

MAKEREADY of a ROLAND ULTRA

four-colour offset machine

Systematic table of a proven
and suitable method
assuming two operators and
two assistants (without
uncoupling of the machine)

Operations	Parallel operations	Personnel				Time
		1st operator	2nd operator	1st assistant	2nd assistant	
Gumming the four plates Wheeling out piles from feeder and delivery		x	x	x	x	→ about 9 minutes
Removal of damping rollers Empty ink troughs, insert wash-up devices Wash ink rollers		x x x	x x x	x x x	x x x	→
Remove washing devices and clean Wash ink troughs Wash damping rollers Measure plates and mark up, prepare underlay sheets Prepare inks and reducers, etc.		x x	x	x x	x x	→
Wash plates and unclamp Get feed pile ready and set feeder Pile table to be inserted in delivery and delivery to be set Clean plate, blanket and impression cylinders Mix inks and get them ready for printing		x	x	x x x	x	→
Clamp plates in first double unit Put inks in second double unit Clamp plates in second double unit Put inks in first double unit Make rough ink knife settings to plates in all four units Insert damping rollers		x x x x	x x x x	x x x x	x x x x	→ about 45 minutes
Run trial sheets Check plate inker settings with machine running Run in the inks Put dampers on and check setting and damping Other cleaning operations Wash plates and run with ink After ten spoil sheets make check sheet		x x x x x	x x x x	x x x x	x x x x	→ about 30 minutes
Gum plates Register and make settings Improve register by plate settings Adjust damping and inking Fill water fountain and powder containers Continue with 10 spoil sheets and make further check sheet		x x x x	x x x	x x x	x x	→ about 30 minutes
Revise sheet to be checked Set sheet transfer discs on transfer drums Wash blankets Make necessary colour adjustments to inks		x	x	x x	x x	→ about 30 minutes
Run first machine sheet for run and check		x	x	x	x	→ 30-60

MAKEREADY

INK CHANGE

Ink change = 90 minutes
Makeredy = 165-195 minutes

Total time required
= 255-285 minutes
(4 1/4-4 3/4 hours)