



image printing products international

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COLD FOILING - SOLUTIONS GUIDE

Problem	Possible Cause	Solution
Foil does not transfer at all	Wrong web path	Using the wet lamination method the foil must be nipped before the U.V. lamp and pass through the lamp for curing
Poor foil transfer	Not enough nip pressure Nip roller too soft Poor alignment of webs entering nip rollers	Increase pressure Use harder nip, nip roller must be over 80 durometer Adjust or change web paths
Foil transfer not even across the web	Nip roller worn or grooved	Replace nip roller
Image looks smudgy, squeezed out	Too much adhesive Web tension varies Nip roller too soft	Use a higher line screen anilox Better web tension control Nip roller must be over 80 durometer
Lines showing up across the web	Web tension inconsistent at stripping station Stripping angle not correct	Better web tension control Alter stripping angle or change stripping roller size
Fisheyes	Foil does not have good contact with the web inside the drier	Check for air bubbles between foil and the web. Increase press speed
Poor foil transfer / adhesion	UV adhesive is not fully cured	Turn up UV lamp power or slow down the press

Cracks in foil	Unwind tension too high	Reduce tension
Pinholes	Poor laydown of adhesive Gassing, caused by insufficient nip Debris on surface of plate, impression cylinder, nip roller, undernip.	Use lower line anilox or add 5% reducer Increase nip pressure or use harder nip Clean the press
Rough Edges	Print impression not sharp Adhesive build up on plate shoulders Cured too fast	Reset print impression Use higher line screen anilox Increase volume of adhesive or reduce lamp power
Poor scratch resistance	UV lamp power is too low	Turn up UV lamp or slow down the press
Foil prints in non image area's	Spitting print head Print from previous station not fully cured Dirt on Idler or nip rollers	Clean and adjust print head make sure prior printed images are cured properly Clean the rollers
Wrinkles	U.V. Drier too hot Idler rollers not properly aligned Nip roller pressure not even Poor web path	Turn down drier. Increase press speed Align Idler Rollers or bypass offending roller Adjust nip roller pressure Change web path
Print rough at edge of web	Foil is shrinking slightly	Use bearer bars

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