

USER GUIDE **rotec**[®]

For the professional handling of rotec[®] sleeves and adapters

rotec[®] sleeves and adapters are manufactured using the very latest production technologies. The materials used are subjected to constant quality control procedures carried out at our facilities. In order to utilize the product properties of rotec[®] sleeves and adapters in the most efficient manner and to increase the life time of your sleeves/adapters, you should comply with the following recommendations. In case of questions or technical problems, please contact customer service or one of our sales representatives.

Air pressure

- + The air pressure measured at the air cylinder should be within the range of 87 to **maximum 116 psi** (6 to maximum 8 bar) . **DO NOT EXCEED 116 PSI/8 BAR.**
- + The air volume flow should not fall below 25 cfm (12 L/s) to maximum 31.8 cfm (15L/s).
- + Please ensure that the air can pass freely, i.e. the air line is not pinched or damaged.
- + Unnecessarily long or branching supply lines may lead to a drastic fall in air volume.
- + The compressed air system and cylinder surfaces should be free from moisture, oils, lubricants & inks.
- + Check for blockages in the air outlet holes before each usage.
- + For all rotec[®] Atlas and ULW Adapters:

⚠ WARNING: PREVENT SERIOUS OR FATAL INJURY

Before each use of the adapter, check the airflow through the weep holes, which prevent pressure buildup in the case of an internal air leak. There are 6-8 weep holes (3-6mm wide, depending on wall thickness) on each side of the adapter on the end cap. The weep holes are marked with a line (as shown in Fig.1, below).

1. Apply air for 1 to maximal 2 seconds into 1 of the weep holes. **⚠ CAUTION: Wear eye protection during weep hole check.**
2. Check that air comes out of the other weep holes. Two people are required to simultaneously monitor weep holes on both ends.
3. If one of the weep holes is blocked (no air coming through), clear out the blocked weep hole manually or carefully with a drill (**do not exceed a depth of 2.95 inches or 75mm**). Do not enlarge the diameter of the original weep holes.
4. Repeat on the remaining weep holes (as needed) until air flows through all weep holes.
5. The weep hole markings were updated November 2022. If you have a different design or need further support, please contact your XSYS representative.
6. Stop using the adapter if air is escaping from weep holes during normal use.



Fig. 1: Weep hole marked with a line



Fig. 2: Weep hole maintenance

Cleaning and care of rotec[®] sleeves and adapters

- + Please inspect sleeves/adapters routinely for damages of the inner sleeve, the surface and notch as well as register pin of adapters before usage.
- + Damaged sleeves/adapters should not be used for printing.
- + Oil, lubricant, ink and tape residues should be removed as quickly as possible to maintain the surface properties.
- + Stronger residues can be removed with a soft nylon brush.
- + Suitable cleaning solutions are ethanol, propanol, isopropanol, or water.
- + Never use solvents containing grease or oil as they negatively affect the surface properties.
- + Never treat the sleeves/adapters with acids, alkaline solutions, and salt solutions or with any sharp objects that could damage their surface.
- + The entire surface should be cleaned with minimal amounts of cleaning solution and a clean cloth. Residual solvent should be wiped off immediately.
- + As solvents are poorly evaporating from plate/tape gaps, plates should always be demounted after use. When cleaning sleeves or printing plates while mounted, please make sure no solvent remains between the tape and sleeve.
- + Wait at least 30 minutes after cleaning sleeves/adapters to allow the solvents to evaporate completely.
- + The sleeve ends should be protected against liquids at all times.
- + To maintain good mounting characteristics, clean the inner base with an appropriate cleaner.
- + Glass fibre filaments which loosened from the inner base can be ground off. Do not pull out fibres.

Omega surface technology

- + rotec® sleeves and adapters have been developed with the Ω -Surface Technology to prevent inadmissibly high electrostatic charging when printing inks and varnishes containing solvents on flexographic presses.
- + rotec® sleeves and adapters with Ω -Surface Technology comply with BG information, status 11/2003, Order No. 452 and ATEX EU Directive No. 2014/34/EU (formerly ATEX 95), meeting the required bleeder resistance of a maximum of $10^6 \Omega$.
- + The rotec® Ω -Surface Technology enables electrostatic charges on the complete surface to be conducted.
- + The bleeder resistance should be checked each time before use.
- + The functional principle only works when the air-cylinders are grounded.
- + No liability is accepted for sleeves/adapters reworked by manufacturers other than XSYS.

Special advice for conductive rotec® sleeves/adapters with compressible surface

- + To ensure a permanent conductivity, please do not expose the sleeves/adapters to high temperatures, e.g. removing the plate with a hairdryer, hot-air-radiator or other similar equipment.
- + Do not apply isolation materials like hairspray, varnishes or other additional layers as they have a negative effect on the conductivity.
- + Do not use abrasive paper or hard brushes on the surface.

Plate mounting

- + Oil, lubricant, ink and tape residues affect the adhesion properties of the tape.
- + To apply the tape without bubbles on the sleeve, the use of a soft plastic roller is recommended.
- + The plate must be mounted bubble-free on top of the tape – a soft plastic roller is recommended.
- + Exposed surfaces of the sleeve can be protected effectively with PVC/PE adhesive tape.
- + Never apply an edge sealer directly on the sleeve – apply the edge sealer on the tape only!
- + Cutting might damage the surface, therefore please use the rotec® Cutting Ruler.
- + Adjust the tape and plate gaps by a minimum of 30° in order to avoid edge lifting of the plate.

Plate demounting

- + Remove the plate slowly and carefully with a constant tension – too much tension may damage the plate.
- + Remove the tape by slowly pulling it back from the corner at an angle and pull it off in one piece.
- + Remove any residual tape immediately (see Cleaning and Care).

Storage of rotec® sleeves and adapters

If you do not use a storage system for sleeves, please pay attention to the following points:

- + In principle, sleeves/adapters should be stored in an upright position.
- + Sleeves/adapters stored upright must be secured to prevent them toppling over.
- + Sleeves/adapters should not be stacked on top of each other.
- + Constant weight loads and stress may affect the TIR (Total Indicated Runout) of the sleeves/adapters.
- + High air humidity at higher temperatures (tropical climates) affects the service life of the sleeves/adapters.
- + Specified outer diameter is valid only at a storage temperature of 68–70 °F (20–21 °C) and 50% humidity.