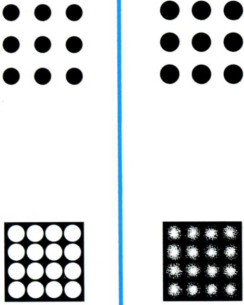



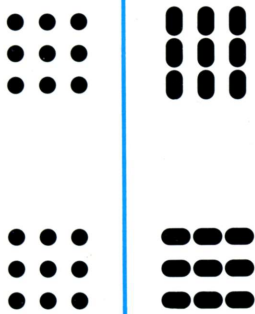







Variations in dot size and shape

2

right	wrong	Points for the pressman to remember
		<p>Dot gains can be visually controlled and dot sizes checked by control strips and measuring aids. For a merely visual check, signal strips are eminently suitable. Filling-in can be reliably controlled by means of screen test areas of high tonal value.</p> <p>Dot gain and filling-in are, in most cases, caused by an excessive ink supply, an inadequate water supply, too high a printing pressure or a rubber blanket not properly tightened. Poor adjustment of the plate inking rollers and the plate dampers may be additional causes.</p>
		<p>Under normal circumstances and with clean halftone dots on the film, the image on the press sheet will always turn out heavier than on the film. In case of imperfections such as blinding of the plate or ink piling on the rubber blanket, the image may become sharper. Remedies are: more frequent washing of the blankets and inking units, changing the colour sequence, examination of plate rollers, cylinder adjustment and the rolling action.</p>
		<p>The occurrence of slur is most strikingly signalled by single line screens. The lines arranged at right angles to one another will in many cases indicate the slur direction. Circumferential slur is in most cases due to differences in diameter between plate and blanket cylinders, or to an excessive printing pressure. For this reason, the rolling action and the printing pressure must be most carefully controlled. Frequently a poorly tightened rubber blanket, or excessive inking are the cause. When <i>lateral slur</i> takes place – which seldom occurs alone – special attention should be paid to the printing stock and to the rubber blanket.</p>
		<p>For an effective control of doubling, the pressman will examine the same press elements as he does in remedying slurring motions. In addition, he will check halftone dots through the magnifier, because the control of the single line screens alone will not indicate whether slurring or doubling occurs. Doubling may be due to many causes. The faults will, as a rule, be found in the printing stock itself, or in its immediate surroundings.</p>
		<p>Offsetting very seldom occurs on modern sheet-fed offset presses. Those sections of a sheet-fed machine where the sheet is mechanically supported on its newly printed side, are more easily susceptible to offsetting. A stiff quality of printing stock increases the offsetting risk. Offsetting may also take place in the pile and on perfectors.</p>