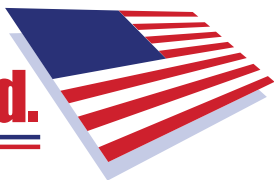


**American Inks
& Technology Ltd.**



Troubleshooting Guide

Service • Value • Quality • Integrity

The basis of our success & the future of yours.



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



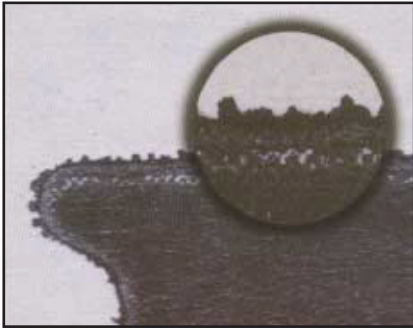
Cause

- 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 to substrate 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



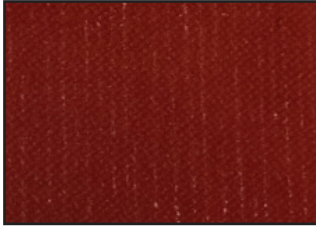
Cause

- 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



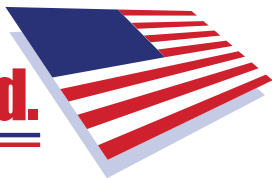
Cause

- 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

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