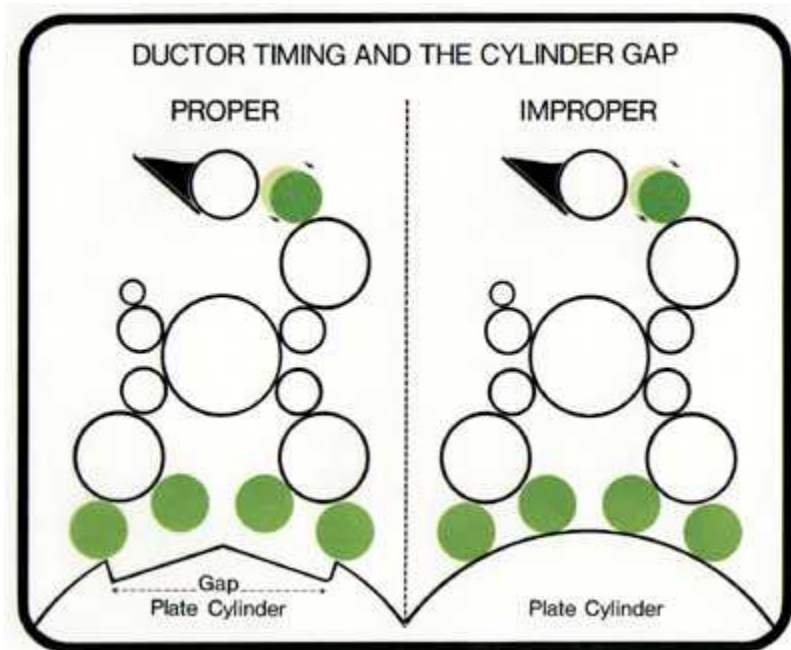


Ductor timing

- When the ductor contacts the distributor roller, it may jar the rollers causing "gear" streaks. To prevent this, the ductor should be set to contact the vibrator when the forms are above the plate cylinder gap.



Importance of using correct form-to-plate pressure

- Excessive pressure may cause the forms to "bounce" at the plate cylinder gap and skip over the lead edge of the plate without inking it.
- Rollers striking the lead edge of the plate cause **severe plate and roller wear**.
- Heavy pressure causes blurred images.
- If the form roller-to-plate pressure is greater than the form roller-to-vibrator pressure, the form rollers will skid on the plate and will cause streaking.
- If forms are set too tightly to the plate, they will act as squeegees and prevent ink from flowing onto the image.

Adjusting form-to-plate pressure

- Must be done **after** form-to-vibrator pressure is set.
- Is accomplished using different methods on different presses.
- Pressure **should always be less** than form-to-vibrator pressure.

