



INTERNATIONAL

# METAL DECORATOR NEWSLETTER

Second Quarter, 2012  
SPECIAL CONFERENCE EDITION



## *The International Metal Decorators Association Annual Conference Was a Success*

*We are providing this issue to those members who were not able to join us at our recent conference and want to share what the attendees received at the conference. The wording has been adjusted to reflect that this is a post conference issue.*

This year, the theme of our conference related to the *Safe, Sustainable and Superior* nature of our products. Through today's innovation and improvements in technology, metal decorating overall represents all three of those qualities. By listening to the conference presentations attendees learned about the latest products and techniques that elevate metal decorating to the high standards that it is known for. After viewing this year's Excellence in Quality entries, you certainly will concur. You can view them on our website, [metaldecorators.org](http://metaldecorators.org).

At the conference, attendees received two gifts that represent sustainability. The first was the bag with the IMDA logo. You should know that this bag is constructed from recycled materials and it is intended to be used and reused, washed and used again. We hoped that attendees fill this bag up with the materials received during Wednesday's exhibits where they viewed the latest offerings from our 60 exhibitors. This exhibit was a highly valuable opportunity because it allowed attendees to get questions answered, collect brochures, meet vendors, and network with the metal decorating industry. Our second gift was a business card holder made from steel. Steel represents a wholly recyclable material which can be recycled from a can or closure into a new sheet of steel which can be introduced into the marketplace. As an industry, we have much to be proud of and our gifts served as a reminder that we represent recyclability and sustainability.

We know that the presentations are the driving force for attending our conferences, and we feel that we offered a solid line-up as a result of our collective team efforts. However, we wanted to know what attendees think and we asked them to participate in our survey compilation. These survey forms provide the critical feedback that the committee uses to create and make changes for the next year's conference. Those who submitted the forms and were rewarded with some exciting prizes which included iPad 3's and Amazon Kindle Fires. There were five sessions held over the two full days of the conference. Our Wednesday morning session kicked off our conference with our keynote on Sustainability presented by Crown's Bob Gillies discussing "metal being a permanent resource." After our entertaining motivational speaker, Keni Thomas, we celebrated our recipients of *Member of the Year, Decorators of the Year, Scholarships* and our *Quality* winners during our first ever awards luncheon. During the afternoon attendees had a choice of attending our flat sheet or two piece breakout sessions. Following our Wednesday sessions we enjoyed our Sponsor Hosted Hospitality and Exhibition. We convened on Thursday morning for another general session and we concluded the day with our increasingly popular technical tutorials. Based on what we have learned from the survey results, attendees left the conference not only having enhanced their knowledge base, but also expanded their contacts and friendships with fellow attendees.

*Your 2012 IMDA Conference Committee*



## ***President Jack Knight Proclaims our Membership Campaign is Successful to Date!***

The attendees at the IMDA's Annual Conference, like me, saw many new faces in attendance from around the globe. Attendees saw many attendees wearing a New Member ribbon. This is a result of our concentrated efforts to reach out to the world and spread the word that the International Metal Decorators Association is the premier membership to have.

Since taking over the Chair of the Presidency of the IMDA I have been traveling the world promoting the association in over 10 countries. This was just a start as I looked forward to adding China to the list in early 2012 at both AsiaCan in March, where I presented the value of membership to the audience, and just recently at Cannex. Mexico will also be in my crosshairs as I look to increase the membership in our own backyard. My goal is to increase the membership by 50% by the end of my term in 2013. In 2011, we got an early start with an increase of 8% from our involvement in AsiaCan Tech in 2011. At this meeting we inducted over 80 new members covering October's and May's Board voting to approve these members. If we keep the pace up, 50% should be obtainable.

Of course I am not doing this alone. It is through the networking and partnering with members all over the world that we will be able to meet this number together. As many of you know, I spend a great deal of time traveling in Asia for my company and I am fortunate to have made many valuable contacts with so many distinguished and enjoyable metal decorating industry personnel. In fact, it is my goal to add an International Metal Decorators Association chapter to this part of the world by the end of my term as President.

After all, we are an international organization and we need to increase our reach not only in Asia, but to other parts of the world as well.

To support our efforts to increase membership, we launched a membership drive whereby we waived the \$50.00 initiation fee for joining until June 15, 2012. This membership promotion proved successful.

If you need a membership application, you may download a form from [metaldecorators.org](http://metaldecorators.org).

I look forward to everyone's involvement making these goals realities in the coming years for the IMDA Community.

Wishing you the Best,

*Jack Knight*

IMDA President

P.S. I thought that I would share one of my experiences. Last year I visited Kian Joo in Kula Lumpur Batu Caves in Malaysia where I saw many years of IMDA awards in their waiting room. And this message board:

(Deepavali marks the beginning of the Hindu New Year according to the Lunar Calendar. It literally means "Row of Lights" and celebrates the victory of Goodness over Evil and Light over Darkness. It ushers in the New Year.)



**MEMBERSHIP NEWS**

**2012 SCHOLARSHIPS**

**WE ARE PLEASED TO ANNOUNCE THE RECIPIENTS OF OUR IMDA SCHOLARSHIPS.**

<b>LAURA KARASZEWSKI</b>	<b>2,000.00</b>
<b>MAURA LACEY</b>	<b>2,000.00</b>
<b>BRITTANY MOON</b>	<b>1,000.00</b>
<b>ETHAN KNIGHT</b>	<b>1,000.00</b>
<b>JOHN WINTERS</b>	<b>500.00</b>
<b>BRETT LACEY</b>	<b>500.00</b>
<b>LINDSAY FRIEDMAN</b>	<b>500.00</b>

**SCHOLARSHIP CHECKS WILL BE MADE PAYABLE TO THEIR RESPECTIVE SCHOOLS AND MAILED OUT IN JULY. CONGRATULATIONS TO OUR RECIPIENTS!**

**HOT FROM THE OVEN**

**DUES**

The 2012 membership dues invoices were mailed in February. Some members have not yet submitted payment, we ask that you do so soon. We will be sending out reminder notices in June as a follow-up for those who have forgotten or misplaced their dues. We thank you for your continued support.

**WEBSITE**

***Have You Been There?***

Our website has been updated to include previous newsletters, our membership directory, quality winners and convention presentations. However, to see that information, you have to go to the Members Area of the website. Members in good standing can log on to that section and request access to see all of the member's information. We will authorize your access and notify you that you are ready to view the contents. Frankly, many of you have not done so and are missing out on a member benefit.

Many of this year's presentations will be posted on the site upon the completion of the conference. But, again, you have to be a paid up member to gain access. If your dues are unpaid, you will be given a notice that your access will be denied until paid. If you have any difficulty in obtaining access to the site, contact Michael Masenior at [ampmgt@aol.com](mailto:ampmgt@aol.com) or 410-252-5205 and he will make sure that your questions get answered.

visit [metaldecorators.org](http://metaldecorators.org)

**2012 OFFICERS & DIRECTORS**

**President**

Jack Knight, INX International Ink Co

**Vice President**

Janelle Harris, Ball Corporation

**Secretary Treasurer**

Mark Von Bokel, SGS International

**Executive Director**

Michael Masenior

**Directors**

James Andamasaris, Select Metal Litho

Russell Cannon, Crown Cork & Seal

Jim Cation, Rexam Beverage

Rick Clendenning, INX International Ink Co

Craig Eberts, First Transitions

Renee Etiopio, INX International Ink Co.

Joe Finan, INX International Ink Co.

Mark Finch, Silgan Containers

Eugene Furey, Honorary Member

Nick Hammer, Ball Corporation

William Graue, Silgan Closures

Dr. William Hoyle, Hoyle Consulting

Kyle Hurla, INX International Ink Co.

Art Hurley, Silgan

James Lore, Watson Standard

Kenneth Matyska, Retired

T.R. Moreau, Can Corporation of America

Ted Nevins, J.L. Clark

Mark Novotny, Nordson Corp

Neal Santangelo, Crown Cork & Seal

Allan Sayers, Sayers Publishing

Gary Silke, Honorary Member

Michael Yavorski, Valspar Corporation



(Left to right) Mark Von Bokel, Secretary Treasurer, Janelle Harris, V.P. & Committee Chair, Jack Knight, President, and Michael Masenior, Executive Director

## **The IMDA MATTERS**

This issue of the newsletter was an abbreviated issue for distribution at the conference and a more thorough version will be mailed to members in our third quarter issue. We will showcase all of the award winners, provide presentation copy, and inform you on the latest association developments. We will include photographs from the conference, golf outing, award ceremony and our Excellence in Quality Award Winners. We will also post a full color version on our website in the Members section. However, you may obtain presentations and photographs by visiting our website.

Once more, for those members who have not yet requested access to our Members section of the website [metaldecorators.org](http://metaldecorators.org), we urge you to do so soon as we will have the presentations posted and photos of our conference for you to enjoy as well. If you need assistance in getting to the members section, please email [ampmgt@aol.com](mailto:ampmgt@aol.com) and we'll review the steps with you.

### **2012 Annual Conference & Scholarship Golf Committee Members**

A hearty thank you is extended to this year's Conference Committee for their valuable time and energy expended to deliver this year's agenda. Please thank our committee member's; they would appreciate hearing from you.

Janelle Harris, Chairperson	Ball Corp	Joe Kwain	Honorary Member
Jim Cation	Rexam	James Lore	Watson Standard
Paul Chenier	Grace	Carl Martel	Coral
Buzz Detrick	Finzer Roller	Angel Martinez	Amro Supply
Craig Eberts	First Transitions	Mike Masenior	Ameripro
Renee Etiopio	INX International Ink Co	Mike Matteson	Valspar Corp
Joe Finan	INX International Ink Co	Ken Matyska	INX International Ink Co
Mark Finch	Silgan Containers	TR Moreau	Can Corporation
John Friedman	Northern Containers	Ted Nevins	J.L. Clark
Gene Furey	Honorary Member	Mark Novotny	Nordson
Bill Graue	Silgan Closures	Joerg Pfuetzner	Technical Office
John Greenwald	Honorary Member	Bryan Pugh	Grace
Nick Hammer	Ball Corp	Aamir Rizvi	Aamir Metal
Bill Hoyle	Hoyle Consulting	Jeffrey Robinson	ES&T
Kyle Hurla	INX International Ink Co	Neal Santangelo	Crown Cork & Seal
Art Hurley	Silgan Closures	Gary Silke	Consultant
Greg Imhoff	IMDA Member	Steve Steerman	Ball Corp
Jack Knight	INX International Ink Co	Mani Subramanian	Grace
		Mark Von Bokel	SGS International

### **Meet Your IMDA Secretary /Treasurer Mark Von Bokel**



I would like to take this opportunity to introduce myself to those who do not know me. I joined the IMDA in 1995 after attending the convention in Portland, OR. I was elected to the Board of Directors in 2005 after serving a number of years on the conference planning committee, initially in the two piece section and then moving to the general session in 2010. Along with my current officer duties, I am also on the conference planning committee, Quality Awards Committee and am the Chairperson of the Website Committee.

My current employment position is Vice President, Sales & Technical Supporting Metal Decorating for Southern Graphic Systems. I began my career as a 2 piece press operator with Metal Container in 1979.

Back then, we made cans at 800 cans per minute and thought we were lightening fast. I continued my career with Metal Container for 31 years holding positions in operations, engineering, quality and 9 years as the Graphics Manager. Throughout my career, I have had a focus on the improvement of can decoration, which is evident by winning an IMDA quality award each of my last 4 years as a can printer.

I consider it a great honor to represent the IMDA; since joining, I have been extremely impressed with the level of professionalism, knowledge and camaraderie within the organization. If any of you have ideas on how we can improve the IMDA, please do not hesitate to talk with me or email me at [mark.vonbokel@spgintl.com](mailto:mark.vonbokel@spgintl.com). It is a constant focus of our Board of Directors to improve the organization from the input we receive from our membership.

Thanks again for the opportunity to represent such a fine Organization!

# MEMBERSHIP NEWS

## DecoDates

September 27-28, 2012

### The Canmaker Summit

Hilton Tokyo Bay  
Tokyo, Japan  
Tel: 44 1293 435100  
E: info@sayers-publishing.com  
www.spgevents.com

November 7-9, 2012

### Latin Can

Hyatt Regency  
Weston, Florida  
Worldcanconferences.com

May 21, 2013

### IMDA Scholarship Golf Outing

Hilton Indian Lakes Resort  
Bloomington, IL USA  
Tel: 410-252-5205  
E: ampmgt@aol.com  
metaldecorators.org

May 22-23, 2013

### IMDA Annual Convention

Hilton Indian Lakes Resort  
Bloomington, IL USA  
Tel: 410 252 5205  
E: ampmgt@aol.com



## The IMDA has a facebook page and we want you to like us.

The page name is facebook.com/metaldecorators  
We are posting activities on our wall, industry tidbits, and fun stuff. We also have a tab for discussions among industry members. Watch for pictures from this conference to be posted soon.  
We are receiving many visits to the page. However, we need more friends to share with: Our goal is 100 by Fall.  
Take a look! We're on the book!

## The Value of IMDA Membership

When new applicants asked for some of the benefits of membership in IMDA we provided our list of the top 10. Here they are.

1. The ability to seek and receive technical assistance through communications with headquarters, and networking
2. Reduced Seminar fees
3. Scholarships only for members and family members
4. A membership directory for industry contacts
5. Assistance with job searches
6. Assistance with supply, material, and service provider sourcing
7. Assistance with equipment sourcing
8. Access to Member only bulletin board on website
9. Access to conference presentations on website
10. Membership provides conferences and opportunities to communicate with peers on technical, environmental and management information

## When is an email not an email?

The answer is simple, when it doesn't reach your inbox. If you have an email address and are not receiving our regular "Enewsletter blasts," and updates from the association, we do not have your correct address. If you would like to be included on IMDA email messages, the ONLY way to add your email address to the list is to send it to ampmgt@aol.com and to our Eblaster, Past President Joe Finan at metaldecorators@earthlink.net.



## MEMBERSHIP STATISTICS

(as of 5-14-11)

<b>MEMBERS</b>	<b>5 6 5</b>
<b>HONORARY</b>	<b>3 5</b>
<b>PRIVILEGED</b>	<b>2 1</b>
<b>TOTAL</b>	<b>6 2 1</b>
<b>COUNTRIES</b>	<b>3 0</b>

## EMPLOYMENT ASSISTANCE

We have several members who are unemployed and are looking for positions in the industry. With valuable years of experience in flat sheet decorating management and sales capacities, these individuals may be able to help your organization. Contact Executive Director Michael Masenior at our headquarters 410-252-5250 to receive contact information. All inquiries will remain confidential. We are serving as a networking source only and wish to help fellow members in their



We welcome the following new members who were voted into the IMDA in October, 2011 and May, 2012

First	Last	Company	Country
<b>October, 2011</b>			
Mike	Baker	Spartanics	USA
Matthew	Dudas	Eastman Chemical	USA
Michael	Grady	Illinois State University	USA
Cindy	Hope	ISRA Vision	USA
David	Lewis	Ball Corporation	USA
Donatas	Ramanauskas	INX International Ink Co.	USA
Carlos	Zamacona Ruiz	Grupo Zapata	MEXICO
Gerry	Russell	"CMC Kuhnke, Inc"	USA
Jacek	Schloemer	Ball Corporation	USA
Amit	Shah	INX International Ink Co.	USA
Jesse	Timmins	W.R. Grace	USA
John	Wagg	"CMC Kuhnke, Inc"	USA
Chong	Louis Wah	Kian Joo Can Factory	MALAYSIA
Lee	Wah	Kian Joo Can Factory	MALAYSIA
<b>May, 2012</b>			
Joseph	Atwell	Ball Corporation	USA
Jay	Avrett	Dixie Graphics	USA
Mike	Bartley	Miltec UV	USA
Kochavee	Bavornwattanakorn	Pattanakit Global Thailand Co	THAILAND
Paul	Beard	Ball Corporation	USA
Marty	Bilderback	Cobra Color & Technologies	USA
Eric	Bildstein	AkzoNobel Packaging Coatings	USA
Andrew	Capozzi	PPG Industries	USA
Lewis J.	Connor	Stolle Europe	UNITED KINGDOM
James	Cozier	Carnaud Metalbox	UNITED KINGDOM
Mark	Crouch	Ball Corporation	USA
Mark E.	Dimmock	Dantex	UNITED KINGDOM
Justin J.	Eppler	PPG Industries	USA
Catie	Filkins	Kemeny Overseas Product Corp	USA
Kevin	Folk	Anheuser-Busch	USA
Maynard	Freer	JAX/Exact Fluid Solutions	USA
David	Grant	Watson Standard	USA
John	Griffiths	Miltec UV	USA
Ronnie	Hankins	Ball Corporation	USA
John C.	Harrison	Roeslein & Associates Inc	USA
Jennifer	Hausman	Metal Container Corporation	USA
Stephen L.	Higginson	Stolle Europe	UNITED KINGDOM
Kristi	Holmes	Ball Corporation	USA
Tadaharu	Hoshikawa	Fuji Kikai Kogyo Co. Ltd	JAPAN



First	Last	Company	Country
Glen J.	Huey	Ball Corporation	USA
Takehiko	Iguchi	Fuji Kikai Kogyo Co. Ltd	JAPAN
Cheryl	Johnson	X-Rite Pantone	USA
Kent	Jones	Ball Corporation	USA
Markus	Jung-Diefenbach	Blechwarenfabrik Limburg	GERMANY
Craig A.	Kauffman	SACMI USA	USA
Brian	Keefe	Watson Standard	USA
James D.	Lloyd	Ardagh Metal Packaging USA	USA
Roger Chi-Sing	Lo	Ball Asia Pacific Ltd	SAR CHINA
Burt	Marchman	Valspar Inc	USA
Gerald J.	Masters	Valspar Inc	CANADA
Barbara Ann	Mayfield	Miltec UV	USA
Hope C.	McFall	Ball Corporation	USA
Timothy B.	McGlinchy	GED Integrated Solutions	USA
Timothy	McKeon	KBA North America	USA
Kevin	McLaughlin	Flexo Concepts	USA
Dhara	Metla	The Dow Chemical Co.	USA
Kirkland	Miller	Crown Americas LLC	USA
Rene' P.	Niehues	Ball Corporation	USA
Gene	Pawula	Rexam Beverage Can Co	USA
Andy	Pott	Arc Pacific Ltd	USA
Dr. Doug	Rasic	Ubis (Asia) Plc	THAILAND
Craig M.	Ressler	J.L. Clark	USA
John M.	Riemer	JAX/Exact Fluid Solutions	USA
Michael	Ruben	Schekolin AG	LIECHTENSTEIN
John	Saalwachter	Ball Corporation	USA
Dhiren	Sanghani	Splash Graphics	USA
Christopher	Schult	Grace Darex	USA
Mark	Selepack	Golden Aluminum	USA
Richard	Shenowski	Bway Corporation	USA
Tony	Tavares	Grace	USA
Michael	Tolliver	J.L. Clark	USA
Steve	Turnbull	INX International UK Ltd	UNITED KINGDOM
Somasundram	TVSL Subramaniam	Kian Joo Group of Companies	MALAYSIA
Thomas A.	Van Kuren	IMDA Member	USA
Mary	Van Vonderen	MEGTEC Systems	USA
Michael	Walton	Jamestown Coatings	USA
David	Watson	Jarden Home Brands	USA
Barbara	Wester	Ball Metal Foods	USA
Dennis L.	Wilcox	Southern Graphic Systems	USA
David	Williams	Ball Corporation	USA
Karen	Winkler	The Dow Chemical Co.	USA
Jinghang	Wu	The Dow Chemical Co.	USA

# **The Continuing *Ask the Ductor, M.D.* (metal decorator) Series**

***Following is our next technical clinic provided by Dr. Deco***

## **Reading the Can – Defect Diagnosis with Dr. Deco**

This article will help you to understand defects visible on the can and translate that visual inspection into an exact adjustment on the decorator. There is no substitution for years of experience on the decorator, but I have seen even experienced decorator operators benefit from onsite training and insight. This article alone is not going to tell you exactly what adjustments are needed to control quality, but it will begin to point you in the right direction and suggest ideas you might not have considered.

But before we discuss how to diagnose the problem, let's talk about the best way to quickly detect and address quality problems: regularly following a basic quality routine.

### **Basic Quality Routine**

The following are basic quality control tasks that should be part of your regular routine. If you neglect any of these for long, you stand a very good chance of seeing a poor quality can. Although decorators hold their adjustments for quite a long time, they do not hold their adjustments forever.

1. Every 2 minutes, look at the deco quality coming off the decorator.
2. Every 5 minutes, stir the ink in the ink fountains and add ink as needed.
3. Every hour, pull a can for every mandrel in sequential order from the end of the pin oven. For the typical 24-mandrel machine, pull 24 cans, one from each mandrel.
  - a. Check for defects.
    - If the defect is 1 out of 24, you probably have a mandrel problem.
    - If the defect is 1 out of 12, it might be a blanket problem.
    - If the defect is 24 out of 24, check parts that are common to all cans (plate, inker, etc.)
  - b. Check varnish coverage using the method available to you (E-coat, cupric sulphate, etc.)
  - c. Check bottom varnish (if applicable).
4. Every hour, use a certified target can approved by the quality department to compare the colors off the decorator to the target can.
5. Every hour, save 2 sample cans off the back of the pin oven. These 2 sample cans could come from the 24-can check. Taking them off the end of the pin oven gives you a dry sample. Place them in a rack next to the hourly samples from the last 12 hours of production. Compare cans for color conformance over time.
6. Twice per shift, check overvarnish weights and the viscosity of the overvarnish.

Once again, if you neglect any of these quality checks in your quality routine, you are guaranteed to see problems eventually. It is easy to become complacent in the quality routine, but being vigilant and attentive will pay off in the end.

A good quality routine is an essential start, but that won't diagnose your defects for you. I've seen plants that have the highly skilled mechanics and the equipment to implement a quality routine and resolve quality problems, but lack the proper training to troubleshoot and quickly correcting the quality issue. So what knowledge and insight were we able to give them to interpret the defects and make the right adjustments on the decorator? Next, let's look at some common defects and possible causes.

### **Defect Diagnosis**

The fun part about defect diagnosis is that each machine and environment is different. From troubleshooting decorators in many different facilities, I can tell you that only someone on-site will be able to determine for certain the exact cause on your particular machine. If you work through the suggestions below and can't solve the problem, consider calling an experienced consultant to get the issued solved quickly and maintain quality.

**Light Deco** – The most common cause is that the fountain is out of ink or low on ink. Another cause could be that the ink is too stiff and isn't flowing down to the fountain roll. Adjust fountain keys if needed, to allow more ink to flow to the fountain roll. You might need to adjust inker rolls or print pressure, as well.

**Dark Deco** – Check the fountain blades. If they are open too much, the ink will build up and drip down through the inker rolls.

**Poor registration** – First, check the print plates to see if they are mounted properly on the plate cylinders. In addition, you may also need to make registration adjustments to the plate cylinder, so that the plates are aligned color to color, left to right, and top to bottom. Also, check the plate to blanket pressure—poor registration could be a result of too much pressure. Pressure adjustments must be made based on trial and error. If these items check out and you are still having registration problems, you may have a defective plate or simply the wrong plate, which can occur during a label change.

**Deco Voids** – Begin by looking at plate pressure, ink pressure, and ink transfer. Then start looking for something foreign on the plates preventing the ink from transferring. Deco voids can be caused by a cut in one or more of the blankets. Also, check to ensure that your printing plate is not missing any characters, or that your washer is not throwing water spots onto the can. If there are any impurities on the can, prior to the print process, the ink will not adhere to it and that will cause a void. These impurities could come from or be anything, including oil, water vapor, loose particles, etc. In addition, these types of particles could inadvertently come into contact with the decorator and plates.

**Pin dents** – These can be caused by issues with the pin chain—either it is too close to the can, or the pin chain to vacuum transfer disc is out of time. Stop the machine and bring both the pin chain and the decorator into sequence by moving the bull gear. If the pin chain is not the problem, the vacuum release could be set improperly. It might be pulling the can away or dropping it too soon.

**Open-end damage** – Marring from the infeed guides or the upstream process could result in open-end damage. The type of damage helps to determine if the cause is the infeed or upstream process. A void in the print, which might resemble damage caused by a cut blanket, suggests a loading problem causing infeed damage. Infeed guides can cause damage because there tends to be a lot of contamination in that area, which is 9 times out of 10 a combination of misting and aluminum oxide. Also, the pin chain could be out of time.

**Ink Smears** – If you have inadequate overvarnish coverage, ink smears can result. Also, something could be coming into contact with the can while it is still wet. Sometimes the Decorator builds up a reject pile to the point that it hits every can that runs by. When you see ink smears, start looking for something that should not be there. Then check your overvarnish thickness. If the overvarnish is too thin, it will actually pull the ink away. You need enough varnish on there to coat the ink without removing the ink.

**No print** – This can be a result of running out of ink or having the plate pressure set too low. Another cause of no print is that the decorator sensor indicates that a can is present when there is no can. Look for a damaged can that failed to blow off, a tripped out carriage, a broken sensor, or a tripped out (off or non-print position) form roll. It's possible a damaged can or a trim ring gets stuck and lodged on the can mandrel and stays in the area where the sensor tells it to be, or it stops a can from loading all the way. These types of problems cause the machine to move into and out of print position for every can it does not see, and the machine can be asked to adjust too often, too quickly. Two cans in a row may cause no problem, but Decorators, especially older machines, do not respond well to adjusting in and out of print position at the rate of "one off, one on."

**Overvarnish voids** – First, check to ensure that the gravure roll, applicator roll, and metering roll are set up perfectly parallel to each other. The thickness of the overvarnish is metered by having the parallelism be exact. If overvarnish builds up on one side, it tends to sling and mist, and becomes very tacky and sticky. Next, confirm that the application roll is not cut or otherwise damaged. Another possible cause could be a malfunctioning sticky mandrel. If the mandrel gets enough build-up, it starts dragging and not turning at the correct rate. Use your number counts (discussed in the Basic Quality Routine) to determine if your problem is with a mandrel: if the problem is 1 can out of 24, it is likely to be a mandrel problem.

**No overvarnish** –As in overvarnish voids, check to ensure that the gravure roll is arranged perfectly parallel and functioning properly, and that the pressure is correct. No overvarnish can also be caused by a broken or malfunctioning pump or low applicator roll. If it's low, it means you're starting to lose adjustment. An applicator roll can also be on the lowest end of the acceptable spectrum, but temperature changes (even the temperature difference caused simply by running the machine) can change the diameter enough to move it out of the acceptable range.

**Dirty Overvarnish** –If the film weight is too low, ink will come off the can and then soil the tank, resulting in a dirty overvarnish. To determine this, look for when the varnish in the tank starts changing colors or when off-colored cans appear. Another possible cause, especially with mostly silver-colored cans such as diet soda cans, is a buildup of aluminum oxide in the tank.

Learning to diagnose can defects on a Decorator in combination with a basic quality check routine is a good start. But even better than finding and fixing the cause of a defect is preventing it from happening in the first place. The best way to prevent defects from occurring is by instituting a preventative maintenance plan and a daily maintenance routine. This is what Dr. Deco will discuss in the next article.

• Dr. Deco, a.k.a. Rick Justiniano of Beckon Worldwide, draws on 30 years of can manufacturing experience to teach and consult on issues of quality control, decorator operation, and production. The Beckon team also provides decorator service, repair, and training tailored to your needs. He can be reached at +1 314 965 0755 or Dr.Deco@BeckonWorldwide.com.

## DID YOU KNOW ?

**That:** Americans earn nearly \$1 billion a year from recycling aluminum cans, yet nearly another \$1 billion worth of aluminum cans are tossed into landfills according to the Aluminum Association. European countries fare much better in their recycling rate and some countries exceed 90% such as Belgium, Sweden, and Germany. Aluminum cans are 26% of the global beverage container market.

**That:** Steel is the World's Most Recycled Material; More than all other materials combined. 83% of steel is recycled. Steel cans have the highest recycling rate of any food package at 66%. The amazing metallurgical properties of steel allow it to be recycled continually with no degradation in performance and from one product to another. Sources of Steel scrap are classified into 3 main categories: Home scrap, prompt scrap and obsolete scrap. Home scrap is produced within the steel mill, Prompt scrap is that produced from manufacturing products from steel and Obsolete scrap is produced from steel products at the end of their life cycle.

**That:** Heinz is bringing back its canned baked beans after an absence of several decades. Per a Heinz spokesman, they believe that it is time to bring back this "convenient, nutritious, and value-oriented classic."

**That:** Visiongain, a European independent media company, projects that the metal packaging market will reach \$114 billion in 2012 due to emerging market growth. They published The Metal Packaging Market 2012-2022 report.

**That:** Chromatic Technologies Inc, the specialized inks company whose products are seen on packages around the world, are now showing their true colors on the beverages from Hiball Energy. The cold activated 16 oz cans replaced 10 oz bottles and encourage the retailers to stock the product cold.

**That:** Craft Beers packaged in cans is on an explosive path. Visit [craftcans.com](http://craftcans.com) to see what is happening. As of this writing there are 450 craft beers brewed in 67 styles at 150 breweries in 41 states.

**That:** Canned foods count toward dietary goals: Only 46% of Americans surveyed realize that canned foods count toward the U.S. Department of Agriculture's dietary recommendation goals. The new MyPlate food icon issued by the USDA provides guidance on how Americans should fill their plate for more healthful eating. Canned foods are among the recommended ways that consumers can ensure they are getting a proper balance of nutrients. We need to continue to get the word out that canned foods are in fact nutritious.

### Do You Know: What Color Is?

**Color** is the perception that allows us to distinguish between different objects in a scene or image. It is the result of interaction of light, matter and the retina of the human eye. Objects are observed to have varying colors because they reflect different amounts of power at different wavelengths. Color is a three dimensional quantity, comprised of three independent aspects of color perception. These are often referred to as *Hue*, *Saturation*, and *Luminance*.

**Hue** is that aspect of color that allows us to give it a "name". Hues are generally associated with the colors of the rainbow: blue, green, yellow, orange or red.

**Saturation** is that aspect of color that describes its purity. Colors of low saturation are contaminated with white, or the neutral hue. For example, pink is a desaturated version of red.

**Luminance** is that aspect of color that allows us to differentiate between black (low luminance or darkness) and white (high luminance or brightness).



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# 16th Annual EXCELLENCE IN QUALITY COMPETITION



This Year's Excellence in Quality Competition was one of the best on record. With over 130 entries presented, we will see some of the best craftsmanship this industry has to offer. We will be announcing this year's award winners during our Awards Luncheon on Wednesday. Following this year's conference, we will be publicizing the results in major industry magazines and we will be generating the first ever Excellence in Quality showcase of metal decorating brochure for distribution to promote the graphic capabilities that metal decorating has to offer.

This is the first year where we conducted a no entry fee showcase and we would not be able to provide that opportunity, to present crystal awards and fund the upcoming promotional material if it were not for our Sponsorship. We thank the below listed companies for your support not only in a financial way, but for believing that there is value in recognizing those metal decorating companies who participated. All of them are Winners! You will agree when you see the quality of workmanship submitted.

## Gold Level



## Silver Level



## Bronze Level





## 2012 Annual Conference Sponsors

The International Metal Decorators Association is grateful to the following companies for their generous support. Without their participation in our conference sponsorship program, we could not present the quality seminars and networking opportunities which we have been able to provide our conference attendees.

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