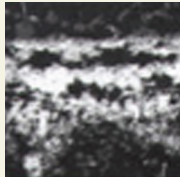
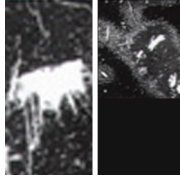
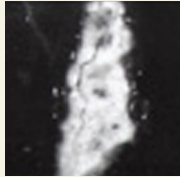
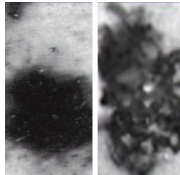
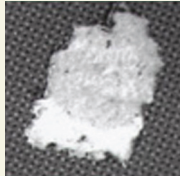


Possible Faults and Remedies/ Debris

This help guide has been produced to help identify if there is a board debris problem and to offer some possible solutions with the aim of reducing any consequences.

Problem		Possible causes	Possible remedies	Appearance
Print	Edge dust (fine debris) Fine particles in print area beginning at sheet edges, later covering all print areas	Board: Over refined fibres. Dry Board Mechanical pulp particles	Please refer to key below 1 2 4 5 9 10 11 12	
Blanket	White outlined edges, gradually moving inwards			
Tape	Concentrated fibre dust			
Print	Cutting edge fibres Fine/medium fibres covering all printed areas	Board: Bad cross cut Bad slit edge	Please refer to key below 1 2 3 4 5 6 9 11 12	
Stacks	Rough cutting edges	Printer: Grippers dusty Loose dust in machine		
Blanket	Fine/medium fibres all over			
Tape	Fine/medium debris			
Print	Coating particles Single particles, which stick on plates or blankets.	Board: Loose coating Particles	Please refer to key below 1 2 7 8 9 10 11 12	
Sheet	Loose coating particles on coated board surface.	Printer: Dirt at printing machine Ink Skin Particles from rollers Particles in rollers Grippers dusty		
Blanket	Randomly covered with disturbing elements			
Tape	Small to large non fibrous white particles			
Print	Sticky particles Single particles, which stick on plates or blankets.	Board: Sticky particles on board surface:	Please refer to key below 1 2 7 8 9 10 11 12	
Sheet	Sticky particles on coated board surface.	Printer: Dirt at printing machine Ink Skin Particles from rollers Particles in rollers Grippers dusty		
Blanket	Randomly covered with disturbing elements			
Tape	Fine to medium particles			
Print	Coating pick-out (scraper dirt) Medium to large debris as a result of coating pick outs. The fault can be seen as an indent in the printed sheet. For this some printed sheets must be leafed back.	Board: Pollution between top layer of board and coating -> low bond	Please refer to key below 1 2 7 8 9 10 11 12	
Sheet	Spots in unprinted sheets which can be scratched out	Printer: Ink too tacky		
Blanket	"Coating particles" all over			
Tape	Medium/ Large "coating particles", which are white on top and black on the reverse side			

Fault Key

1. Increase the frequency of wash-ups
2. Select pallets on production time, reel and position in the web
3. Select pallets by judging edges
4. Print with bad edge in gripper
5. Vacuuming edges and sealing edges with glycerine or similar sealing solution
6. Cutting edges by 1mm
7. Adjust/soften inks
8. Check/clean dampening water
9. Change printing sequence
10. Change (reduce) machine speed
11. Clean equipment
12. Scavenging with water on first unit and on-line or off-line sealing

Please note that without the appropriate evidence and information the board mill may not be able to take corrective actions for the next production.

For analysis the mill must have:

- Printed sheets highlighting the problem
- Unprinted sheets
- Sellotape pulls from the blanket placed onto clear acetate only
- The sheet showing the primary pick out (if it is a coating pick fault)
- Pallet labels from the relevant pallet/pallets

When expensive corrective actions have to take place the mill must be consulted.