

**Table I  
Control of Color Register**

**No. Print Condition**

**Press Adjustment or Cause**

1. In a pull of inspection sheets, only one sheet has misregister out of limits.	No action: may be chance effect. See No. 2
2. In each of several consecutive pulls of inspection sheets, one or more sheets has misregister out of limits.	Check press: register system. Check paper: See Nos. 4 to 12.
3. Register OK on several pulls of inspection sheets, but shows trend or drift toward limits for misregister in one or more colors.	Check press: gripper edge and side-guide register settings.
4. Consistent sidewise misregister along trailing edge; gripper edge OK. May occasionally show wrinkles.	Check paper: may have tight or wavy edges. Check press: excessive impression/blanket squeeze may stretch paper beyond elastic limit.
5. Misregister varies sheet-to-sheet, mostly in the around-the-cylinder direction and worse along the trailing edge of the sheet.	Check paper: usually due to mechanical stretch in soft, lightweight papers. Also may be due to multiple-sheeted paper or loose blanket. Check ink and blankets: may have excess tackiness.
6. Random misregister, where area of misregister is different on different sheets.	Check paper: sometimes occurs in printing heavily embossed papers. Check press: reduce impression pressure.
7. Some colors consistently longer or shorter from gripper edge to trailing edge.	Check press: blanket and packing may have compressed during pressrun, causing change in print length.
8. Consistent misregister at gripper edge or side-guide edge.	Check press: register system.
9. Random misregister at gripper edge or side-guide edge.	Check paper: edge trim may be bowed convex or concave, paper may have wavy or tight edges. Check press: press speed may be too fast for register system to function properly; check register system.
10. Misregister lengthwise along gripper edge.	Check paper: may be grain-short, moisture content too low, or pressroom humidity too high. Check press: side-guide and sheet-forwarding mechanisms.
11. Doubling in one of the colors.	Check paper: may have tight or wavy edges. Check press: sheet hold-down device, play in impression or transfer cylinders, slippage in grippers, all register devices, and blankets.
12. Register OK except for consistent misregister in one area of sheet.	Check paper: if area is on off-guide side trailing edge, check for trim and tight or wavy edges. Check plates: may have misfit that was not noticed during makeready, or large solid on an earlier-down color near the misregister area, causing paper stretch or embossing in that area. Check press: blanket delamination between face and backing.