

# INSTRUCTION

## F-DOCTOR BLADE AND FSD-DOCTOR BLADE

### 1. Positioning

Position the FSD-holder without support blade and F-holder with support blade in the machine holder. The welded ribbon points down towards the cylinder.

### 2. Assembly

Tighten only one clamping screw in the center. Then press firmly from the center outwards from above until the holder touches the bottom reference to compensate the slight distortion caused during welding. Then tighten the remaining clamping screws from center to sides. Eventually use calibration gauge or coin for checking (exactly as wide as the overlap between machine holder and doctor blade), especially if there is no stop at the bottom.

### 3. Insertion of blade strips

Using the FSD-holder, first insert the support strip, than the blade strip. Using F-holder, insert only one blade strip. Cut off a piece of strip (a bit longer) in the length of your holder. Beginning from the right side, insert the strip over a few cm (about two inches) by hand. (Don't try to pull the strip lengthwise through the gap!) Then continue to insert it with the aid of a folded piece of

paper, a rag or our special insert tool. Guide the strip along the holder with your left hand, while firmly pressing it down. After being completely inserted, the blade strip will overlap the support strip only 1-2 mm, depending on the thickness of the blade strip.

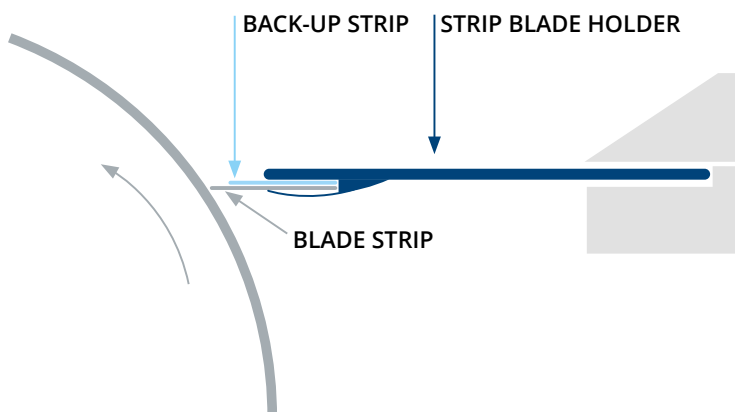
### 4. Cleaning

After printing, the complete holder with the blade strip or strips still inserted (one or more, depending on holder) is cleaned by hand in the printing machine, or taken out completely and washed in a washing machine. After that, replace the worn-out blade strip(s). The support strip can remain in the FSD-holder. If contrary to expectations any dirt or residual ink get into the clamping gap please pull our special cleaning tool through the whole length of the gap (without the strips inserted).

### Function of support strip (only FSD-holder)

The support strip has the task to prevent the FSD-holder against premature wear-out of blade strip, in particular at the cylinder ends. It should only be replaced when the FSD-holder is in risk of touching the cylinder. Blade strips more than 100 µm do not need a support strip (the gap would be too narrow for holding both strips).

**TYPE FSD** 0,5 mm



**TYPE F** 0,3 mm

