



DOCTOR BLADES FOR
FLEXO
WIDE WEB APPLICATIONS

Doctor blade life on modern flexo presses, with their combination anilox roller/doctor blade inking systems, is of great importance. The cleanest possible wipe requires minimal doctor blade pressure to prevent excessive blade and anilox wear.

Equally important for blade life is the relationship between cell configurations (shape / count) and the blade tip thickness. Daetwyler manufactures a wide variety of doctor blades to meet your specifications and applications.

Innovating print performance
since 1972.



Daetwyler



STANDARD

This special design of our European steel is the most commonly used product for wide web applications. **Tips Available :** [Lamella](#) / [Radius](#)



BLUESTAR

This blade is made of special, heat treated steel. It is most often used in wide web applications when printing process color. The special tip design gives both stability and durability to the blade making it ideal for medium run lengths. **Tips Available :** [Multiblade](#)



SOFT

This blade is coated with a soft, corrosion-resistant nickel based material. The soft coating provides a more gentle contact point therefore reducing or eliminating the chance of anilox score lines. This coating also heals small nicks in the blade edge, reducing lines and streaking as well as steel contamination in the inks. **Tips Available :** [Lamella](#) / [Radius](#)



LONGLIFE

The doctor blade choice for fighting print defects, such as streaking. It is commonly used for abrasive inks and coatings. This hardened coating significantly lengthens blade life, therefore reduces the amount of steel contamination in the ink. Fewer blade changes are needed, resulting in reduced downtime and waste. **Tips Available :** [Lamella](#) / [Radius](#) / [Multiblade](#)



STARLIFE

This doctor blade is primarily used for very abrasive inks, primarily white containing TiO2 pigments. The hardened coating protects the doctor blade from damage and also offers a low coefficient of friction therefore reducing anilox wear. **Tips Available :** [Radius](#)



GAMUTSTAR

A new coating designed to extend blade life and reduce anilox scoring, while providing the cleanest possible wipe. This is specifically suited when blade changes need to be predetermined (such as in ECG printing). This allows the blades changes to occur at specific times, eliminating unnecessary downtime. **Tips Available :** [Radius](#) / [Lamella](#)

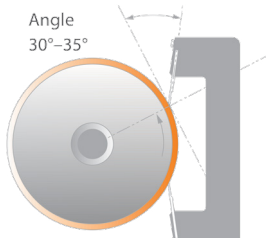
CONTAINMENT BLADES

Daetwyler offers multiple solutions for doctor blades used for containment purposes.

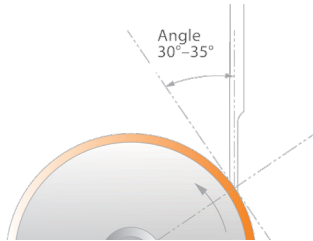
PolyPro – Available in thicknesses of .007", .015" and .020". These are the most common and cost effective containment blades.

OptiPro Plus – Often used in combination with longer lasting coated blades such as Longlife, Starlife or GamutStar. A good fit for ECG printing and also for abrasive inks and coatings

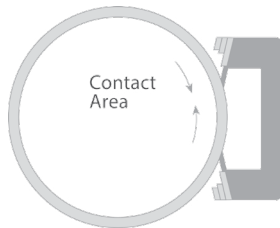
PearlStar – This blade has a proprietary coating that repels ink. This repelling property added together with low friction values make it ideal for customers experiencing back doctoring issues.



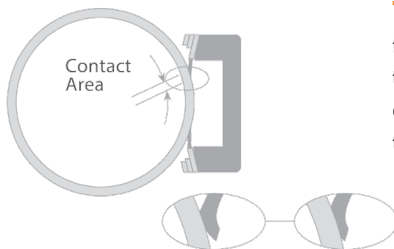
CHAMBER DOCTOR BLADE SYSTEMS There are two distinctly different blade systems; single Reverse-Angle Blade system and the more commonly used Enclosed Doctor Blade System. Angles on an enclosed system are pre-set and for single reverse-angle blade system the industry standard is approximately 30 to 35 degrees. Flat angles create greater contact area, requiring more doctor blade pressure to get a clean wipe. This increase in pressure creates excessive anilox and blade wear.



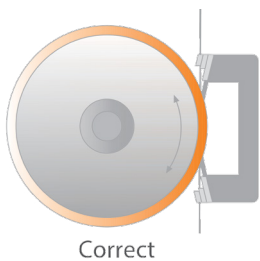
REVERSE ANGLE DOCTOR BLADES Provide excellent printing and wiping. To obtain best results, the blade holder must be cleaned carefully and be in good condition. The Doctor Blade must be mounted absolutely straight and without waves. To prevent waves, tighten bolts in the blade holder from the center out. As always, minimal pressure is the key to successful printing.



THE CORRECT PRESSURE Minimum pressure ensures consistent blade wear and extended anilox life. The thinner the tip, the less pressure required to achieve a clean and brilliant printing result. It is recommended to use the same material on both sides of the chamber to eliminate uneven pressure. Increased pressure leads to a deflection of the doctor blade, resulting in a reduced angle and therefore in an increased contact area. The actual wiping is done by the back of the blade, leading to excessive anilox and blade wear.

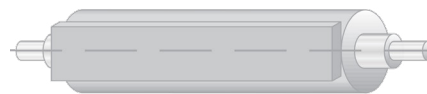
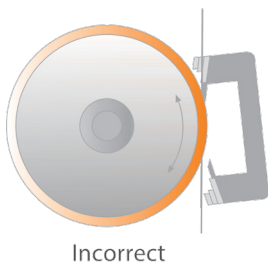


THE INCORRECT PRESSURE Or excessive blade pressure creates free floating metal slivers that contaminate ink systems. When a hard particle becomes trapped between the deflected blade tip and the anilox, this particle rides there, effectively destroying rows of cells. These rows of cells appear as thin bands running the circumference of an anilox and are commonly called score lines.



PROPER SYSTEM ALIGNMENT For consistent ink metering, best print quality and optimized blade life, an enclosed chamber system requires perfect alignment (both horizontal and vertical) so that both blades have equal amounts of pressure. Incorrect alignment creates uneven blade pressure, blade wear and/or ink leakage.

A common error that results from correcting alignment problems is excessive blade pressure. This excessive pressure will lead to a variety of previously discussed problems, like score lines.



FLEXO PRINTING PROBLEMS

INK SPITTING

CAUSES:

- » Surface of the anilox does not match correctly with doctor blade tip
- » Doctor blade is too flexible
- » Doctor blade is loose in the holder
- » Doctor blade angle is not correct
- » Dried ink on cylinder ends

SOLUTIONS:

- » Replace doctor blade with thicker blade
- » Ensure the blade tip is matched for the anilox line screen
Check doctor blade angle to ensure holder is set parallel with the anilox roller
- » Check for dried ink on anilox ends
- » Check for damage on anilox ends

SUGGESTED PRODUCTS:

- » MULTIBLADE
- » ONE STEP
- » PEARLSTAR

BACK DOCTORING

CAUSES:

- » Too much blade pressure
- » Incorrect ink viscosity
- » Containment blade is not correct

SOLUTIONS:

- » Reduce blade pressure
- » Look for signs of extra pressure (i.e. wavy blades) and correct
- » Check ink viscosity to ensure it is within specifications
- » When using steel for both wiping and containment blades, the containment blade should be thinner than the wiping blade
- » When using plastic, containment blade should not be more rigid than the wiping blade
- » Containment blade width should be within specification of the chamber manufacturer

SUGGESTED PRODUCTS:

- » POLYPRO
- » OPTIPRO PLUS
- » PEARLSTAR

UNEVEN METERING

CAUSES:

- » Wavy blades
- » Blade/chamber alignment
- » Vibration

SOLUTIONS:

- » Clean holder and reset blade
- » Check holder for damage and repair
- » Tighten bolts from center out alternating sides
- » Replace missing bolts
- » Provide even tensioning on bolts
- » Check end seal placement and height
- » Ensure centerline of chamber is parallel to centerline of anilox
- » Make sure containment and wiping blade in chamber contact the roller at the same time without adding additional pressure
- » Check blade extension throughout entire chamber to consistency
- » Check gear box of vibration

SUGGESTED PRODUCTS:

- » STABLEFLEX
- » MULTIBLADE

LINES

CAUSES:

- » Foreign particles trapped under the doctor blade
 - » Nick in the doctor blade
- ### SOLUTIONS:
- » Reduce blade pressure
 - » Install ink filters and magnets
 - » Change doctor blade
 - » Check anilox for damage
 - » Send worn doctor blades to Daetwyler for evaluation

SUGGESTED PRODUCTS:

- » LONGLIFE
- » STARLIFE

ANILOX WEAR

CAUSES:

- » Over-pressure of doctor blade
- » Doctor blade contact area to large
- » Incorrect blade material
- » Blade holder/chamber in contact with anilox roller
- » Excessive engraving recast

SOLUTIONS:

- » Look for reasons excessive pressure is needed and correct (see uneven metering)
- » Install stops to limit over adjustment (pressure) of doctor blades
- » Use filters and magnets in ink system
- » Inspect anilox for recast on top of cell walls
- » Use correct doctor blade to match anilox line screen
- » Check new doctor blades for smoothness/roughness

SUGGESTED PRODUCTS:

- » SOFT
- » LONGLIFE
- » STANDARD STEEL (LAMELLA)
- » GAMUTSTAR
- » MULTIBLADE

EXCESSIVE INK FILM THICKNESS

CAUSES:

- » Contact area of doctor blade too large
- » Anilox cell count and volume does not match doctor blade selection
- » Anilox line count and volume is too large
- » Doctor blade is not set parallel to anilox and/or set incorrectly
- » Blade pressure is too high causing blade to bend and wipe with back of blade
- » Doctor blade wears too quickly/aggressively

SOLUTIONS:

- » Match blade tip to anilox line screen
- » Check doctor blade set up to ensure blade is set evenly across the anilox and low pressure is used
- » Look for reasons excessive pressure is needed and correct.
- » Use a longer life, coated doctor blade

SUGGESTED PRODUCTS:

- » LONGLIFE
- » SOFT
- » STANDARD STEEL (LAMELLA)
- » MULTIBLADE
- » GAMUTSTAR

LEAKING CHAMBER

CAUSES:

- » Incorrect chamber alignment
- » Incorrect end seals
- » Wavy blades
- » Re-doctoring of ink from the containment blade (back doctoring)

SOLUTIONS:

- » Verify chamber is parallel to anilox roller and both top and bottom blade are contacting the anilox roller at the same time
- » Check with holder manufacturer for the correct end seal specifications and material
- » Check blade settings to ensure the seal apex and blade width match

SUGGESTED PRODUCTS:

- » OPTIPRO PLUS



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