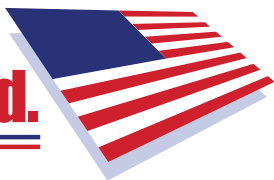


**American Inks  
& Technology Ltd.**



## **Troubleshooting Guide**

**Service • Value • Quality • Integrity**

*The basis of our success & the future of yours.*



[www.AMINKS.com](http://www.AMINKS.com)



**AMERIFRESH™ pH Adjuster** - “Refresh with **AMERIFRESH™**” - Use to replenish the amine lost while printing, and to rejuvenate older kits of ink.

**pH Max** - EXTREMELY concentrated form of **AMERIFRESH™** - Use to raise the pH of an ink without reducing the strength of the formulation.

**Defoamer** - Eliminate excessive foam by modestly misting on top of formed foam bubbles.

**Extender** - Add important properties back into an ink while maintaining its viscosity and extending your print mileage.

**AMERICLEAN GREEN™** - Intense proprietary cleaning agent used to clean anilox rolls, doctor blades, printing plates, pumping units, ink spills and more. With a non-caustic pH level you can use **AMERICLEAN GREEN™** straight for deep cleans or dilute up to 10:1 with water for daily maintenance of virtually anything in your pressroom.

## Color Too Strong



### Cause

- Ink viscosity too high
- Anilox volume is too low

### Solution

- Add **EXTENDER** or **AMERIFRESH™**
- Change anilox volume

## Color Too Weak



### Cause

- Ink viscosity too low
- Anilox cell volume too high
- Improper pressure settings on impression or anilox roll
- Anilox cells are dirty or clogged

### Solution

- Add fresh ink
- Utilize anilox of a lower cell volume
- Reduce metering roll pressure to allow more ink on anilox roll
- Clean anilox roll with

**AMERICLEAN GREEN™**

## Color Variation During Run



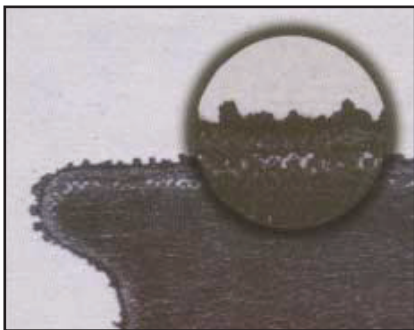
### Cause

- Ink viscosity changing
- Variation in substrate

### Solution

- Monitor viscosity every 15 minutes to maintain & control
- Increase viscosity by adding fresh ink, if possible, to compensate

## Dirty & Ragged Edges of Print



### Cause

- Excessive plate impression
  - Ink pH is too low
  - Ink is drying too fast

### Solution

- Reduce plate to substrate impression
- Add **AMERIFRESH™** or **pH MAX** to raise pH
- Increase machine speed, eliminate any air or heat blowing on plates, or slow drying by adding a slow solvent

## Filling In of Small Type



### Cause

- Excessive plate impression
  - Ink viscosity too high
- Reverse print design is too small for ink film thickness

### Solution

- Reduce plate to substrate impression
- Add **EXTENDER** or **AMERIFRESH™**
- Revise artwork and print plates for press capabilities

## Ink Foaming



### Cause

- Ink pump too fast (trapped air)
  - Agitator too fast (trapped air)
    - Air in line
- Remnant detergent in ink from cleaning with **AMERICLEAN GREEN™**
  - Not enough **Defoamer** in ink

### Solution

- Slow pump speed
  - Slow agitation
- Check for air leaks
  - Use fresh ink
- Mist a small amount of **Defoamer** over ink foam

## Pinholes & Fisheyes



### Cause

- Too much **Defoamer** added to ink
  - Ink is drying too fast
- Dirt or foreign material on impression

### Solution

- Replace with fresh ink
- Increase machine speed, eliminate any air or heat blowing on plates, or slow drying by adding a slow solvent
- Clean and remove the foreign material with **AMERICLEAN GREEN™**

## Poor Trapping



### Cause

- Improper viscosity sequence
  - Improper pH sequence
- Second down ink is not compatible with first down ink

### Solution

- Viscosity should be 3-4 seconds higher for each succeeding down
- pH sequence should be from high to low, Example - 9.4, 9.1, 8.8, 8.5
- Switch the trapping sequence, and/or use a transparent ink

## Tracking or Smearing



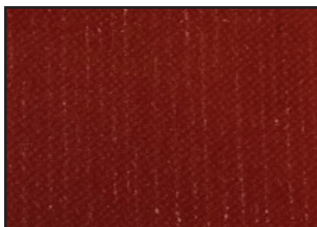
### Cause

- Ink drying too slow
- Ink film too thick
- Die coated with ink

### Solution

- Verify correct ink formulation (DISPLAY GRADE = Fast Dry) or increase ink drying speed by decreasing machine speed, reducing ink viscosity and, if available, increase dryer temperature
- Reduce ink film with better metering
  - Clean die

## Striations



### Cause

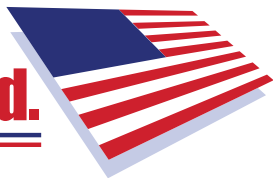
- Anilox cells are dirty or clogged
- Durometer of plate too high / plate is too hard
  - Ink viscosity too low

### Solution

- Clean anilox roll with **AMERICLEAN GREEN™**
- Use plates with a softer durometer
  - Add fresh ink

# **American Inks & Technology Ltd.**

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