भारतीय मानक
Indian Standard

IS/ISO 12636 : 2018

(Superseding IS 15141 : 2002/
ISO 12636 : 1998)

ग्राफ़िक प्रौद्योगिकी — ऑफसेट प्रिंटिंग के लिए ब्लैंकेट्स

(पहला पुनरीक्षण)

Graphic Technology — Blankets for Offset Printing

(First Revision)

ICS 37.100.10

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NATIONAL FOREWORD

This Indian Standard (First Revision) which is identical with ISO 12636 : 2018 Graphic technology — Blankets for offset printing‘ issued by the International Organization for Standardization was adopted by the Bureau of Indian Standards on recommendation of the Printing Machinery Sectional Committee and approval of the Mechanical Engineering Division Council.

This standard shall supersede IS 15141 : 2002/ISO 12636 : 1998 — ‘Graphic technology — Blankets for offset printing’.

The blanket is an essential part of every offset printing press. Its properties exert a profound influence on the mechanical conditions within the press and the visual characteristics of the prints produced. It is, therefore, useful to provide test methods, unified data, and tolerances for some essential properties of the blankets. This permits the suppliers to state properties of blanket types in a unified and well known manner. It also helps the printer to select the appropriate blanket type for a particular press type or press condition. A further benefit is that the design of printing presses can be based on blanket data resulting from unified test methods.

The text of ISO Standard has been approved as suitable for publication as an Indian Standard without deviations. Certain terminologies and conventions are, however, not identical to those used in Indian Standards. Attention is particularly drawn to the following:

a) Wherever the words ‘International Standard’ appear, referring to this Standard, they should be read as ‘Indian Standard’.

b) Comma (,) has been used as a decimal marker, while in Indian Standards, the current practice is to use a point (.) as the decimal marker.

In this adopted standard, reference appears to the following International Standard for which Indian Standard also exists. The corresponding Indian Standard, which is to be substituted in its place, is listed below along with its degree of equivalence for the edition indicated.

International Standard	*Corresponding Indian Standard*	*Degree of Equivalent*
ISO 4287 Geometrical Product specifications (GPS) — Surface texture: Profile method — Terms, definitions and surface texture parameters	IS 15262 : 2002/ISO 4287 : 1997 Geometrical product specifications (GPS) — Surface texture: Profile method — Terms, definitions and surface texture parameters	Identical with ISO 4287 : 1997

The standard also makes a reference of BIS Certification marking of product. Details of which are given in National Annex A.

In this adopted standard, reference appears to certain International Standards where the measurement conditions to be observed are stipulated which are not applicable to tropical/subtropical countries. The applicable standard atmospheric conditions for Indian conditions are 27 ± 2°C and 65 ± 5 percent and shall be observed while using this standard.

For the purpose of deciding whether a particular requirement of this standard is complied with the final value, observed or calculated, expressing the result of a test or analysis shall be rounded off in accordance with IS 2 : 1960 ‘Rules for rounding off numerical values (*revised*)’. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Introduction

The blanket is an essential part of every offset printing press. Its properties exert a profound influence on the mechanical conditions within the press and the visual characteristics of the prints produced. It is therefore useful to provide test methods, unified data, and tolerances for some essential properties of the blankets. This permits the suppliers to state properties of blanket types in a standardized and universally understood manner. It also helps the printer to select the appropriate blanket type for a particular press type or press condition. A further benefit is that the design of printing presses can be based on blanket data resulting from unified test methods.

Indian Standard

GRAPHIC TECHNOLOGY — BLANKETS FOR OFFSET PRINTING

(First Revision)

1 Scope

This document defines vocabulary and specifies test methods, characteristics, ordering and labelling information for blankets for offset printing. This document does not apply to un-tensioned or unclamped blankets for offset printing, nor offset printing sleeves used on gapless presses.

2 Normative references

There are no normative references in this document.

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at http://www.electropedia.org/

3.1
across cylinder direction
direction of the side of the *blanket* (3.4) as intended to be applied perpendicular to the direction of rotation

3.2
around-the-cylinder direction
direction of the side of the *blanket* (3.4) as intended to be applied in the direction of the rotation

3.3
average thickness
mean of thickness measurements

3.4
blanket
composite body, consisting of coated carrier material, e.g. fabric, used for transfer of the printing ink from the form onto the material to be printed on, e.g. for offset printing

3.5
load at specific deflection
average stress of a *blanket* (3.4) under compressive force

Note 1 to entry: It is expressed in kPa.

3.6
compressibility–deflection
average thickness reduction of a *blanket* (3.4) measured under a specific pressure

Note 1 to entry: It is expressed in millimetres.

3.7
compressibility–indentation
average depth of impression, I, in a *blanket* (3.4) measured under a specific pressure

Note 1 to entry: It is expressed in millimetres or as percentage indentation, I_p.

3.8
elongation
increase of the dimension in the *around-the-cylinder direction* (3.2) of a *blanket* (3.4) under longitudinal stress

Note 1 to entry: It is expressed in percentage of the length at a specified force per width.

3.9
packing
underlay material placed under the *blanket* (3.4)

3.10
printing surface
side of the *blanket* (3.4) that is used for the transfer of printing ink

3.11
shrinkage
decrease in thickness due to mechanical forces and decrease in all dimensions due to exposure of the blanket printing surface to a liquid

Note 1 to entry: It is expressed as a percentage of the original blanket thickness, or as an absolute thickness decrease in millimetres.

3.12
sizes
dimensions (thickness, width and length) of a cut ready-to-use *blanket* (3.4)

3.13
swelling
increase in thickness due to exposure of the blanket printing surface to a liquid

Note 1 to entry: It is expressed as a percentage of the original blanket thickness or as an absolute thickness increase in millimetres.

3.14
tensile strength
force per unit width required for breaking a *blanket* (3.4) under longitudinal stress in the *around-the-cylinder direction* (3.2)

3.15
thickness variation
difference between the greatest and the smallest thickness value in millimetres

3.16
surface texture
average roughness of blanket surface, R_a

Note 1 to entry: It is expressed in micrometres.

4 Requirements

4.1 Information

The compatibility of the blankets to either conventional, dual use or ultraviolet (UV) inks shall be documented.

The overall hardness and the microhardness are not specified in this document. They are the choice of the manufacturer. If the manufacturer provides such information, the test method shall also be documented and mentioned with the results.

The printing surface material formulation and surface texture are the choice of the manufacturer and may be stated in technical descriptions by the supplier. The surface texture may vary, e.g. cast (moulded) or ground (buffed). No specification for surface texture is given in this document. The measurement method is based on 5.8. The use of data to market products is the choice of the manufacturer.

The nominal (mean) thickness shall be stated in technical descriptions when ordered.

Compressibility information should be given to the user and the test method shall be indicated.

When testing the compatibility of blanket washes and an offset printing blanket, it is the option of the blanket manufacturer to report the test results using the test method according to 5.9 for each property.

On the non-printing side of the cut-to-size blanket, the following should be reported:

a) blanket dimensions (average actual thickness, width and length) indicating which dimension is the around-the-cylinder direction. If the recorded thickness is nominal, it shall be stated;

b) the batch control number;

c) the name of the manufacturer or the supplier and the blanket brand or trade name.

4.2 Dimension

4.2.1 Thickness

The test method according to 5.2 shall be used. For applications with packing, the nominal thickness should be 1,68 mm or 1,95 mm. For applications without packing, the nominal thickness should be agreed upon between the supplier and the user of the product.

The thickness variations of blankets with an area not in excess of 1,5 m^2 shall be less than ±0,02 mm. Those of greater sizes shall be less than ±0,03 mm. No individual thickness measurement shall yield a value which deviates more than 0,05 mm from the ordered thickness.

4.2.2 Mean thickness

Mean thickness is an average of four measurements of a cut blanket where the measurements have been made on the points indicated in Figure 1, namely on two diagonally opposed corners and one each at the middle of the two sides that are perpendicular to each other within a right triangle.

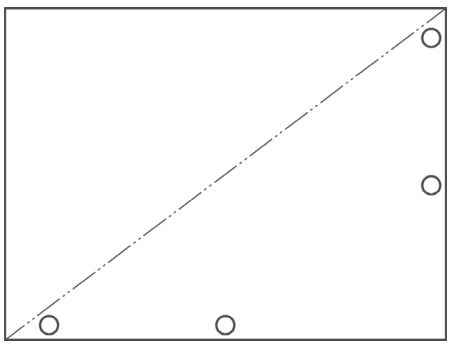


Figure 1 — Thickness measurement points

4.2.3 Accuracy of width and length

If one of the sides is 1 m or less, the tolerance shall be ±3 mm; otherwise, it shall be ±4 mm.

4.2.4 Plan view

The sides of the blanket shall form right angles. The difference between the length of the diagonals and the length of any two parallel sides shall not exceed 0,5 %.

4.3 Elongation

The elongation, *E*, shall be less than 1,5 %. The test method according to 5.3 shall be used or any other method where results can be correlated to those of the test method defined in 5.3.

4.4 Tensile strength

For all blankets with a thickness of 1,68 mm or more, the tensile strength shall be greater than 40 N/mm. The test method according to 5.4 shall be used or any other method where results can be correlated to those of the test method defined in 5.4. For blankets of lower thickness, no specification is given.

4.5 Compressibility

No specification is given. The test method according to either 5.6 or 5.7 shall be used. Alternatively, load at specific deflection (the test method according to 5.5) may be used.

4.6 Thickness change

4.6.1 Swelling and/or shrinkage due to printing ink component

The thickness change, ΔT, due to exposure to printing ink ingredients, shall not exceed 4 % maximum swelling or 2 % maximum shrinkage. The test method according to 5.9 shall be used for each property.

NOTE The blanket printing surface is typically designed for use with specific ink types. For example, UV blankets are designed for use with UV-cured inks.

4.6.2 Swelling and/or shrinkage due to blanket washes

Blanket washes should be tested for compatibility with the blanket according to the test method given in 5.9.

NOTE The choice of a proper wash is a difficult decision due to efficiency versus safety and environmental needs.

4.7 Cut blanket markings

The method and format for marking is the choice of the manufacturer.

5 Test methods

5.1 General

The testing environment should be (23 ± 2) °C. Relative humidity is (50 ± 5) % Rh.

5.2 Thickness

Place the blanket between two parallel flat circular disks of 100 mm^2 to 200 mm^2 area. Load the disks with a force that produces a pressure of (60 ± 5) kPa. Measure the gap between the disks in millimetres. Other methods, e.g. continuous ones, may be used instead if the results can be correlated to those of the method specified.

5.3 Elongation

Cut a 50 mm by 350 mm (minimum) sample from the blanket with the long direction parallel to the around-the-cylinder direction. Apply to the sample two benchmarks 250 mm apart. Clamp the shorter sides of the sample in a tensile testing apparatus with a jaw separation of 300 mm (minimum), and apply a static line force of 10 N/mm. After 10 min dwell time, determine the distance, L, between the benchmarks under load. Calculate the percentage elongation using Formula (1):

$$E = \frac{L - L_0}{L_0} \times 100\,\% \tag{1}$$

where

L_0 is equal to 250 mm benchmarks;

L is the length after 10 min under load.

5.4 Tensile strength

Cut a 50 mm by 300 mm (minimum) sample from the blanket with the long direction parallel to the around-the-cylinder direction. Clamp the shorter sides of the sample into a tensile strength testing apparatus with a minimum jaw separation of 200 mm. Apply the load with a jaw separation speed of 50 mm/min. Increase the load till the break occurs; read the force at break. The tensile strength is expressed in N/mm.

5.5 Load at specific deflection

a) Load at specific deflection is expressed as an average of stress (expressed in kPa).

b) Apparatus: continuous loading apparatus (tensometer) utilizing parallel flat surfaces and a circular load disk of 100 mm^2 to 1 000 mm^2.

c) Sample size is the same as the load disk.

d) Place the sample face toward the load disk and compress the sample to a preload of (60 ± 5) kPa.

e) Head speed: 1 mm/min.

f) Compress the sample to a deflection of 0,22 mm to 0,25 mm and immediately deload the sample to 0 kPa.

g) Reload the sample to (60 ± 5) kPa and repeat the deflection cycle two more times, recording the stress (in kPa) on the third cycle at 0,05 mm, 0,10 mm, 0,15 mm, and 0,20 mm. These recorded values are the

— load at 0,05 mm,

— load at 0,10 mm,

— load at 0,15 mm, and

— load at 0,20 mm.

h) Report values from an average of four samples.

Due to the machine deflection inherent in all test equipment, care should be taken to compensate for this deflection when reporting results. This deflection may be in the fixtures (e.g. compression cage) as well as the load cell. A test with the 100 mm^2 circular load disk between the parallel flat faces is run to determine the deflection of the testing system at different loads (stress). The stress-strain curve is used to correct this instrument deflection in order to indicate the correct deflection at specific load (stress).

5.6 Compressibility – Deflection

a) Indication of blanket compressibility is expressed as an absolute deflection at a pre-determined pressure of 2 000 kPa.

b) Apparatus: continuous loading apparatus (tensometer).

c) Use a compression load cell with parallel flat surfaces or a compression cage (maximum diameter is 100 mm) (see Figure 2).

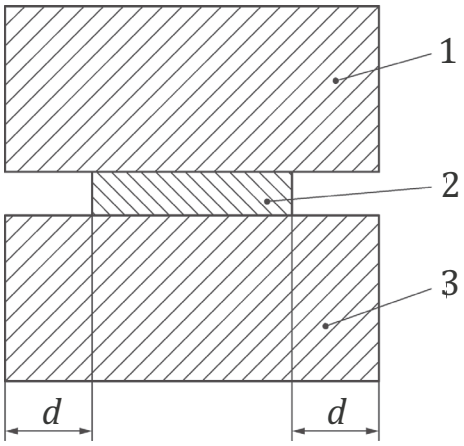
d) Sample size: (700 ± 10) mm^2, disk-shaped.

e) Head speed: 1 mm/min.

f) Zero point: (60 ± 5) kPa.

g) Compress the sample until a load of 2 060 kPa is reached, recording the deflection at the first and fifth cycles at 1 060 kPa and 2 060 kPa.

h) Report the fifth cycle deflection values at 1 060 kPa and 2 060 kPa from an average of four samples.



Key

1 upper face of compression apparatus
2 circular sample of 700 mm^2
3 lower face
d distance of 10 mm (minimum)

Figure 2 — Compressibility – Deflection (not to scale)

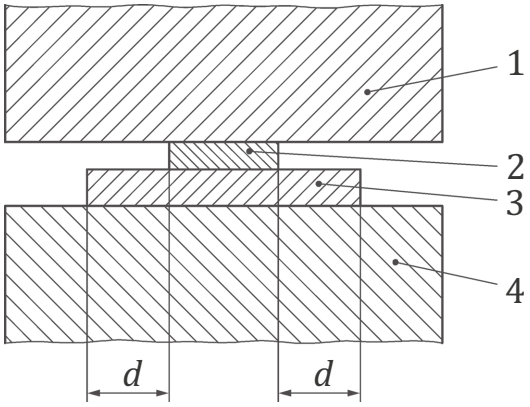
Due to machine deflection inherent in all test equipment, care should be taken to compensate for this deflection when reporting results. This deflection may be in the fixtures (e.g. compression cage) as well as the load cell. A test with a flat non-compressible circular disk (700 ± 10) mm^2 is run to determine the deflection of the testing system at different loads. This disk should be of minimum thickness such that all force is borne by the disk during the test. Suggested material for this disk is brass or steel. The stress-strain curve is used to correct for this instrument deflection in order to indicate the correct blanket compressibility.

5.7 Compressibility – Indentation

a) Indication of blanket compressibility is expressed as an absolute indentation at a pre-determined pressure of 1 000 kPa.

b) Apparatus: continuous loading apparatus (tensometer) utilizing parallel flat surfaces and a circular load disk of 100 mm^2 (see Figure 3).

c) Sample size: (700 ± 10) mm^2.



Key

1 upper face of compression apparatus
2 circular load disk of 100 mm^2
3 sample
4 lower face
d distance of 9 mm (minimum)

Figure 3 — Compressibility – Indentation (not to scale)

d) Zero point: (60 ± 5) kPa.

e) Record the distance between the load disk and the lower face in millimetres at the preload of (60 ± 5) kPa. The recorded value is the initial preload thickness, D_0 (see Figure 4).

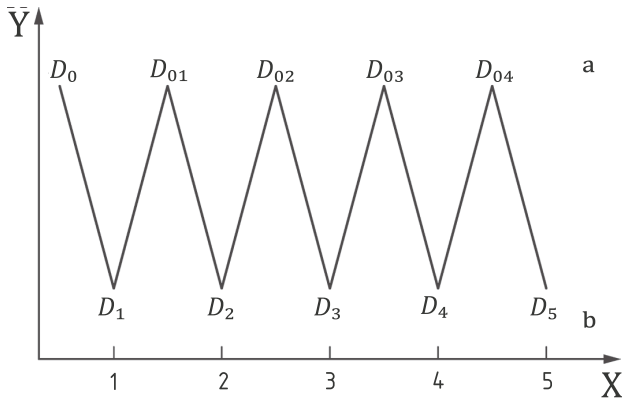
f) Head speed: 1 mm/min.

g) Compress the sample until a load of 1 060 kPa is reached, recording the distance between the load disk and the lower face in millimetres. The recorded value is the indented thickness, D_1.

h) Repeat the loading three times, then deload to 60 kPa, recording the distance between the load disk and the lower face in millimetres. The recorded value is the fifth cycle preload thickness, D_{04}.

i) Compress the sample a fifth time until a load of 1 060 kPa is reached and record the distance between the load disk and the lower face in millimetres. The recorded value is the indented thickness, D_5 (see Figure 4).

j) Report values from an average of four samples.



Key

Y thickness

X number of load cycles

a Unloaded thickness.

b Loaded thickness.

Figure 4 — Test procedure for Compressibility – Indentation

Report the following:

— the initial preload thickness, D_0;

— the absolute indentation, I_1, at the first loading, D_0 to D_1;

— the absolute indentation, I_5, at the fifth loading, D_{04} to D_5.

Alternatively, the percentage indentation, I_p, can be reported; then, the percentage indentation at the first loading is shown in Formula (2):

$$I_{p1} = \frac{D_0 - D_1}{D_0} \times 100\% \quad (2)$$

The percentage indentation at the fifth loading is shown in Formula (3):

$$I_{p5} = \frac{D_{04} - D_5}{D_{04}} \times 100\% \quad (3)$$

Due to the machine deflection inherent in all test equipment, care should be taken to compensate for this deflection when reporting results. This deflection may be in the fixtures (e.g. compression cage) as well as the load cell. A test with the 100 mm^2 circular load disk between the parallel flat faces is run to determine the deflection of the testing system at different loads. The stress-strain curve is used to correct this instrument deflection in order to indicate the correct blanket indentation.

5.8 Surface texture

The surface texture of a blanket will be measured with a surface roughness indicator (also referred to as a profilometer). Calculation is based on ISO 4287.

The size of the sample shall be sufficient to measure by the indicator.

Measure and record R_a from three samples. Report the median (i.e. middle) value of the three results. Additional roughness metrics may be reported at the choice of the manufacturer.

The direction of measurement of the blanket sample (across cylinder direction or around-the-cylinder direction) shall be reported.

5.9 Thickness change

5.9.1 Swelling or shrinkage after exposure to a test liquid

Cut a 50 mm diameter or 50 mm square sample from a blanket. Measure the initial thickness, T_0, of the blanket using the test method according to 5.2. Clamp the sample into a test fixture which protects the edge and non-printing surface from contact with the test liquid (see Figure 5). The test liquid shall be at least 3 mm deep. Expose the printing surface to the test liquid for a period t at a temperature, ϑ (5.9.3 for inks and 5.9.4 for washes). Remove the sample from the test fixture, clean off excess liquid and measure the thickness, T_1, using the method as specified in 5.2. Calculate the percentage thickness change using Formula (4):

$$\Delta T_1 = \frac{T_1 - T_0}{T_0} \times 100\% \tag{4}$$

where

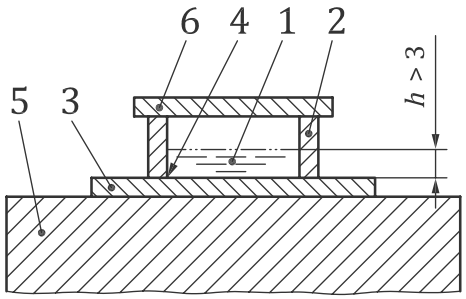
ΔT_1 is the percentage change after time, t;

T_1 is the thickness after time, t;

T_0 is the initial thickness.

The absolute thickness change may also be expressed in millimetres.

Dimensions in millimetres



Key

1 test liquid
2 upper test fixture
3 blanket sample
4 sealing point
5 lower test fixture
6 cover

Figure 5 — Test liquid exposure fixture (not to scale)

5.9.2 Swelling or shrinkage after recovery from exposure to a test liquid

Let the sample remain at a temperature of (23 ± 2) °C for 72 h and measure the thickness, T_2, using the test method according to 5.2. Calculate the percentage thickness change using Formula (5):

$$\Delta T_2 = \frac{T_2 - T_0}{T_0} \times 100\% \tag{5}$$

where

ΔT_2 is the percentage change after 72 h;

T_2 is the final thickness;

T_0 is the initial thickness.

The absolute thickness change may also be expressed in millimetres.

5.9.3 Exposure conditions for printing ink ingredients

The time of exposure is 20 h. The temperature of exposure is (35 ± 2) °C.

5.9.4 Exposure conditions for washes

The time of exposure is 5 h. The temperature of exposure is (23 ± 2) °C.

5.9.5 Report

Report the following points:

a) the percentage thickness changes, ΔT_1 and ΔT_2, and/or absolute thickness change;

b) the test liquid and time of exposure.

Bibliography

[1] ISO 4287, *Geometrical Product Specifications (GPS) — Surface texture: Profile method — Terms, definitions and surface texture parameters*

National Annex A

(*National Foreword*)

A-1 BIS CERTIFICATION MARKING

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act*, 2016 and the Rules and Regulations framed thereunder, and the product(s) may be marked with the Standard Mark.

Bureau of Indian Standards

BIS is a statutory institution established under the *Bureau of Indian Standards Act*, 2016 to promote harmonious development of the activities of standardization, marking and quality certification of goods and attending to connected matters in the country.

Review of Indian Standards

Amendments are issued to standards as the need arises on the basis of comments. Standards are also reviewed periodically; a standard along with amendments is reaffirmed when such review indicates that no changes are needed; if the review indicates that changes are needed, it is taken up for revision. Users of Indian Standards should ascertain that they are in possession of the latest amendments or edition by referring to the latest issue of 'BIS Catalogue' and 'Standards: Monthly Additions'.

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Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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