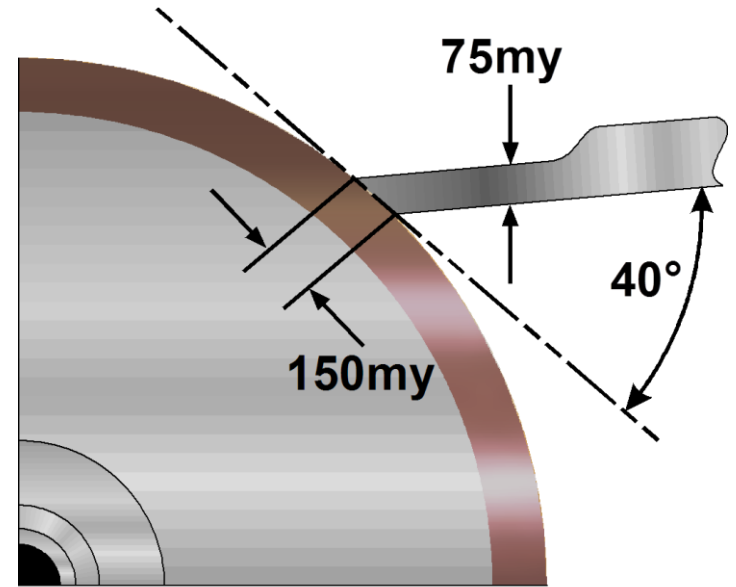
### Correct Contact Angle



## Doctor Blade Angle



Correct

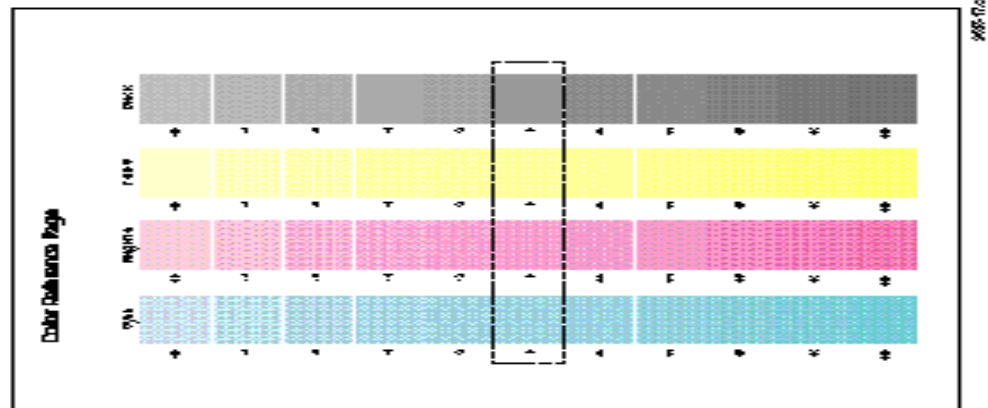


Incorrect

# I HAVE TWO QUESTIONS.....BE HONEST

Who here has ever changed the doctor blade angle to match color to a color standard?

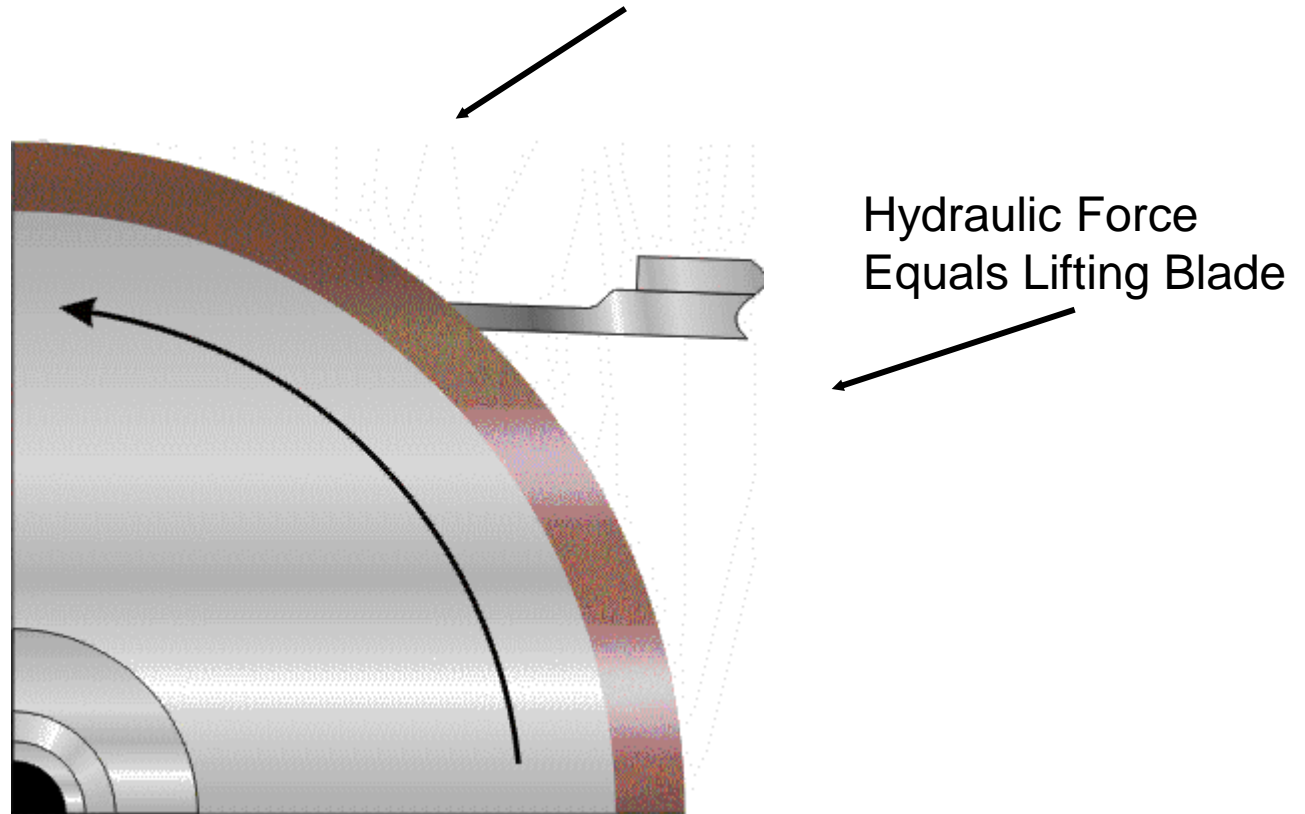
Who here has ever turned off the doctor blade oscillation to achieve color?



# ***Doctor Blade Angle***

## **Flat or Incorrect Contact Angle**

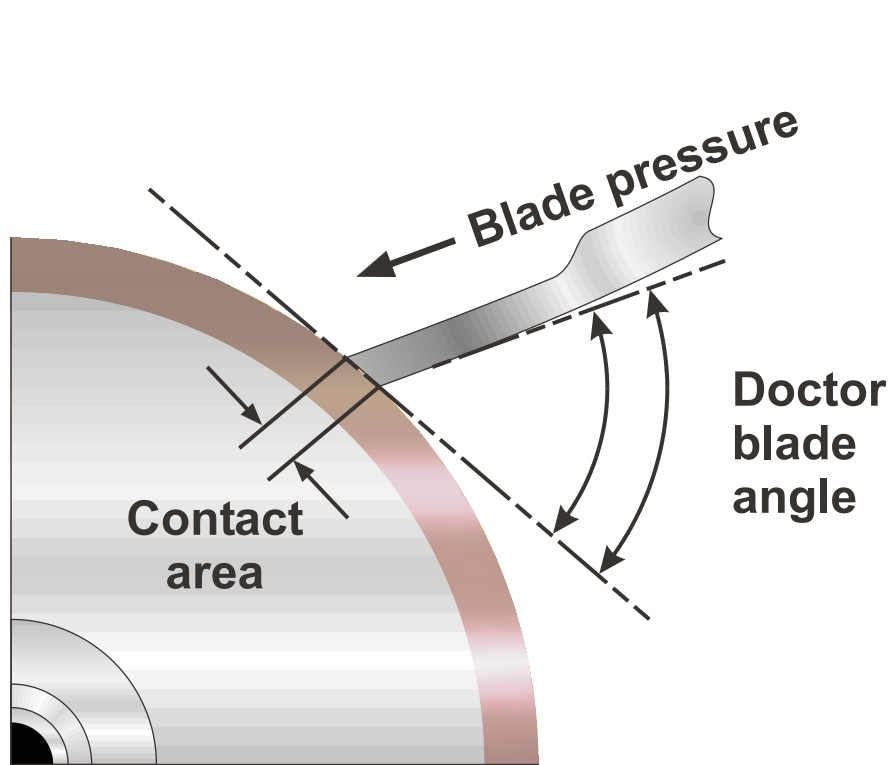
Haze, tone and streaking



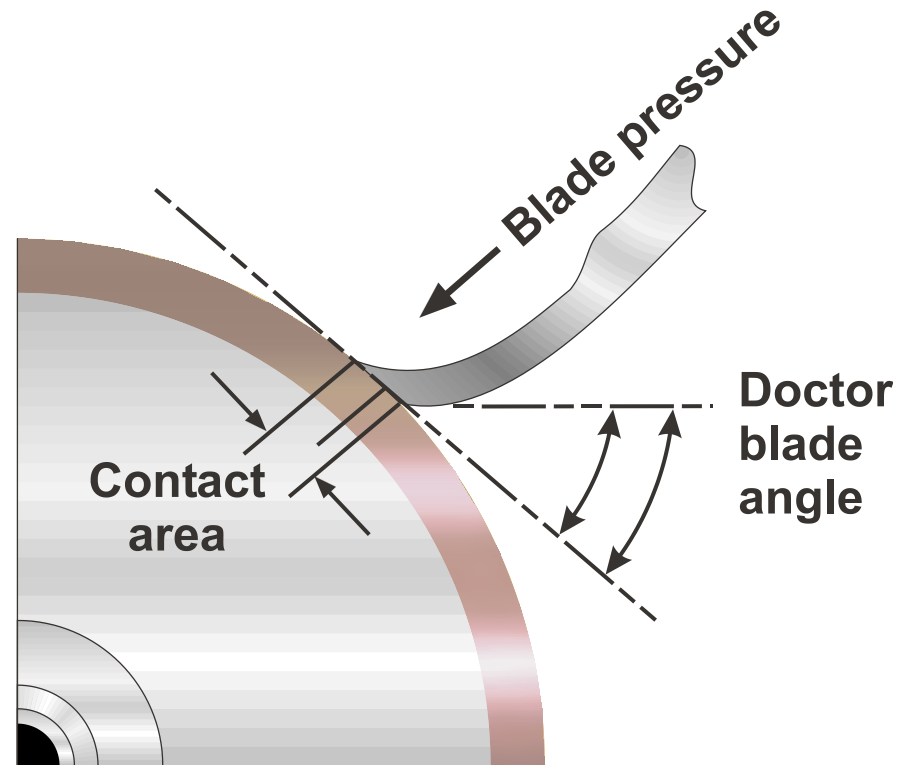


# Doctor Blade Pressure

Correct Doctor Blade Pressure



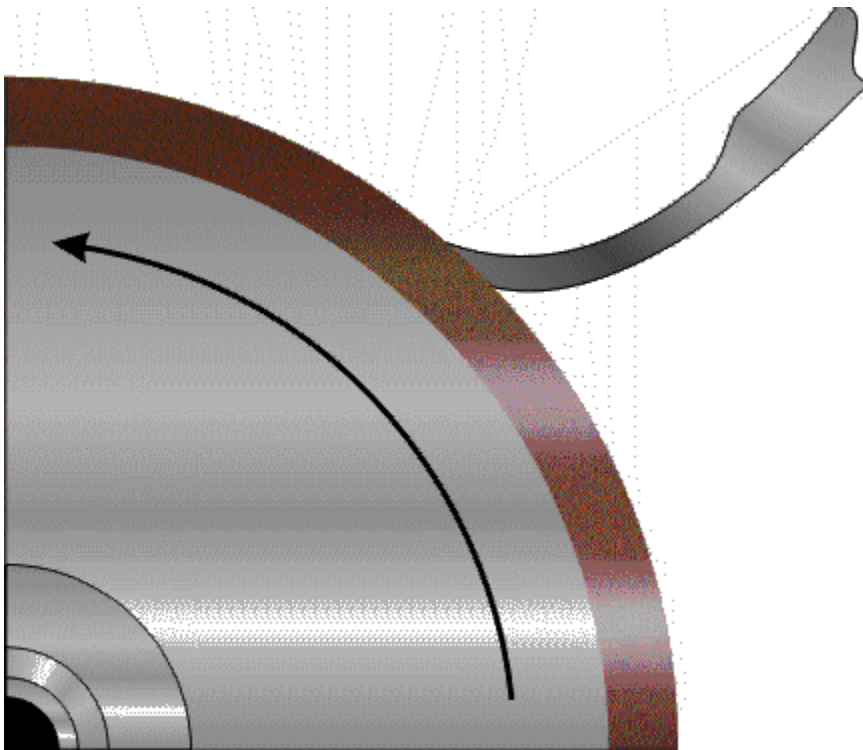
**Correct**



**Incorrect**

## *Doctor Blade Pressure*

### Excessive Pressure - Effects of hydraulic Force



### **Blade Lift leads to**

- **Hazing (Toning)**
- **Streaking**

# JOB RUN DATA SHEET

DB tracking Gravure [Compatibility Mode] - Microsoft Word

File Home Insert Page Layout References Mailings Review View

## JOB DATA SHEET

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**JOB NAME:** \_\_\_\_\_

**SUBSTRATE** \_\_\_\_\_

**INK SERIES:** \_\_\_\_\_

**PRESS NUMBER:** \_\_\_\_\_

**PRESS SPEED:** \_\_\_\_\_

**FORMAT:** \_\_\_\_\_

**CYLINDER SIZE:** \_\_\_\_\_

**COLOR APPROVAL:** \_\_\_\_\_

**DATE RAN LAST:** \_\_\_\_\_

**TOTAL FOOTAGE:** \_\_\_\_\_

**COUNTER START:** \_\_\_\_\_

**COUNTER END:** \_\_\_\_\_

**TOTAL IMPRESSIONS:** \_\_\_\_\_

**WASTE ALLOWANCE:** \_\_\_\_\_

**A- Hazing / Toning**

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100%

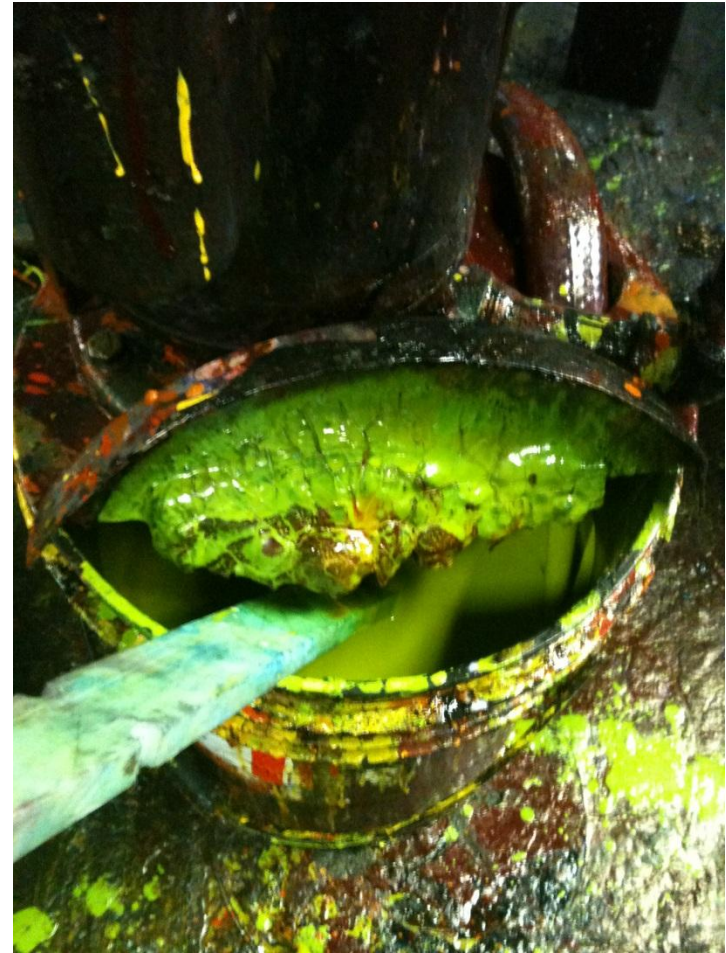
# Press Settings Data Sheets

Unit	Color	Viscosity	Blade Type	Blade Angles	Blade Pressure	Special Instructions
1	Yellow	22	Bevel	60*	1.3 bar	Always use ____
2	Magenta	23	Coated	45*	19 psi	Never use_____
3	Cyan	22	Bevel	17		
4	Black	21	Lamella	18		
5	Silver	23	Coated	14		
6	Brown	23	Coated	18		
7	White	20	Coated	12.5		Use Series 44 Ink

# Angle Finders



# Ink Contamination



# Closing Thoughts

- Start with good angles and maintain them
- Start with light doctor blade pressure
- Be aware of your doctor blade tip thickness
- Do not move blades angles to achieve color
- Always run your oscillation
- Keep data sheets on press settings
- Clean your parts

# THANK YOU

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