

### PLATE GAUGES

- Standard: 0,15 - 0,30 mm.

### COATING - EXPOSURE

- Coating colour: green.
- **AL-G3 S** can be exposed with metal-halide or UV lamps that emit in the wavelength between 350 – 450 nm.
- The black density of the film should be 2.5 minimum.
- In order to determine the correct exposure time it is recommended to use scales UGRA 1982, STOUFFER or similar.
- Recommended reproduction results using UGRA 1982: Grey scale -continuous tone-: clear n° 3 -density 0,45-  
Microlines: 8 – 10 microns

### DEVELOPMENT

- **AL-G3 S** gets its optimum results working with IPAGSA positive developers.  
Developer **HF-LD** ready to use direct (autoregenerant).  
Developer **HF-C8** concentrate, use diluted **1+4** (1 part developer + 4 parts water).
- Temperature of developer: Manual: 20 - 22°C  
In processor: 20 - 25°C
- Dwell time: Manual: 45 - 60 seconds  
In processor: 20 - 30 seconds

### DEVELOPER REPLENISHMENT

- **HF-LD** is dual purpose being able to be used as a developer or replenisher Replenishment rate: 100 - 120 ml/m<sup>2</sup>
- **HF-C8** concentrate, use diluted 1+3 (1 part developer 3 parts water) Replenishment rate: 70 - 90 ml/m<sup>2</sup>

### GUMMING

- The plate should be protected with a gum designed to ensure there is no oxidation in the non image areas.
- It is advised to remove all gum before starting the print run to ensure rapid ink-water balance.
- **GUM M-31** Gum for processors. Mix 1+1 with water.
- **GUM M-3** Gum for processors. Ready to use.
- **GUM F-20** Gum for plate storage. Ready to use.
- **GUM T-10** Gum for the baking process. Ready to use.

### BAKING

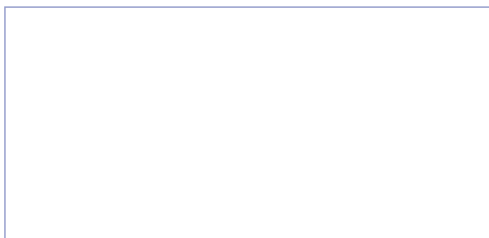
- Hardening of the image by baking will increase the press life of the plate.
- Before baking wash abundantly with water to remove any residues of deletion fluid and apply acid solution **T-660** before gumming with **GUM T-10**.
- Baking conditions: Static oven: 200 - 220°C during 6-8 minutes  
On-line oven: 230 - 250°C during 3-4 minutes
- The image will be hardened correctly when, on applying deletion gel for 4-5 minutes on the coating, the colour of the coating does not alter. If there is an appreciable alteration in the colour modify the time or temperature of the baking.

### DELETION

- Deletion pens or gel can be used to remove unwanted images on the plate.
- Apply over the area to be corrected and leave for 20-30 seconds. Remove by washing with abundant quantities of water.
- **KR-78** Deletion gel.
- IPAGSA Deletion pens are available with wide, medium, and fine points.

### ON PRESS

- **CLEANER A-610** as preparation for the background areas prior to starting the print run.
- **CLEANER S-630** for baked plates.  
Avoid systematic use, the solvent base of the cleaners could damage the image and reduce print capacity.
- Fountain solution additives IPAGSA **PH SYSTEM** are suitable for all sheet fed and web presses.  
Recommended pH range: 4,8 - 5,2.  
Recommended conductivity range: 800 - 1.500 microsiemens.



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