



Tech Talk From

Prisco®

Tech Talk #C5

AQUEOUS COATING START UP PROCEDURE FOR ANILOX BLANKET COATER

An Anilox Blanket Coater is a coating unit that applies coating directly to the blanket with a single anilox roller. The metering of the coating is achieved with a doctor blade. The anilox roller is engraved with lines of cells at a specific angle (usually 60°) and of a specific depth. The anilox roller cell frequency is measured in lines per inch/cm and the depth is measured in microns. In order to determine the amount of coating that can be potentially delivered to the sheet, a formula using the lines per inch/cm and the cell volume is used to yield a result measured in total billion cubic microns. Your anilox roller supplier should be contacted to ensure that your specific anilox roller will deliver the recommended one (1) wet pound of coating per thousand square feet. Typically, an anilox roller with 180 lines per inch (70.8 lines/cm) and a cell volume of 10 will deliver the proper amount of coating to the sheet.

BLANKET PROCEDURE:

1. Use a compressible blanket.
2. Pack blanket to press manufacturer's specifications.
3. Cut the packing ¼" (6mm) smaller than the sheet size on both sides and the tail.
4. Cut the packing off sharply; do not step the blanket packing.
5. Cutting and stripping the blanket, CAD Cut Systems, or Cyrel Plates can be used to achieve spot or pattern coating.

APPLICATOR ROLLER:

1. A maximum stripe of ¼" (6mm) should be set between the anilox roller and the blanket. It is extremely important that the blanket be packed correctly.
2. Stripes wider than ¼" (6mm) may cause the unit to bounce.
3. The doctor blade on the unit should be adjusted so that only a light pressure is felt on the roller. Excessive doctor blade tightening will cause unnecessary wear of the roller and doctor blade.

BACK CYLINDER SETTING:

1. The pressure should result in a light kiss impression.
2. To determine the proper pressure, the back pressure is reduced until the coating film fails to transfer evenly to the sheet. Then the back pressure is increased in .002" (.05mm) increments until an even film of coating is achieved.
3. Too much back cylinder pressure will result in a build-up of coating on the tail end of the sheet.

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