

TIP 0305-38

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Troubleshooting the printing section

Scope

Trouble shooting issues in the printing section.

Safety precautions

Accomplish actions with drive stopped. Use “Tag Out/Lock Out Procedures” established by the plant before your initial checks.

Operating troubles

<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
Insufficient ink	No ink in reservoir	Replenish reservoir
	Clogged hoses	Remove and clean, or replace
	Air pressure lost	Find and correct trouble
	Ink foaming	Add defoamer to ink
	Electricity failure	Find and correct trouble
	Ink circulating system filter clogged	Remove and clean filter; check ink pH
	Ink spilled on floor	Put doctor blade assembly in position, or turn air pressure on Check end seals and blades for wear, reduce ink flow
	Incorrect setting of circulating system valves	Check valve setting

TIP Category: Automatically Periodically Reviewed (Ten-year review)

<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
	Erratic air supply to pumps	Minimize bends in the line, the best is a direct line from air compressor or air accumulator tank, check air valve
Ink roll does not go up	Air solenoid defective	Replace solenoid
	Pneumatic lines clogged with oil or water	Remove and bleed; replace if necessary
	Ink roll eccentrics bound and cannot move due to dried ink and debris	Clean and re lubricate
	Leaky pneumatic lines	Repair or replace
	Air supply not turned on or insufficient air	Ensure that air supply valves are open, and that the air regulator is set to the proper pressure
Jam-up in printing section	Loose liner on sheet	Replace sheet
	Loose sheet guides (sub beds)	If sheets are slightly warped, a loose sheet guide may cause snags; tighten
	Sheet liner sticking to printing plate	This will happen if machine is stopped during run without first interrupting feed and clearing sheets in process; remove jammed board and carefully clean printing plate. Ink may be drying too fast – adjust ink
Loss of register (First determine from appearance of sheet where register was lost. It will be at a point in the machine preceding the out-of-register evidence.)	Misplaced printing plate	Relocate to correct position
	Stretched or loose printing plate blanket	Repair or replace
	Wrong stretch from plate maker	Replace plates
	Not enough print surface on plate to pull paper	Pull strips relocated or changed
	Loose or worn gears in compensator assembly or main drive.	Repair or replace
	No pull bands on plate	Pull strips relocated or changed
	Loose “constant mesh” shaft coupling	Replace key in feed/pull roll

<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
	Insufficient pressure on pull rolls	Adjust
	Upper feed pull roll worn	Replace
	Loose feeder bar	Tighten
Printing out of registration	Insufficient sheet control	Add pull bands or add plate material in areas T/B D/C out, gives more control
Print not centered	Printing blanket not centered on machine Plates incorrectly positioned	Return lateral setting of print cylinder to "O" after previous order Remount plates
Ink return flow sluggish or stopping during run	Ink return pump clogged with paper dust.	Dismantle return pump and clean out (must be done once a week at last washup)
	No return pump (gravity only) ink foaming	Add defoamer in spray form only
	Ink pan full of paper scrap	Clean pan out
Ink viscosity dropping and/or ink level increasing	Water getting into ink; valve sticking on automatic washup device	Check water shutoff valve; piston may stick; increase air supply
Ink pan overflowing	Ink supply flow too great	Ink return flow should visually show a flow not much greater in diameter than 3/8 in. (10 mm); supply capacity is greater than return capability
	Ink pan full of paper scrap	Clean the pan
	Ink return pump clogged	Dismantle return pump and lines and clean
Ink throwing at high speed on print cylinder	Ink flow too great	Cut down ink flow
	Damaged meter roll or nick in doctor blade.	Replace roll or doctor blade
	Viscosity too low	Check pH and adjust viscosity
	End seals worn	Replace end seals
Section does not close	Gearing out of time	Set timing dials on all sections at "0"
	Floor rollers damaged	Replace worn/broken floor rollers
	Tracks clogged with dirt	Clean tracks

<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
Press will not start; torque sensing device light "On"	Torque sensing device indicating problem with anilox and/or wipe roll	Check ink level in the pan, make sure lines are clear, check anilox and /or wipe rolls fill ink container if it is out of ink
No response to impression pressure setting on nip control	Loose powered elevator logic card (for machines with anilox nip controls)	Remove control panel; push card into place; tighten holding bracket
Impression nip control dial out of adjustment	Caliper of gap does not equal dial setting	Calibrate gap; set dial to measured gap
Wash up water runs sluggish or stops through return line	Ink return pump clogged with paper dust	Dismantle return pump and lines and clean
	Ink too heavy	Check Ph/viscosity, bad ink (old)
Insufficient ink in nip	No ink in bucket	Fill ink bucket
	Ink too heavy	Check pH/viscosity, bad ink (old)
	Clogged hoses	Remove and clean
	Ink foaming	Add defoamer with a spray bottle (only use a little)
	Ink filter clogged	Remove and replace or clean
	Ink circulating system valves not properly adjusted	Check valve adjustments
	Pump jammed or malfunctioning	Check pump
Non uniform ink coverage on ink roll	Improper pressure between wipe roll and ink roll	Check adjustment. (Parallel to anilox roll)
	Metering system damaged/worn	Replace wiper roll or doctor blade. Parallel to anilox roll
	Anilox roll worn or dirty	Replace or clean anilox roll
	Ink foaming	Add defoamer spray only
Ink smear	Excessive ink application due to worn or dirty doctor blade	Clean or replace doctor blade