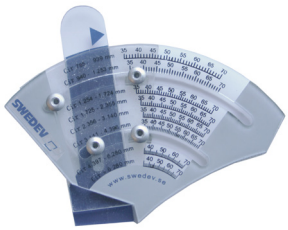
Doctor Blade Angle Gauge



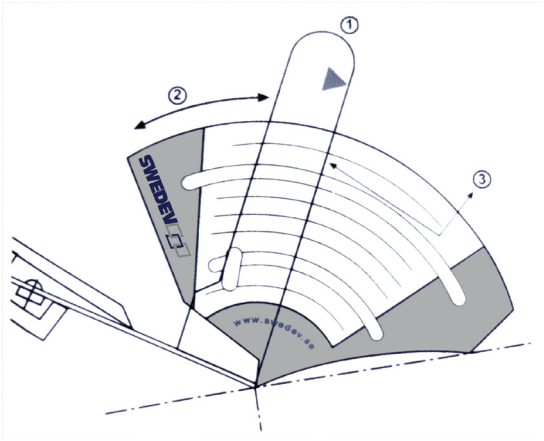
In rotogravure printing, it is important to set the doctor blade at a correct contact angle. Many printing issues like haze, streaks and drag-outs are friction- and temperature related, and setting up the contact angle incorrectly can be a disaster. When using too low an angle, the contact area between doctor blade and cylinder increases and the friction and temperature rise. An angle that's too high can give doctor blade vibration problems. It is recommendable to use a contact angle between 55-65 degrees. A correctly set doctor blade angle normally allows as well a lower doctor blade pressure.

The Swedev "Doctor Blade Angle Gauge" is the tool that helps you control contact angle setting.
It is easy to handle and in such a size that it can be kept in your pocket, quickly ready for use.
The gauge is available in two sizes; for cylinder circumferences 300-785 mm and 785-6280 mm.

How to use it:
Place the Swedev "Doctor Blade Angle Gauge" on top of the printing cylinder as shown in the figure below---with the "sharper" end at the point where the doctor blade edge touches the printing cylinder. Adjust the blue bar (1) on the gauge so that its base is fully in contact with the top side of the doctor blade/backup blade.

Remove "Doctor Blade Angle Gauge" from the cylinder but make sure the blue bar (1) is not moved from its position.

Read the degree of angle shown at the right side (arrow side) (3) of the blue bar. Read the scale matching the cylinder circumference used (2).
Now you know at what angle the doctor blade is set. But remember that an increase in doctor blade pressure will lower the contact angle due to blade flex, so it can be a good idea to set the blade angle 2-3 degrees higher than required.



SWEDEV

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