

Autobond Matt Etch Varnish - Recommended Operating Procedures & Helpful Tips

OPP, PET, or Nylon film can be used. An ideal dyne level is around 40 or higher however, there are many variables such as the age of laminating films, temperature and humidity so we highly recommend before any job is laminated that you do your own dyne test on the actual reels of laminate that you are about to process. Despite what all manufactures indicate for their films, there is always the risk that the dyne level has been reduced. Dyne test pens are available from Graph-Pak.

Steps to perform prior to application of Autobond Matt Etch Varnish

- 1) Print normal litho sheets.
- 2) Laminate sheets with gloss laminate.
- 3) Trim 3 mm off laminated sheets to clean up angle hair.
- 4) Matt Etch varnish plates are output from pre-press using same process as the litho plates.

Autobond Matt Etch Varnish (Etch) should be run in the same manner in which standard litho inks or vanishes are run, with a few minor differences.

1. Thoroughly clean down the press from the last ink job, and then fill the ink trays with Etch.
2. Set water slightly higher than normal, at around 7.5 to 8, as the product's consistency is very sticky.
*Note - Because of the above reason, do not allow the Etch to sit in the press for too long and do not leave the Etch unattended for extended periods of time. Keep rollers on a crawl as otherwise it will have a tendency to dry up like glue. Also, use a product such as Ink Guard or another anti-skinning spray when running the Etch.
3. Wind and load sheets.
4. Start out with 8-10 clean unprinted sheets, followed by live sheets, when changing jobs from standard ink. In case any old ink is still on the rollers, it'll be printed onto these scrap sheets.
5. Run a few sheets. Press settings - Sweep at 30 and ink key settings at 40. Check for coverage on the sheet. If coverage is too thin, uncoated spots or entire uncoated areas will be visible on the print. If coverage is too thick, the sheet will feel very tacky to touch. Open or close keys to adjust flow of the Etch accordingly. Obviously, the larger the coverage area the more product that should be applied.
*Note - While checking for good coverage, also check to make sure old ink is not being printed onto the sheets. Etch has a tendency to pull ink out of the rollers if they have not been washed down very thoroughly. If there is evidence this has occurred, wash down rollers completely and repeat steps 1 through 4.
6. During step 5, check for good registration and make the necessary adjustments. Registration or getting fit - Turn unit 1 off and fit unit 2, then turn unit 2 off and fit unit 1.

FOR FURTHER INFORMATION PLEASE CONTACT OUR HEAD OFFICE



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7. While running, periodically check to make sure the Etch is not being applied too heavy by placing hand on a sample sheet to make sure it is not too tacky. If it is, reduce flow as too heavy an application will seriously inhibit drying capability.
8. On delivery, the print needs to be racked at approximately 10 cm to 20 cm intervals. For example, when running 250 gsm board, approximately 400 to 500 sheets can be stacked before inserting a rack for the next 400 to 500 sheets. When running 90 gsm paper, stack approximately 800 to 1000 sheets, then rack for the next 800 to 1000 sheets. You can use spacers and plywood to utilize the entire height of the press delivery.
9. Before banding and shipment can take place, sheets with small coverage area should take approximately 12 hrs to adequately dry. To adequately dry a large coverage area should take close to 24 hrs. The product can dry in this way by oxidation, but by utilizing IR dyers drying time can be cut in half.
10. Wash up procedure is the same as any other job. No special chemicals are used. Use wash up trays and rags. Similar to running any other ink or varnish job, try to restrict the Etch from getting in any other components of the press apart from the ink tray and rollers.

Helpful Tips

- Fill entire ink tray(s) with Etch if a large amount of coverage area is required.
- Run at slower speeds to ensure good registration - approximately 7,500 to 8,000 sph.
- Run water higher.
- Run heavier powder higher than when running ink.
- Always rack.
- Before running, make sure rollers are absolutely clean as Etch will pull out old ink from the rollers and apply it to the sheet.
- For the above reason, it is wise to build up a number of Etch jobs to run consecutively rather than switching back and forth between ink jobs and Etch jobs.
- Two coats of the etch varnish are recommended for jobs trying to offer a raised feature of varnish like in screen production for example, these two coats provide better coverage and are more forgiving on those real special effect jobs and or if a hickey shows up on one plate.
- You can check quality of the finish with an electronic device that measures the dullness.

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