



PRINT ACCESSORIES FOR

# FLEXO

A P P L I C A T I O N S

As the growth of the Flexo industry rapidly increases, MDC continues to offer more products to meet our Flexo customer's demands for a variety of quality products used everyday in the pressroom.

Achieve superior results when combining our Flexo Consumables with Doctor Blades by Daetwyler - the industry's trusted leader in precision performance and innovation.

Innovating print performance  
since 1972.



# Daetwyler

# END SEALS

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## WHITE AND GRAY FOAM

White & Gray Foam end seals are the most economical seals and are available in various hardnesses. They are used for short runs and are a good match with economical doctor blades choices such as MDC Flexolife.



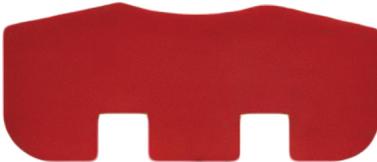
## TAN FOAM

Used most often for process work, Tan Foam end seals are designed mainly to be used with a preground/tipped doctor blade for the cleanest wipe possible.



## PRE-SOAKED FELT

Pre-soaked Felt works well with any blade type and is very durable through multiple press stops. Available in three grades, this felt works well with any blade type.



## RED DURAFOAM

Red Durafoam is durable for long runs and is designed to match the life of a premium coated doctor blade. Useful when the blade and seal life needs to be predetermined so press stops can be predicted



## RED RUBBER AND FELT COMBINATION

Used to extend blade life and designed for long life with multiple press stops. Great for ECG and match for premium coated blades with special designed tips.

## CLEANING BRUSHES FOR ROLLS



### STAINLESS STEEL BRUSH

Designed for cleaning ceramic anilox rolls, each bristle is precision refined to .003" diameter to reach into cells and break up dried ink.

### BRASS BRUSH

Designed for cleaning chrome cylinders. These plate brushes clean photopolymer and rubber plates effectively without the worry of damage.

### NYLON PLATE BRUSH

Designed for cleaning photopolymer or rubber plates and widely used throughout the printing industry, nylon brushes are non-abrasive and will not harm plates.

### HORSEHAIR PLATE BRUSH

Specifically for cleaning photopolymer and rubber plates to prevent damage. Horsehair bristles are softer than nylon bristles and are preferred for high-resolution or high-end graphics plates.

## ANILOX PROTECTION



### PRO-MAX PROTECTIVE ROLL COVERS

Keep rolls safe and clean from damage during storage and handling. These fire resistant rolls are available in various materials and are made to fit the cylinder length and diameter in accordance with customer's requirements.



### CYLINDER REPAIR KIT

Chips and dings on cylinder ends let particles enter the inking system, causing damage to the roll surface. This easy-to-apply repair putty adheres to ceramic and chrome cylinders and restores your cylinder ends to a like-new appearance.



### HOOK RARE EARTH MAGNET

Small particles circulating through the inking system can lodge behind the doctor blade and damage the roll. MDC Hook Rare Earth Magnets are field proven and are highly effective in removing particles from doctor blades, ink pump impellers, dried ink, paper dust and other debris.

### ADJUSTABLE RARE EARTH MAGNET

The same as the Hook Rare Earth Magnet but includes an adjustable bracket.



### DOCTOR BLADE SAFETY SHIELD

Protect the worker and the Doctor Blade Tip during setup, when in storage, and whenever handling! Daetwyler's Doctor Blade Safety Shield is long lasting, reusable and comes in convenient 100ft rolls.

# FLEXO PRINTING PROBLEMS

## INK SPITTING

### CAUSES:

- » Surface of the anilox does not match correctly with doctor blade tip
- » Doctor blade is too flexible
- » Doctor blade is loose in the holder
- » Doctor blade angle is not correct
- » Dried ink on cylinder ends

### SOLUTIONS:

- » Replace doctor blade with thicker blade
- » Ensure the blade tip is matched for the anilox line screen  
Check doctor blade angle to ensure holder is set parallel with the anilox roller
- » Check for dried ink on anilox ends
- » Check for damage on anilox ends

### SUGGESTED PRODUCTS:

- » MULTIBLADE
- » ONE STEP
- » PEARLSTAR

## BACK DOCTORING

### CAUSES:

- » Too much blade pressure
- » Incorrect ink viscosity
- » Containment blade is not correct

### SOLUTIONS:

- » Reduce blade pressure
- » Look for signs of extra pressure (i.e. wavy blades) and correct
- » Check ink viscosity to ensure it is within specifications
- » When using steel for both wiping and containment blades, the containment blade should be thinner than the wiping blade
- » When using plastic, containment blade should not be more rigid than the wiping blade
- » Containment blade width should be within specification of the chamber manufacturer

### SUGGESTED PRODUCTS:

- » POLYPRO
- » OPTIPRO PLUS
- » PEARLSTAR

## UNEVEN METERING

### CAUSES:

- » Wavy blades
- » Blade/chamber alignment
- » Vibration

### SOLUTIONS:

- » Clean holder and reset blade
- » Check holder for damage and repair
- » Tighten bolts from center out alternating sides
- » Replace missing bolts
- » Provide even tensioning on bolts
- » Check end seal placement and height
- » Ensure centerline of chamber is parallel to centerline of anilox
- » Make sure containment and wiping blade in chamber contact the roller at the same time without adding additional pressure
- » Check blade extension throughout entire chamber to consistency
- » Check gear box of vibration

### SUGGESTED PRODUCTS:

- » STABLEFLEX
- » MULTIBLADE

## LINES

### CAUSES:

- » Foreign particles trapped under the doctor blade
- » Nick in the doctor blade

### SOLUTIONS:

- » Reduce blade pressure
- » Install ink filters and magnets
- » Change doctor blade
- » Check anilox for damage
- » Send worn doctor blades to Daetwyler for evaluation

### SUGGESTED PRODUCTS:

- » LONGLIFE
- » STARLIFE

## ANILOX WEAR

### CAUSES:

- » Over-pressure of doctor blade
- » Doctor blade contact area to large
- » Incorrect blade material
- » Blade holder/chamber in contact with anilox roller
- » Excessive engraving recast

### SOLUTIONS:

- » Look for reasons excessive pressure is needed and correct (see uneven metering)
- » Install stops to limit over adjustment (pressure) of doctor blades
- » Use filters and magnets in ink system
- » Inspect anilox for recast on top of cell walls
- » Use correct doctor blade to match anilox line screen
- » Check new doctor blades for smoothness/roughness

### SUGGESTED PRODUCTS:

- » SOFT
- » LONGLIFE
- » STANDARD STEEL (LAMELLA)
- » FLEXOLIFE
- » MULTIBLADE

## EXCESSIVE INK FILM THICKNESS

### CAUSES:

- » Contact area of doctor blade too large
- » Anilox cell count and volume does not match doctor blade selection
- » Anilox line count and volume is too large
- » Doctor blade is not set parallel to anilox and/or set incorrectly
- » Blade pressure is too high causing blade to bend and wipe with back of blade
- » Doctor blade wears too quickly/aggressively

### SOLUTIONS:

- » Match blade tip to anilox line screen
- » Check doctor blade set up to ensure blade is set evenly across the anilox and low pressure is used
- » Look for reasons excessive pressure is needed and correct.
- » Use a longer life, coated doctor blade

### SUGGESTED PRODUCTS:

- » LONGLIFE
- » SOFT
- » STANDARD STEEL (LAMELLA)
- » MULTIBLADE
- » IBOSTAR PLUS

## LEAKING CHAMBER

### CAUSES:

- » Incorrect chamber alignment
- » Incorrect end seals
- » Wavy blades
- » Re-doctoring of ink from the containment blade (back doctoring)

### SOLUTIONS:

- » Verify chamber is parallel to anilox roller and both top and bottom blade are contacting the anilox roller at the same time
- » Check with holder manufacturer for the correct end seal specifications and material
- » Check blade settings to ensure the seal apex and blade width match

### SUGGESTED PRODUCTS:

- » OPTIPRO PLUS



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