

# USING H.S. BOYD RULES

## General Guidelines

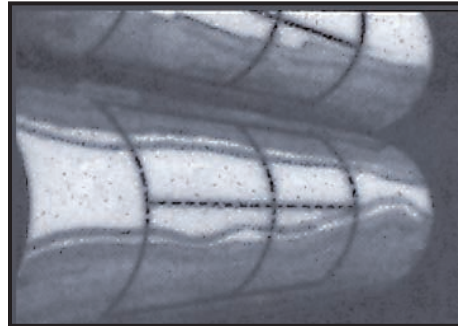
Proper preparation of the impression cylinder is essential each time a rule is to be used to insure adherence of the rule's adhesive backing to the cylinder surface. Clean the impression cylinder to remove any oil or grease and be certain the surface is dry before you apply the rule.

Although careful handling and precise machine settings will minimize damage to the blanket, many printers prefer to use an old blanket to avoid the risk of indentation during the run. When such a blanket is to be reused, always check the position of the previous job to be certain the print matter and the finishing element will not be affected. Also, keep in mind that, on longer runs, the cost of a blanket is nominal compared to the savings afforded by on-press finishing.

The guidelines for positioning the rules should be clearly placed on the plates. Check before you begin to be certain you will be able to position the rule precisely in accordance with the artwork. Also, be certain you have the appropriate type and size of rule to complete the job correctly.

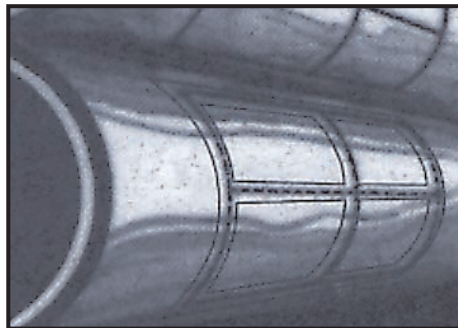
Three methods of successful application of H.S. Boyd rules have proven equally effective. Each is described and illustrated here. The method chosen should be one that saves you time while insuring proper positioning and a secure fit. Regardless of the application method you use, always remember to overlay the rule with the clear tape provided in the product package. This tape is resistant to press conditions and will not slip during the run. The working edge of the rule will cut through the tape on the first impression.

## Direct Application to Cylinder



## Ink image onto impression cylinder

In this method, you will transfer the plate image directly to the impression cylinder to serve as the guide for positioning the rules. The first step then is to ink up and run through one printing cycle without paper. When the image has been transferred to the cylinder, check to be certain the rule guidelines are clearly visible.



## Rule with tape in position over ink image on impression cylinder

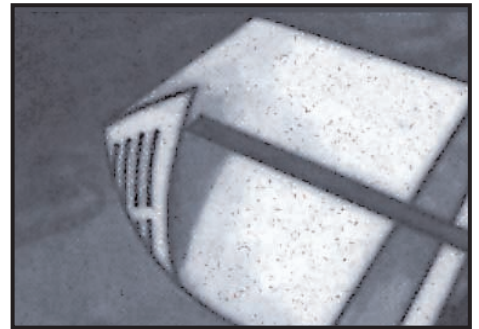
Measure and cut the rule to the designated lengths and remove the paper backing to expose the adhesive surface.

Carefully align the rule with the guidelines on the cylinder and press down firmly on the face of the rule. Add a length of clear tape over the rule blade to secure its position. You are ready now to begin the run, however, certain precautions should be included in your preparation.

Be certain that all press parts clear the rule as you set the pressure to begin. You may find it useful to run through some spoil sheets to check the accuracy of rule placement and the pressure against the printed surface.

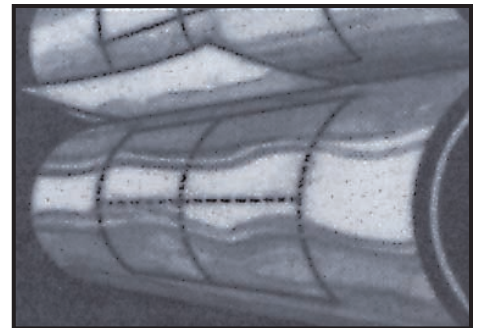
Too much or too little pressure will affect the performance of the rule. The pressure may need to be adjusted before you begin, as well as during the run.

## Application by Transfer



## Printed sheet face down on light table

This method of application utilizes a printed sheet to serve as the transfer guide. Run through one printing cycle with paper to print your guide.



## Rule sticks to the cylinder as sheet is carried through

Place the printed sheet face down on a light table or workbench, and cut the rule to the measured length.

Use a light coating of spray adhesive to affix the rule, blade down, to the back of the printed sheet.

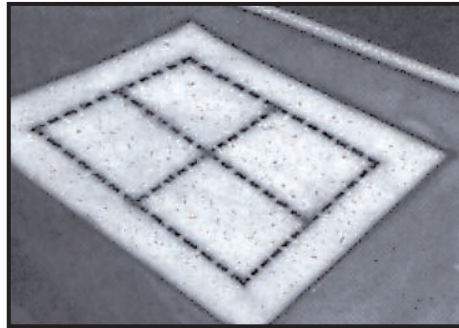
Place chipboard on both sides of the transfer sheet and, with gentle pressure, drive the rule edge into the transfer sheet. Remove the paper backing to expose the rule's adhesive surface.

Now feed the transfer sheet by hand through the press. The rule should transfer readily to the impression cylinder. If unsuccessful, repeat the procedure, using a lighter coating of spray adhesive than before. Use the clear tape to cover and stabilize the rule once it is positioned, and adjust the pressure before beginning the run so that all parts clear the rule.

### Application to Carrier Sheet

This method of application secures the rule to a carrier sheet (for example, a thin sheet of stable plastic or a printed sheet of paper) which is then secured to the impression cylinder.

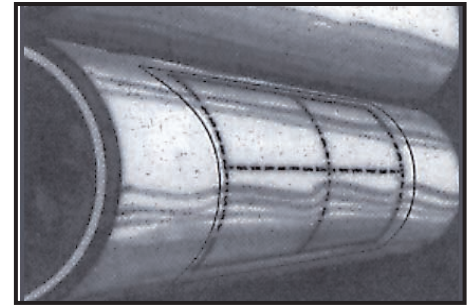
With the carrier sheet lying face up on a table, apply the rule along the guidelines, using a straight edge for exact lines. Overlay the rule with the clear tape.



**Rule with tape on the carrier sheet**

Apply a coat of spray adhesive to the impression cylinder to prepare the approximate area the carrier sheet will cover.

Place the carrier sheet in the feeder. Open the sheet detectors wide enough to allow the rule to pass through and



**Adhesive-coated carrier sheet sticks to cylinder**

roll the carrier sheet through the detectors by hand. As the carrier sheet enters the grippers, trip the grippers by hand so that the carrier sheet will stay on the cylinder. Then use a razor blade or knife and cut the carrier sheet even with the front edge of the cylinder. The carrier sheet should stay affixed to the cylinder. Check for loose edges and corners, and readjust the pressure before starting the run. Upon completion of the job, the plastic sheet may be removed and stored for future use.

## Troubleshooting and Guidelines

Problem	Possible Solution
Paper is sticking to the teeth on the perf.	Grippers need to be adjusted or replaced. Lay a piece of clear tape over the perf. Possibly apply a silicone spray to the blade teeth.
Perf is not perforating as desired.	Add pressure, or use a Special High product instead.
Perf is slitting instead of perforating the paper.	Back the pressure off, or try changing to a Special Low product, or overlay the blade with a piece of clear film tape.
Rule is not perforating at all.	Use a good, hard, 3- or 4-ply, non-compressible blanket. Check the pressure. Does this particular press have spring-loaded cylinders designed to release under pressure as a safety precaution?
Teeth are bending or breaking off.	Back off the pressure and make sure the correct height of perf for the stock is being used.
Perforation is straying from the guidelines.	Back off the pressure. Try using a good 1/2" to 3/4" masking tape to overlay the perf (especially in high-speed web operations that generate heat).
An indentation or shoulder mark in the paper is appearing adjacent to the perforated line.	Back off the pressure. Try a center-mounted blade to distribute pressure evenly to both sides of the blade.

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