

Introduction:

In laser printing/photocopying the toner is heated to have a good adhesion on the substrate. This adhesion is influenced by the type of printer, toner and paper. To use the printed documents the adhesion must be good. To check the adhesion a print with pick test oil can be made on the laser printed/photocopied substrate. It can be checked if the toner is pulled off from the surface.

In this leaflet the method has been described for a constant speed of 0.4 m/s, according to EN 12883. If the toner is not pulled off from the paper and it must be known if there are differences in toner adhesion, the test can be carried out at higher constant speeds.

Another way to find out at what are the differences is to carry out the test at an increased speed so that the toner is pulled off at different levels. This method with increasing speed has been described in W56.

The method with the constant speed of 0.4 m/s described in this leaflet W55 has been standardised in EN12883.

Principle:

The paper is laser printed/photocopied. A strip of this toner printed paper is printed with pick test oil at a constant speed on an IGT printability tester. After printing the densities are measured at the location where the print has been made with pick test oil (toner has been pulled off) and at the location where no print has been made with the pick test oil (toner has not been pulled off). The densities are used in a formula to calculate the percentage of toner, which has been pulled off from the surface of the paper.

Method of operation:

- It is recommended to execute the test in the standard atmosphere; to most standards it is 23.0 ± 1.0 °C (73.4 ± 1.8 °F) and 50 ± 2% rh.
- For the operation of the AIC2-5T2000, Global Standard Tester, High Speed Inking Unit 4 and ink pipette follow the instructions of the manual, IGT information leaflet W100 and the display accurately.
- Handle the samples to be tested carefully.

Preparation

1. Condition the papers during > 6 hours in the standard atmosphere.
2. Print a stack of 10 sheets of a standard paper, the sheets of the papers to be tested and 5 sheets of the standard paper with a maximum density on a laser printer or photocopier.
3. Condition the papers, the pick test oil and the equipment during > 6 hours in the standard atmosphere.
4. Cut the paper strips (preferable 55 x 340 mm, 5 strips per sample) and mark them with top and/or bottom side, machine and/or cross direction and a code for the type of material.
5. For AIC2-5T2000 only:
 - 5.1. Mount the packing on the sector. See W100.
 - 5.2. Adjust the printing force for the upper printing disc shaft to 800 N and pay attention for the right backlash for both shafts. See W100.
 - 5.3. Adjust the printing speed to 0.4 m/s in the constant speed mode (□).
6. For GST 2/3/3H only:
 - 6.1. If not present, mount the sector with clamps. See W100.
 - 6.2. Mount the packing on the sector. See W100.
 - 6.3. Select the menu "Toner adhesion" in the display.
7. Check the functioning of the tester following the instructions in the chapter "Execution"
8. Adjust the High Speed Inking Unit with the following settings:

Materials / testing conditions		
1	IGT AIC2-5T2000	710.000.000
	or IGT Global Standard Tester 2	412.000.000
	or IGT Global Standard Tester 3	416.000.000
	or IGT Global Standard Tester 3H	467.000.000
2	IGT High Speed Inking Unit 4	466.000.710
3	(Top roller with 4 segments for conventional inks)	(466.003.003)
4	IGT ink pipette	408.000.200
5	Printing disc, aluminium, 20 mm, ø 65 mm	402.302
6	Pick test oil, medium viscosity	404.004.020
7	Packing, paper, 55 mm	404.001.005
8	Sector with clamps (for GST 2/3)	361.000.000
9	Photocopier or laser printer	
10	Densitometer	
11	"Standard paper", 15 sheets A4	
12	Paper to be tested, 5 sheets A4 per type	
13	Lint free rags	
14	Cleaning naphtha	
Printing force		800 N
Printing speed		Constant, 0.4 m/s
Pick test oil film thickness (volume)		8 µm (0.30 cm ³)
► The numbers 1 thru 8 are available at IGT Testing Systems. ► The numbers 5 thru 7 can be obtained as Toner Adhesion Set for AIC2-5T2000, GST 2/3/3H, article number 489.000.710. ► This leaflet contains article numbers per January 1st, 2006 ◀.		

Water bath: 23.0 ° C (73.4 °F)

Top roller: 4-segmented, rubber for conventional inks

Mode: 3

Starting time: 10 s

Distribution time: 30 s

Distribution speed: 0.5 m/s

2nd distribution time: 10 s

2nd distribution speed: 0.3 m/s

Inking time printing discs: 30 s

9. Check the functioning of the High Speed Inking Unit.
10. Fill the ink pipette with IGT medium viscosity pick test oil

Execution

1. Apply (0.30 cm³) of pick test oil to the inking unit or add 0.03 cm³ of pick test oil to maintain this layer and distribute the pick test oil. **NOTE:** Do not add pick test oil more than 4 times. **NOTE:** For another type of top roller see the manual of the inking unit.
2. Place the printing disc on the printing disc shaft of the inking unit and ink the printing disc.
3. If desired, adjust the printing speed of the tester.
4. Attach a test strip in the front clamp of the sector with the laser printed side up
5. Take the printing disc from the inking unit and place it on the (top) printing disc shaft of the tester.
6. Make a print. See W100.
7. Remove the test strip from the sector.
8. Measure the test result as explained in the chapter "Assessment".
9. Take the printing disc from the shaft and clean it with rags and naphtha.
10. Repeat the points 1 thru 9 for every strip. It is recommended to perform the test at least 5 times per sample.
11. After having finished the tests, clean and store all parts as described in the manuals.
12. Make an accurate record of the conditions and the test results of the test.



Fig. 1: Toner adhesion

Assessment

1. Measure the densities on the toner which has not been subjected to the pick test ($D_{\text{solid black}}$) and on the toner which has been subjected to the pick test (D_{IGT}). Measurements have to be made 10 times on every single strip.
2. Calculate the toner adhesion as:

$$\text{Toner adhesion} = (D_{\text{IGT}} : D_{\text{solid black}}) * 100\%$$

3. Repeat the points 1 thru 2 for every test strip.
4. Calculate the average and if desired the standard deviation. Sometimes it can be useful to mention the highest and lowest values as well.

Notes:

- 1 The test results of the AIC2-5T2000, AIC2-5 and Global Standard Tester 2, 3 and 3-H compare well with one another, on the condition that they have been carried out under the same conditions.
- 2 The maximum storage life of the pick test oil in the original packing is 3 years, in an opened packing 1 year.

► In comparison to older IGT leaflets, this leaflet is valid for the AIC2-5T2000 and Global Standard Testers as mentioned

This information leaflet has been compiled with the utmost care. However, may you find any inadequacies or if there are any comments, we kindly request you to send these to IGT Testing Systems, Sales Department.