

Contact your Sales Representative today to take advantage of technical services, provided by Dynamic Dies, Inc.



## Impression Optimization



The Dynamic Dies Incorporated philosophy is to engineer a printing plate to meet the customer's challenge. This means meshing graphic design concept with real world manufacturing.

Process routines create repeatability that connect to reliability of performance and more speedy delivery! Box makers want and deserve the best they can buy in a time frame that meets the demand.

### Headquarters

1705 Commerce Road  
Holland, OH 43528

### Indianapolis

2321 Executive Drive  
Indianapolis, IN 46241

### Indianapolis - Digital

2801 Fortune Circle East, Suite I,  
Indianapolis, IN 46241

### Pittsburgh

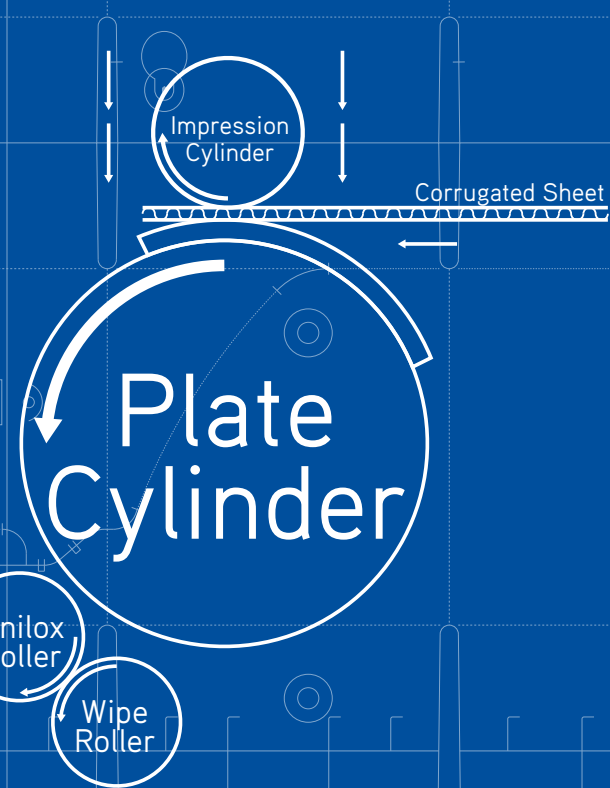
3251 Old Frankstown Road  
Building E  
Pittsburgh, PA 15239

### Middletown

1310 Hook Drive  
Middletown, Ohio 45042

419.865.0249

visit us at: [dynamicdies.com](http://dynamicdies.com)



**When printing plates are forced beyond the minimal setting needed to print a complete and uniform image:**

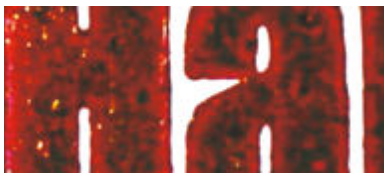
- Halos will appear around the printed copy.



- Corrugated substrates will be crushed resulting in caliper loss and a consequent loss of structural integrity.



- Positive copy will be oversized, reverse copy will be undersized.



- Registration may be off due to varied print lengths between colors that are set at different printing pressures.



**Set The IMPRESSION Roll**

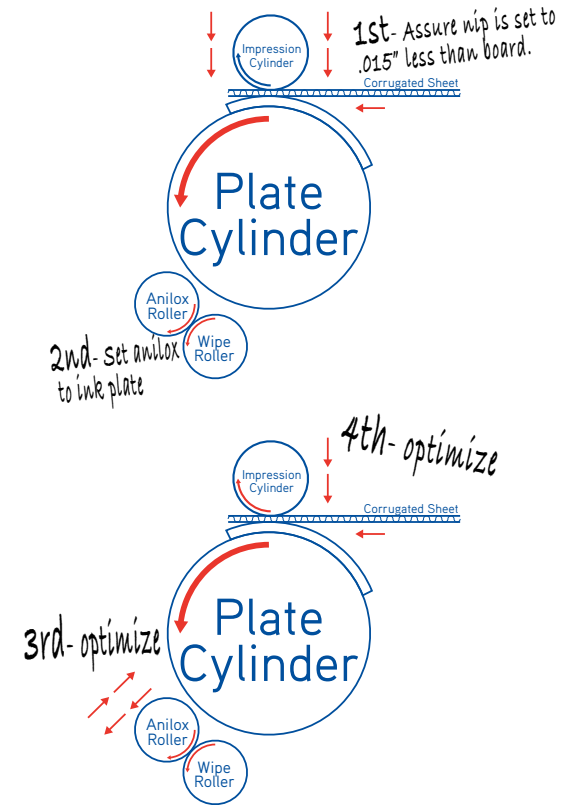
- 1) Rotate the plate cylinder to position the plate so a physical measurement can be checked between the printing plate and the impression roll.
- 2) Insert a piece of the corrugated to be printed between the printing plate and the impression roll. Have a helper close the impression gradually until the nip tightens on the paper. The objective is a nip opening of .015" - .020" less than the paper caliper. This assures good contact from the plate to the paper.
- 3) Check the actual gauge reading. If it is off make note to adjust it.

**Set The ANILOX Roll**

- 1) Set the anilox roll at zero (or where the operator normally sets it to print if the gauge is not working).
- 2) Print 3 - 5 Sheets and check the results.
- 3) If the sheets show complete print, back the anilox off .003" and print 3 - 5 more sheets.
- 4) Repeat as needed until print image "drops". Add .003" anilox back to the plates. When image comes back complete, you know your anilox roll is set at the minimum (optimum) setting.

**Back Off The Plate Impression .003"**

- 1) Print 3 - 5 sheets and check the results.
- 2) If the sheets still show complete print, back the impression off another .003" and print 3- 5 more sheets. Repeat as needed until print image "drops". Add .003" impression back to the plates. When image comes back complete, you know your impression roll is set at the minimum (optimum) setting.



Contact your Sales Rep. to schedule a Technical Rep. for a fingerprint, print trial or training.

Ask about our new plate materials and substrates!