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| PACKAGES CONVERTORS LIMITED BU-FC | Document type Work Instructions |
| | Title Impression Roller Testing |

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| Prepared by Hassan | Approved by BUM FC | PAGE 1(1) | REV 3 | DATE 01.07.2024 | DOC NO. WILEMANIC/BUFC/7.5.2/01 |
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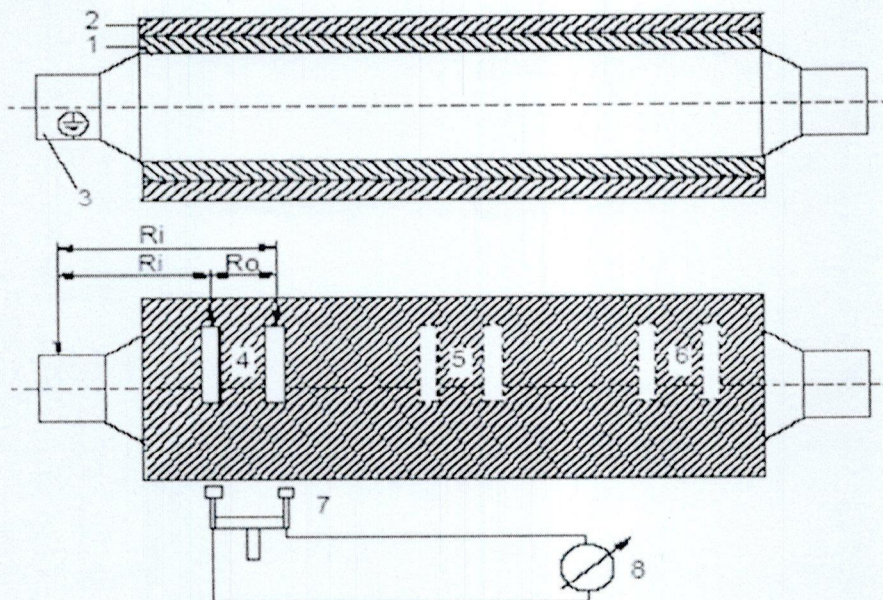
- 1. Purpose:** Guidelines to Test The Impression Roller according to Standard procedure
- 2. Scope:** Roto Line Section of BUFC
- 3. Responsibility:** Over all responsibility lies with Production Manager BUFC
- 4. Procedure:**

A.2 Measurement regulations for 2-layer impression rollers for Eltex GNH61 and GNH61P Printing Assists

Measurements are made with the Impression Roller Tester Type 6208 and the Measuring Bow Type 6230. The bow contacts of the tester must be moistened with normal tap water before every measurement. The required measurement values are given in Electrical property requirements of impression rollers (Annex A.1) and the certificate issued by the coating maker.

Fig 47:
Measuring set-up

- 1 insulator
- 2 conductive layer
- 3 grounded metal core (<10 k Ω)
- 4 measuring side A
- 5 measuring centre
- 6 measuring side B
- 7 measuring bow 6230
- 8 impression roller tester type 6208



Surface resistance R_o

Test voltage = 100 V. The test values are to be determined at operating temperature. „Operating temperature“ means that the impression roller is installed in the printing unit and exposed to a dynamic line force load of approx. 10 N/mm. The impression roller is tested after reaching its operating temperature immediately after the roller has come to rest. The time interval between printing start-up and the time the operating temperature is reached must be specified by the coating maker.

Measurements must be taken on a minimum of 3 points: side A, middle and side B; a 20% error from the mean value is permissible.

Insulation resistance R_i

Test voltage = 500 V.

The value must be maintained throughout the entire temperature range.

