

INDEX

	Page
FLEXOGRAPHIC PRINTING	
Introduction	1
Press Types	1
Exercise 1	2
Machine Controls	3
Exercise 2	3
Machine Guards and Safety.....	3
Exercise 3	4
Rolls and Gears	4
Exercise 4	6
Exercise 5	6
Unwind Equipment	6
Exercise 6	7
Exercise 7	7
Unwind Tension Control	7
Exercise 8	8
Rewind Systems	8
Exercise 9	8
Rewind Tension Control	9
Exercise 10.....	10
Drying Systems	10
Exercise 11.....	11
Exercise 12.....	11
Press Maintenance	12
Exercise 13.....	13
Work Docket	13
Exercise 14.....	14
Printing Sequence	14
Exercise 15	14
Mounting and Proofing	14
Exercise 16.....	16
Exercise 17.....	16
Exercise 18.....	16
Exercise 19.....	16
Presr Wash-up Procedure	17
Exercise 20.....	17
Care and Use of Rollers	17
Exercise 21.....	18
Pull or Draw Rolls	18
Exercise 22.....	18
Printing Troubles	19
Exercises 23 and 24	20
Static Elimination Associated with Web Fed Machines..	20
Exercise 25 - Static Eliminators	21

FLEXOGRAPHIC PRINTING (cont'd)	
Register Control.....	22
Exercise 26	22
Use of the Micrometer.....	23
Exercise 27 - Use of the Micrometer,.....	23
Exercise 28 - Plate Thickness,.....	23
FLEXOGRAPHIC PLATE PREPARATION,.....	25
Introduction	25
Types of Printing Images.....	26
Production of Thermosetting Moulds	27
Exercise 29 - Forme Preparation	27
Exercise 30 - Moulding the Matrix	28
Exercise 31 - Preparing a Matrix	28
Preparation of Rubber Stereotypea.....	29
Exerciee 32 - Natural Rubber	29
Exercise 33 - Plate Moulding Rubber	
Stereotypes.....	30
Exercise 34 - Plate Moulding Rubber	
Stereotypes.....	31
Use of Shrinkage Control Materials in the Manufac-	
ture of Rubber Stereotypes.....	31
Exercise 35 - Plate Preparation Using	
Shrinkage Controlled Rubbers	31
Hand Cut Rubber Dies	31
Production of Thermoplastic Printing Platea.....	32
Exercise 36 - Thermoplastic Moulding	
Materials	32
Exercise 37 - Moulding a Thermoplastic	
Printing Plate	33
Exercise 38 - Moulding a Thermoplastic	
Plate	33
Finishing Operations for Plastic and Rubber Plates	34
Exercise 39 - Edge Trimming Finished	
Plates	34
Exercise 40 - Back Grinding Plastic and	
Rubber Plates	34
Exercise 41 - Routing	35
Hardness of Rubbers and Plastics	35
Exercise 42 - Rubber Hardness Using a	
Shore Durometer.....	36
Storage and Care of Printing Plates	36
Exercise 43 - Plate Storage	37
FUNDAMENTALS OF FLEXOGRAPHIC INKS	38
Resins and Binders	41
Exercise 44 - Resin Colour	41
Exercise 45 - Melting Range of a Resin by	
the Capillary Tube	42

FUNDAMENTALS OF FLEXOGRAPHIC INKS (cont'd)

Solvents	42
Exercise 46 - Dilution Ratio.....	43
Exercise 47 - Solvent Colour	43
Exercise 48 - Solvent Odour	44
Pigments	44
Exercise 49 - Solvent Bleeding	45
Exercise 50 - Pigment Wetting Properties.....	45
Soluble Dyestuffs	45
Exercise 51 - Dye Solubility	46
Drying Time	46
Exercise 52 - Drying Time of Inks	46
Drawdown Test	47
Exercise 53 - Drawdown Test	47
Exercise 54 - Gloss of Inks by Proof Press and Drawdown	48
Exercise 55 - Effect of Paper on Gloss	48
Colour Comparison and Colour Strength	49
Exerciae 56 - Colour Comparison	49
Exercise 57 - Colour Comparison	49
Exercise 58 - To Plot Spectrophotometric Curves of Selected Ink Filma	49
Viscosity	50
Viscometers	51
Exercise 59 - Viscosity of Flexographic Inks..	51
Opacity	52
Exercise 60 - Opacity by Drawdown	52
Exercise 61 - Preparation of Opaque and Tranaparent Tints	52
Ink Coverage	52
Exercise 62 - Ink Eatimation	53
Specific Gravity of Flexographic Printing Inks	54
Exercise 63 - Specific Gravity Determination ..	54
Exercise 64 - Specific Gravity by An Alter- native Method	54
Relative Humidity Measurement	55
Exerciae 65 - Wet and Dry Bulb Hygrometer..	55
Exercise 66 - Temperature Variation Through- out the Printing Departments	56
Oil Resistance	56
Exercise 67 - Oil Resistance	56
Solvent Resistance	56
Exercise 68 - Solvent Resistance	56
Water Bleeding of Inks	57
Exerciae 69 - Testing for Water Bleeding Resistance	57
Soap Bleeding	57
Exercise 70 - Soap Resistance.....	57

FUNDAMENTALS OF FLEXOGRAPHIC INKS (cont'd)	
Resistance to Fats. Acids and Alkalies	58
Exercise 71 - Testing for Fat Resistance.....	58
Exercise 72 - Testing for Acid Resistance.....	58
Exerciee 73 - Alkali Resistance	58
Bleeding into Spirit Varnish	59
Exercise 74 - Bleeding into Spirit Varnish....	59
Testing Prints for Waxing	59
Exerciee 75 - Waxing Test,.....	59
Effect of Outdoor Exposure on Prints	60
Exercise 76 - Outdoor Exposure.....	60
Heat Resistance of Inks	60
Exercise 77 - Heat Resistance	60
Light Resistance.....	61
Exercise 78 - Light Resistance.....	61
Testing for Print Odour	61
Exercise 79 - Testing for Print Odour	62
Abrasion Teeting	62
Exercise 80 - Rub Resistance by Hand	62
Exerciee 81 - Alternative Hand Technique for Rub Resistance.....	62
Effect of Substrate Colour on Hue	63
Exercise 82 - Effect of Paper Stock on Hue ...	63
Effect of Illumination on Hue	63
Exercise 83 - Illumination and Hue.....	64
Storage of Inks	64
Exercise 84 - Ink Storage.....	64
Colour Matching Terms	65
Subtractive Colour	65
Exercise 85 - Subtractive Colour	66
Additive Colour	67
Exercise 86 - Additive Colour	67
Colour Wheel.....	67
Exercise 87 - Preparing a Colour Wheel.....	68
Colour Matching	68
Exercise 88 - Colour Progressives	70
Exercise 89 - Colour Matching	70
Exercise 90 - Colour Matching	71
IMPOSITION	72
Introduction	72
Definition of Marginal Terms	72
Imposition Terms	73
Exercise 91 - Bookwork Margins	73
Imposing - Product Sizes. Shapes and Forms	74
Exercise 92 - Ruling Out a Sheet of 16 Labels.	74
Exercise 93 - Four Page Backing-up Imposition Schemes	75

IMPOSITION (cont'd)**Exercise 94 - Imposing for Sixteen Page**

Half Sheet Work and Turn 75

Exercise 95 - Bookwork Margins 76**Exercise 96 - Eight Page Imposition Rule Up**

Including Page Margins and Trims 77

Exercise 97 - Lining Up Tables 77**Exercise 98 - Ruling Out and Eight Page**

Imposition Scheme 78

Exercise 99 - Sixteen Page Imposition Scheme 78**PRINTING SURFACES FOR FLEXOGRAPHY 79****Introduction 79****Attributes of a Good Printing Paper Surface 80****Paper Substance 82****Exercise 100 - Determination of G.S. M. 82****Machine Direction 82****Exercise 101 - Determination of****Machine Direction 82****Traditional Paper Tests 84****Oil Absorption 84****Exercise 102 - Printing Test for Absorbency****on Coated Papers 85****Exercise 103 - Oil Absorption 85****Water Absorption and Relative Humidity 86****Exercise 104 - Water Absorption and****Capillary Action 86****Moisture Content 87****Exercise 105 - Moisture Expansion 87****Equivalent Weight 88****Bulking Thickness 88****Exercise 107 - Ash Test to Determine the****Percentage of Coating 88****Sizing of Papers 89****Exercise 108 - Traditional Testing for****Absorbency 89****Paper Surface 90****Exercise 109 - Visual Examination of Paper****Surfaces 90****Identification of Paper Fibres 91****Exercise 110 - Identification of Esparto****Grass or Mechanical Wood, Fibre 91****Exercise 111 - Herzberg Stain Test 91****Gloss 92****Exercise 112 - Visual Comparison of Gloss ..****Exercise 113 - Instrumental Measurement****of Gloss 92****Regularity of Furnish and Opacity 93****Exercise 114 - Regularity of Furnish..... 93**

PRINTING SURFACES FOR FLEXOGRAPHY (cont'd)	
Exercise 115 - Opacity Using the P.A.T.R.A. Opacity Guide	93
Surface Strength of Papers.....	94
Exercise 116 - Abrasion Testing of Paper ..	95
Exercise 117 - Dust Test	95
Two Sidedness of Paper	95
Exercise 118 - Determining the Right and Wrong Sides	96
Strength and Durability.....	96
Exercise 119 - Strength Testing	97
Finish.....	97
Exercise 120 - Paper Finish	97
Ink Absorbency	98
Exercise 121 - Printing Test for Absorbency	98
Aluminium Foils	99
Exercise 122 - Foil Caliper	99
Exercise 123 - Gloss of Foils	100
Introduction to Plastics and Rubbers	100
Characteristic Chemical and Physical Properties of Plastics and Rubbers	101
Exercise 124 - The Effect of Heat on Various Plastics	101
Exercise 125 - Rub Resistance	102
Exercise 126 - Affinity for Molten Metal...	102
Exercise 127 - Solvent Resistance	102
Plasticisers and Fillers	103
Exercise 128 - Plastic Fillers and Plasticisers	104
Plastic Films	104
Exercise 129 - Moisture Content of Plastic Films	106
Exercise 130 - Opacity of Plastic Films ...	107
Laminates	107
Exercise 131 - Grease and Oil Resistance ..	107
Continuity of Coatings on Nylon Films	108
Exercise 132 - Continuity of Coating	108
Coating Adhesion Test for Plastic Films	108
Exerciee 133 - Scotch Tape Test for Coating Adhesion	108
Surface Contamination	109
Exercise 134 - Comparative Testing of Surface Contaminants	109
Solvent Evaporation	110
Exercise 135 - Rates of Solvent Evaporation	110