


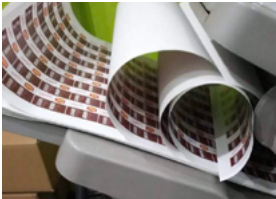






Troubleshooting Guide

Conversion & Application

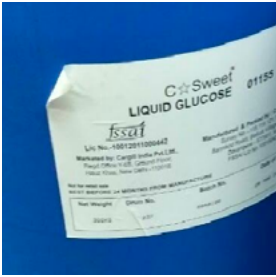

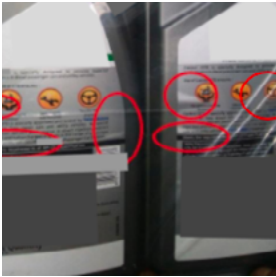
Digital

Problem	Cause	Remedies
Scratch/ Nail test failure 	<ul style="list-style-type: none"> GSM setting not as per Laminate/ substrate Toner composition, Heavy ink/ toner deposition Insufficient fusing/ drying Non compatibility with substrate 	<ul style="list-style-type: none"> Adjust GSM setting as per Laminate/ substrate Replace toner, fresh lot/ batch Try different substrate lot; consult with AD Tech rep Consult machine manufacturers for substrate compatibility
Static charge (post printing) 	<ul style="list-style-type: none"> Uncontrolled pressroom conditions (temp & Humidity) Excessive heat and friction during fusing Static eliminator not functional 	<ul style="list-style-type: none"> Maintain pressroom conditions (Temp 23°C & RH 50%) Adjust GSM setting as per Laminate/ substrate Inspect machines auxiliaries for effectiveness Consult substrate supplier and machine manufacturer
Multiple sheet feeding / jamming 	<ul style="list-style-type: none"> Uncontrolled press room conditions GSM setting not as per Laminate/ substrate High static build up, check static eliminator 	<ul style="list-style-type: none"> Keep material in original packing Maintain pressroom conditions (Temp 23°C & RH 50%) Adjust GSM setting as per Laminate/ substrate Inspect machines auxiliaries for effectiveness
Poor toner adhesion 	<ul style="list-style-type: none"> Inefficient ink fusing/ drying Toner composition/ expired toner Non compatibility with substrates top coat 	<ul style="list-style-type: none"> Keep material in original packing; Temp 23°C & RH 50% Inspect fusing unit Replace toner, fresh lot/ batch Try different substrate lot; consult with AD Tech rep Consult machine mfr for substrate compatibility
Post print curl 	<ul style="list-style-type: none"> High fusing temperature Heavy toner deposition Uncontrolled press room conditions Machine decurler settings 	<ul style="list-style-type: none"> Optimise GSM setting on machine. Optimise profile/ ink deposition Maintain pressroom conditions (Temp 23°C & RH 50%) Consult substrate supplier and machine manufacturer

Offset

Problem	Cause	Remedies
Pin holes (Inconsistent printability) 	<ul style="list-style-type: none"> Ink rheology not maintained Non-standard press room conditions 	<ul style="list-style-type: none"> Check the rheology of ink or Consult ink manufacturers. Keep material in original packing. Maintain pressroom conditions (Temp 23°C & RH 50%) Use different lot material on the same machine parameters and Consult with the AD representative
Mis-registration 	<ul style="list-style-type: none"> Press parameters not aligned (plate, blanket, and substrate) Blanket swollen or embossed Image not aligned on plate Use of excess fountain solution (dimensional instability) Curling because of guillotine at customer end 	<ul style="list-style-type: none"> Align plate, blanket, and substrate on press. Replace Blanket with new one. Make new plate Check alignment and pressure of roller. Avoid multiple pass printing and minimise time b/w passes. Avoid the guillotine process in std. Size
Air bubbles (post lamination) 	<ul style="list-style-type: none"> Thermal Lamination Wrong / excessive of anti setoff powder High lamination tension & uneven Nipping Pressure Ink not dried. Wet Lamination Water in higher proportion in adhesive Foaming in adhesive 	<ul style="list-style-type: none"> Change anti setoff powder with a fine one. Maintain Press room conditions. Ideally (Temp 23 0C & RH 50%) Optimize tension & Pressure Use fast setting ink & Sufficient Dwell time after printing. Consult with adhesive supplier Add anti Foaming in adhesive
Ink set-off (post print) 	<ul style="list-style-type: none"> Use of excess fountain solution Insufficient spray of set-off powder Rough Handling/ High stacking Ink not cured/ oxidised/ dried Ink layer too thick/ excessive moisture in paper/ RH high 	<ul style="list-style-type: none"> Maintain PH & conductivity during press run, Replenish fountain solution. Inspect quality of set-off powder and optimize its spray Reduce stacking height Check IR/UV lamp intensity

Application

Problem	Cause	Remedies
Label edge lifting (post labeling)	 <ul style="list-style-type: none"> • Inconsistent massaging/ pressure • Application temp too low. • Heavy ink/varnish deposition on edges. • Low surface energy substrate. • Adhesive incompatible with substrate 	<ul style="list-style-type: none"> • Review massaging process and use squeegee • Application temp.should be as per TDS • Avoid heavy ink deposition on edges. • Pull liner instead of face to avoid face curl. • Low surface energy substrate required aggressive adhesive • Consult with the AD representative
Label fall-off (post labeling)	 <ul style="list-style-type: none"> • Moisture/contamination on substrate • Contents migrating through containers. • Substrate Temp./application temp too low. • Rough surface /Adhesive coat weight too low • Adhesive not compatible with substrate 	<ul style="list-style-type: none"> • Ensure cleaning of substrate before application. • Ensure no migration through containers. • Application temp. As per TDS • Try aggressive / high adhesive GSM products • Consult with the AD representative.
Abrasion failure (transit test)	 <ul style="list-style-type: none"> • Protection layer (Varnish/lamination) not done. • Excess friction b/w two container on label surface 	<ul style="list-style-type: none"> • Use of appropriate Varnish/Lamination • Use separators for avoiding excess friction b/w containers. • Design outer corrugated box as per container size and stacking..
Air bubble (post labelling)	 <ul style="list-style-type: none"> • Inconsistent massaging/ pressure • Container surface not smooth • Contamination/Moisture on Surface. • Hot Filling of Container. • Application temp too low/ air entrapment during application. 	<ul style="list-style-type: none"> • Ensure sufficient massaging and use squeegee to avoid air entrapment during application. • Ensure cleaning of substrate before label application. • Hot filling required special adhesive, Ensure label application at atmospheric conditions • Application temp. as per TDS • Consult with the AD representative.