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A FAMILY COMPANY

DOCTOR BLADE CHATTER VS. CORRUGATED FLUTING

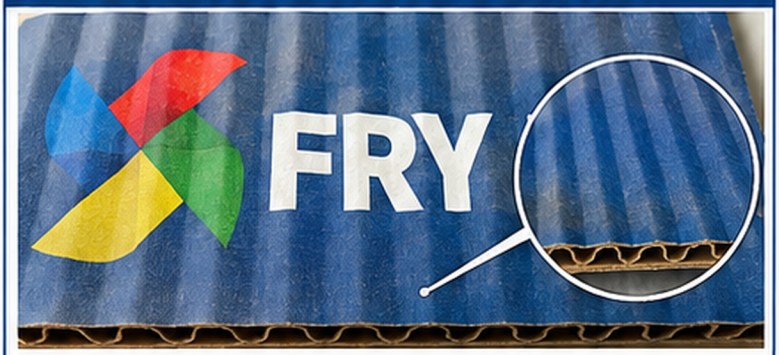
SIMILAR LOOKING DEFECTS. DIFFERENT CAUSES. DIFFERENT FIXES.

Both defects can create lines or banding in printed graphics, but they come from different sources. Diagnosing correctly helps you avoid wasted time, rework, and inconsistent color.

1. DOCTOR BLADE CHATTER

- Caused by doctor blade vibration or unstable blade contact
- Often linked to blade pressure, blade angle, worn blade, holder issues, or mechanical vibration
- Creates repeating streaks / bands and inconsistent ink transfer
- Can cause color variation, print instability, and poor graphics

2. CORRUGATED FLUTING



- Caused by the corrugated board structure showing through the print
- Related to flute profile, top sheet support, pressure, board caliper, and substrate construction
- Creates a washboard / ribbed appearance following the corrugated flutes
- Can make solids look uneven and reduce apparent print smoothness

HOW TO TELL THE DIFFERENCE

1. PATTERN
Doctor blade chatter = fine repeating line pattern. Fluting = broader ribbed pattern tied to board structure.

2. SOURCE
Doctor blade chatter = press / metering issue. Fluting = substrate / board issue.

3. FIX
Doctor blade chatter = inspect blade, holder, pressure, vibration. Fluting = review board quality, pressure, plate cushioning, print setup.

QUICK CHECKS

1. Inspect the print pattern closely
2. Check doctor blade condition and setup
3. Compare to flute direction and board structure
4. Review press pressure and ink transfer
5. Pull samples and confirm the root cause before adjusting

IMPORTANT
Misdiagnosing the defect leads to wasted adjustments. Identify whether the problem is blade chatter or corrugated fluting before making changes.

BETTER DIAGNOSIS.
BETTER COLOR.
BETTER RESULTS.

★ CHECK. COMPARE. CORRECT. EVERY TIME. ★