

WORK INSTRUCTION FOR OPERATING SCREEN PRINTING MACHINE CP1

SN.	Instructions
1	Clean the machine and surroundings before starting the job.
2	Clean the feeder board and runner board for smooth operation and then put the mains "ON".
3	Get the production schedule from the authority & collect all the inputs like sheets, screen, squeegee, artwork and inks for the job to be printed.
4	Place the sheets on feeder board at the center with the help of alignment mark and side supporting arms.
5	Set the suckers positions as per sheet size; set the position of the stopper gauges at the sheet edges for sheets alignment.
6	Pass the sheet on runner board thru inching mode and set the position of side-lays & runners according to sheet size.
7	Mount the screen, squeegee & flood-bar on machine; set the screen carriage position to Zero.
8	Adjust the screen position to get the perfect print position of image on substrate by adjusting the screen carriage movement in X or Y direction.
9	Set the Squeegee pressure through motorized squeegee sensing function in PLC.
10	Pour the required quantity of the ink (or shade) into screen and start the machine at min speed of 900 imp/hour for setting purpose; also start the conveyor and the desired temp for drying(if required)
11	Activate the Printing stroke and take first impression on the substrate and dry the printed sheet by passing it thru the conveyor
12	Refer to the reference sample or mock-up and check quality parameters like image sharpness, registration, shades etc.
13	Get the first piece approval from authority and start the job. Ensure in-process quality check at periodic interval throughout the batch for each colour.
14	Repeat all the steps from SN 4 to SN 13 for multi-colour jobs.
15	Enter requisite details in job card and log book and inform authority.

Prepared by: Production Engineer

Approved by: Production Manager