

SYNTHETIC STONES FOR THE FINISHING OF ROTOGRAVURE CYLINDERS

Reprochem has been producing for a considerable time abrasive stones for the finishing of roto gravure cylinders, working on copper-plated, chromium-plated and nickel-plated surfaces, as well as steel surfaces. Maximising on the experience of the "ACIGRAF" partner company which manufactures amongst others diamonding and cylinder finishing machines, Reprochem is carrying on a continuous research and development on the manufactured stones, keeping them updated according to the newest technologies present on the market.

Considering the variety of finishing machines available on the market and taking into consideration the various operating specifications of each machine, REPROCHEM produces several product lines to optimally match with the specifications required by the customers.

The production range, therefore, envisages a series of differing hardness stones, which can be best adapted to demanding work, different pressures, stones rotation speeds as well as to the different passage speeds.

Considerable working pressures (50-70 kg.), high grinder-rotation speed (500-1400 revs/minute) require harder and more compact stones in order to reach the best compromise between cut standard and grinder wear.

Low work pressures (15-30 kg.) and reduced grinder-rotation speeds (50-300 revs/minute) require softer and less compact stones to promote a better abrasive exchange and to maintain an optimal cutting standard.

To work on reduced- circumference cylinders (400-600 mm) hard stones are better suited, whereas to work on large-circumference cylinders (800-1500) a softer grinder material is more suitable.

The stones are classified by grain, based on the required action, which could be rough-grinding, intermediate finishing or finishing. The available grains are the following:

FOR COPPER POLISHING - SERIES N,T,H,K

120, 220, 240
280,400,600
800,1000
1500
2000, 3000

FOR CHROMIUM AND NICKEL POLISHING

CR3, 800 CR 1000 CR, 1500 CR

FOR STEEL WORKING

120,240



REPROCHEM S.
r.
l.
CHEMICALS FOR GRAPHIC ARTS

STONE SPECIFICATIONS:

COPPER STONES	SERIES N	STANDARD
COPPER STONES	SERIES H	HIGH CUTTING POTENTIAL (LARGE-SIZE CYLINDERS)
COPPER STONES	SERIES K	HIGH CUTTING STANDARD ALSO FOR USE IN HIGH-PRESSURE CONDITIONS
CHROMIUM STONES	SERIES N	STANDARD
CHROMIUM STONES	SERIES S	WITH BETTER CUTTING STANDARD
COPPER STONES	SERIES T	STANDARD
COPPER STONES	SERIES T SPECIAL	HIGH-CUTTING POTENTIAL
CHROMIUM STONES	SERIES T	STANDARD

COPPER AND CHROMIUM T: FOR SWIFT LATCH-ON OF THE
STONES WITH VELCRO GRINDER TO THE GRINDER-CARRIER PLATE.

DIMENSIONS:

STONE SPECIFICATIONS FOR COPPER AND CHROME:

EXTERNAL DIAMETER :	about	195 mm
INTERNAL DIAMETER	about	55 and 100 mm
HEIGHT 50 AND 70 mm	about	50 and 70 mm

STONE SPECIFICATIONS FOR STEEL :

EXTERNAL DIAMETER :	about	200 mm
INTERNAL DIAMETER	about	55 mm
HEIGHT 50 AND 70 mm	about	50 and 70 mm

GRINDER ROUGHNESS

COPPER GRAIN ROUGHNESS * R_{tm} (Rz Din)

120 for copper and steel	6.5 – 8.5
240 for copper and steel	4.2 – 5
280 for copper	4.5 – 5.2
400 for copper	2.9 – 3.5
600 for copper	1.7 – 2.5
800 for copper	1.5 – 2.4
1000 for copper	0.9 – 1.6
1500 for copper	0.7 – 1.4
2000 for copper	0.6 – 1.0
3000 for copper	0.3 – 0.8
5000 for copper	0.3 – 0.6

*ROUGHNESS OBTAINED AT 50 KG PRESSURE ON COPPER,
ACCORDING TO THE STANDARD WORKING PROCEDURE

