flexoclean®
Better cleaning, better printing



ANILOX TROUBLESHOOTING

TROUBLESHOOTING GUIDE

Every problem has a pattern. Every pattern has a solution.

Recognise what you see on the anilox roll, understand the cause and apply the right cleaning step. Seven common problems, each with a clear next step.

SPOTS · CALCIUM · STARCH · ALUMINIUM · TIGER STRIPES · SCORE LINES · CORROSION

CLEANSOLUTIONSGROUP.EU

HOW TO USE THIS GUIDE

SEVEN PROBLEMS.
ONE WAY TO READ THEM.

Every problem follows the same order: what you see, why it happens and what to do. Where cleaning helps, the next page shows the product and the steps.

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MONITOR
Contamination. Cleanable with the right product and method.

ACT NOW
Risk of physical damage. Find the cause before you clean.

NOT CLEANABLE
Permanent damage. Take the roll out of production and contact us.

*Packaging and labels in pictures may differ from delivered products.

PROBLEM 01

TIGER STRIPES

Scoring lines and peripheral scratches

01

MONITOR ACT NOW NOT CLEANABLE

Risk of physical damage. Find the cause before you clean.



Cleaned sections stand out against areas that still hold contamination.

WHAT YOU SEE

Fine, parallel lines or scratches across the roll surface, most visible under angled light or in areas with heavy ink coverage.

WHY IT HAPPENS

Contact between the doctor blade and the anilox roll, caused by blade pressure, misalignment or trapped debris. Resins, paper dust and binders can produce the same pattern.

WHAT TO DO

Clean the affected area manually to remove the remaining build-up. Then check the roll for physical damage. Visible damage? Consider repair or refurbishment.

Anilox After Care, step by step

Next page →

PROBLEM 01 · TREATMENT

TIGER STRIPES

Manual cleaning with Anilox After Care

01

PRODUCT TO USE



FLEXOCLEAN

Anilox After Care

Special cleaner for hard-to-remove limescale stains and streaks. Use with the Power Sponge (art. no. 87301).

Included in the Flexoclean Clean Kit

HOW TO APPLY

1. Apply Anilox After Care to the affected area and rub it in with the Power Sponge.
2. Leave it to work for 10 to 15 minutes, then treat the roll again with the sponge.
3. Rinse thoroughly with clean water.
4. Dry the surface with a clean, dry cloth.

Always wear PPE. Not for non-anodised aluminium, zinc or galvanised parts; test rubber rolls first.

RESULT



After targeted manual cleaning

Visible improvement after targeted manual cleaning. Lines that remain point to physical damage rather than contamination.

TIP

Stripes keep coming back? Check blade alignment, blade wear and press settings. Prevention matters as much as cleaning.

*Packaging and labels in pictures may differ from delivered products.

PROBLEM 02

SPOTS

02

Contamination spots on the anilox roll surface

MONITOR ACT NOW NOT CLEANABLE

Contamination. Cleanable with the right product and method.



Diffuse light spots: residue that reduces cell volume.

WHAT YOU SEE

Irregular, cloudy or hazy patches on the anilox surface that vary in size and shape. Use angled light or a close inspection to find them.

WHY IT HAPPENS

Build-up of dried ink, coating residue or crystallised cleaning product inside the cells or on the roll surface. Often the result of insufficient rinsing or an ineffective daily clean.

WHAT TO DO

Perform additional manual cleaning using a suitable cleaner and sponge to remove stubborn residue. Inspect the roll visually afterwards.

Anilox After Care, step by step

Next page →

PROBLEM 02 · TREATMENT

SPOTS

Manual cleaning with Anilox After Care

02

PRODUCT TO USE



FLEXOCLEAN

Anilox After Care

Or a compatible cleaner for your ink type. Use with the Power Sponge (art. no. 87301).

Included in the Flexoclean Clean Kit

HOW TO APPLY

1. Apply the cleaner directly to the contaminated area.
2. Leave it to work, then scrub again in circular motions.
3. Rinse thoroughly with water.

Always wear personal protective equipment (PPE).

RESULT



After manual cleaning

After manual cleaning the surface looks smooth and even. Spots remain? Repeat the process or contact our technical support.

TIP

Rinse thoroughly every day and use soft water where possible. That keeps new spots from forming.

*Packaging and labels in pictures may differ from delivered products.

PROBLEM 03

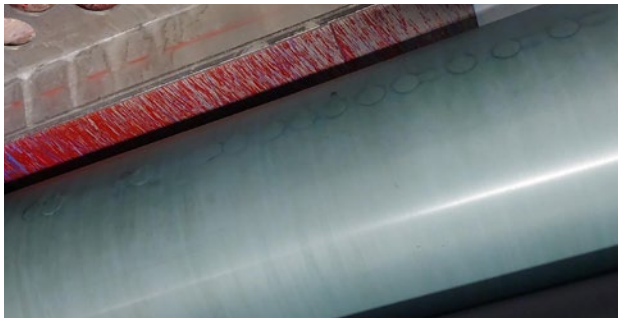
CALCIUM

03

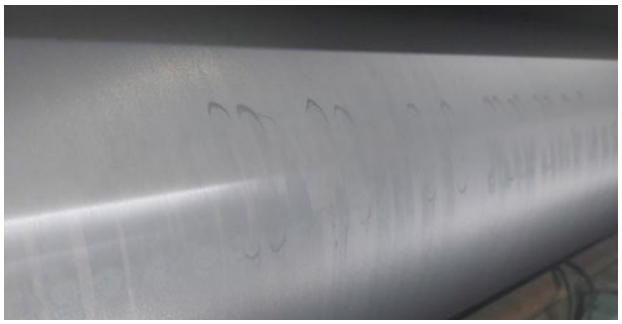
Deposits from hard water or ink components.

MONITOR ACT NOW NOT CLEANABLE

Contamination. Cleanable with the right product and method.



Close up of the deposits



Chalky drops in horizontal lines

WHAT YOU SEE

Round, chalky drops in horizontal lines across the roll. The deposits block cells and disrupt ink flow.

WHY IT HAPPENS

Calcium from hard water, ink components or insufficient rinsing after cleaning. Chemical reactions between cleaning agents and mineral residue can add to it.

WHAT TO DO

Clean manually with a product that dissolves mineral deposits.

Anilox After Care, step by step

Next page →

PROBLEM 03 · TREATMENT

CALCIUM

Manual cleaning with Anilox After Care

03

PRODUCT TO USE



FLEXOCLEAN

Anilox After Care or Limescale Buster

Or Limescale Buster for stubborn limescale on ceramic anilox rolls. Use with the Power Sponge (art. no. 87301).

Included in the Flexoclean Clean Kit

HOW TO APPLY

1. Apply a small amount directly to the affected area.
2. Scrub gently with a sponge or pad, in circular or horizontal strokes.
3. Rinse thoroughly with clean water.

Always wear personal protective equipment (PPE).

RESULT



During treatment



After manual cleaning

The deposits visibly dissolve and the surface turns uniform again. Persistent build-up points to water quality or cleaning frequency: repeat the process or contact our technical support.

TIP

Use softened water and rinse thoroughly after every cleaning cycle.

*Packaging and labels in pictures may differ from delivered products.

PROBLEM 04

STARCH

Build-up from starch glue and coated paper or board

04

MONITOR ACT NOW NOT CLEANABLE

Contamination. Cleanable with the right product and method.



Starch build-up on the roll surface

WHAT YOU SEE

A dull, tough layer on the roll surface that reduces cell volume.

WHY IT HAPPENS

Starch glue and coated substrates such as corrugated board or paper. It builds up over time through insufficient rinsing or drying, or long exposure during production runs.

WHAT TO DO

Starch on the anilox roll? Ask your Flexoclean troubleshooter for the right cleaner. Starch on glue rolls: clean manually with Starch Buster. Then keep rinsing and drying consistent.

Starch Buster for glue rolls

Next page →

PROBLEM 04 · TREATMENT

STARCH

Manual cleaning with Starch Buster

04

PRODUCT TO USE



FLEXOCLEAN

Starch Buster

For glue rolls in corrugators contaminated with starch-based adhesives. Not for anilox rolls. Use with a brush or the Power Sponge (art. no. 87301).

HOW TO APPLY

1. Apply Starch Buster undiluted to the glue roll.
2. Leave it to soak for 5 to 10 minutes, then scrub again with a brush or sponge.
3. Rinse with water, preferably under high pressure, and dry with a dry cloth.

Always wear personal protective equipment (PPE).

RESULT



After cleaning

Severe build-up may need a second treatment.

TIP

Light manual cleaning between periodic cleans keeps starch from accumulating.

*Packaging and labels in pictures may differ from delivered products.

PROBLEM 05

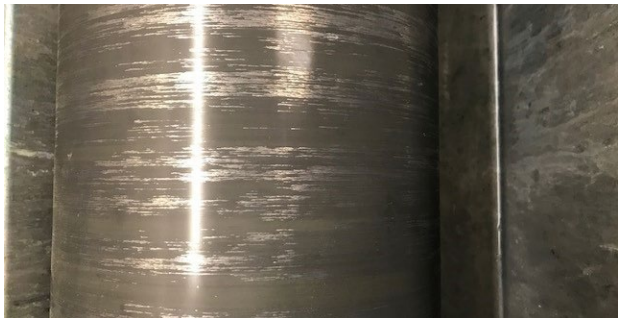
ALUMINIUM

Residue or oxidation from aluminium particles

05

MONITOR ACT NOW NOT CLEANABLE

Contamination. Cleanable with the right product and method.



Greyish smears and metallic sheen



Discolouration in contact areas

WHAT YOU SEE

Dull, greyish smears or a metallic sheen. Sometimes discolouration or staining, mainly where contact or friction is high.

WHY IT HAPPENS

Aluminium from mechanical parts, substrates or friction with metal components. Inadequate rinsing or incompatible cleaning agents add to it.

WHAT TO DO

Clean manually with an aluminium remover. Inspect the roll and nearby components for sources of aluminium contact.

Alu Remover, step by step

Next page →

PROBLEM 05 · TREATMENT

ALUMINIUM

Manual cleaning with Alu Remover

05

PRODUCT TO USE



FLEXOCLEAN

Alu Remover

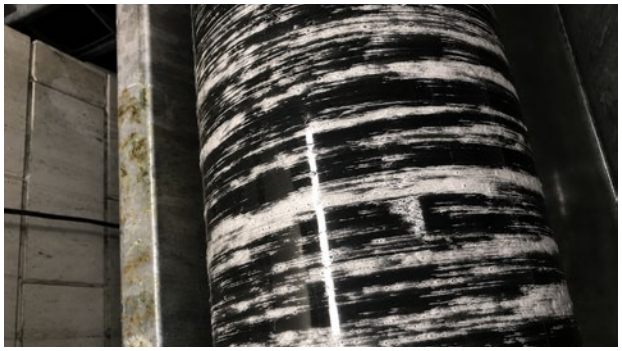
Removes aluminium stuck in the cells of the anilox roll. Use with the supplied Power Sponge.

HOW TO APPLY

1. Spray Alu Remover onto the roll and onto the Power Sponge.
2. Rub it in and leave it to work for up to 10 minutes. Keep applying fresh product until the foaming stops.
3. Rinse with clean water or use the machine's rinse program, then dry the roll.

Always wear personal protective equipment (PPE).

RESULT



Chemical reaction during cleaning



Result after cleaning

Keep the roll wet with product until you rinse. Severe build-up may need a second treatment.

TIP

Inspect metal components regularly and keep them correctly aligned.

*Packaging and labels in pictures may differ from delivered products.

PROBLEM 06

DOCTOR BLADE STRIPES

06

Score lines

MONITOR **ACT NOW** NOT CLEANABLE

Risk of physical damage. Find the cause before you clean.



Fine linear marks on the roll



The effect on solid areas in print

WHAT YOU SEE

Thin, parallel lines or streaks running across the print or the anilox roll.

WHY IT HAPPENS

1. Worn or damaged doctor blades.
2. Dried ink or hard residue stuck behind the blade.
3. Uneven blade pressure or alignment.

WHAT TO DO AND WHAT TO USE

Replace the doctor blade as soon as wear shows. Clean the blade and chamber thoroughly with the right daily cleaner to remove dried ink and coating residue. That restores smooth ink transfer and removes streaks caused by contamination behind the blade.

Which daily cleaner fits your situation? Ask your Flexoclean troubleshooter.

PROBLEM 07

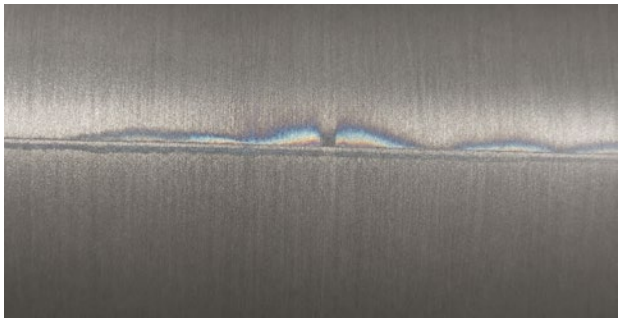
(UNDER) CORROSION

07

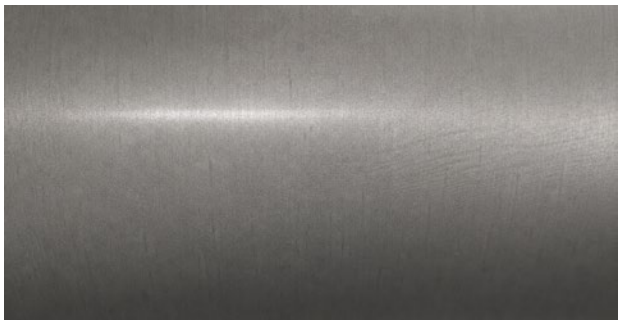
Corrosion under the ceramic layer

MONITOR ACT NOW **NOT CLEANABLE**

Permanent damage. Take the roll out of production and contact us.



Butterfly shape: dark core, lighter wings



Pitted zone on the roll surface

WHAT YOU SEE

Dull, rough or pitted areas, often butterfly shaped: a dark core with a lighter area around it. These are small cracks in the ceramic, permanent damage rather than surface contamination.

WHY IT HAPPENS

Prolonged exposure to ink, moisture or chemical residue. Poor rinsing, harsh cleaners or long machine stops with product left on the roll.

WHAT TO DO

Corrosion is permanent damage that cleaning cannot repair. Take the roll out of production and ask your Flexoclean troubleshooter for an assessment.

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NEED MORE INFO?

GET IN TOUCH

Every ink is different, so the right cleaner depends on your ink and process. Contact your Flexoclean troubleshooter for advice, product information, technical data sheets and orders.

E-mail customerservice@cleansolutionsgroup.eu

Website cleansolutionsgroup.eu/packaging-print

Phone +31 (0)162 576 222

GO TO THE WEBSITE

FLEXOCLEAN CLEAN KIT

KEEP THE SOLUTION AT HAND

Three purpose-built cleaners and Power Sponges in one kit, ready at the press when a problem shows. Anilox Power Boost for heavily dried ink and reduced cell capacity. Anilox After Care for persistent spots, limescale and tiger stripes. Starch Buster for glue rolls contaminated with starch-based adhesives.

SCAN TO ORDER YOUR CLEAN KIT →