LaserEcoClean GmbH & Co. KG

RollerCheck360

Roll Inspection from 08.12.2025
Order:
Rolls: 178
Roll lengths: 870, 1300, 1320, 1360 mm

You can also find this roll inspection report in your LaserEcoClean Customer Portal.
You can use your Customer Portal for:
- cataloguing all your rolls;
- entering up-to-date information on ink transfer changes;
- recording all chips and scratches throughout the entire service life of the roll;
- storing photos of the rolls.

If you want to save time, you can order a professional anilox roll inspection from us, and we will enter the results directly into your Customer Portal.

Please contact us
Ekaterina Hagel
+49 178 716 8270
e.hagel@laserecoclean.de

2026

We have analyzed for you 178 rolls.

43 rolls are heavily worn and require immediate replacement:

046633 - 400 - 4.0	046639 - 180 - 9.9	17011017 - 140 - 9.2	17011018 - 180 - 8.5	alt17447 - 140 - 13.0
h100748-3 - 140 - 12.5	h100748-4 - 140 - 12.5	h100748-6 - 180 - 9.5	h100750-6 - 140 - 12.5	sa008587 - 110 - 13.0
sa008588 - 130 - 10.0	sa008590 - 150 - 9.0	sa008616 - 130 - 14.0	sg49046-3 - 130 - 12.0	sg49046-20 - 380 - 5.0
sg49046-30 - 460 - 3.8	z26268 - 180 - 9.8	z45224 - 140 - 9.5	z45225 - 140 - 9.5	z45229 - 180 - 9.0
z48062 - 180 - 8.5	z48065 - 180 - 8.8	z48067 - 180 - 5.8	z16007650 - 160 - 12.3	z16007651 - 180 - 9.2
z16007652 - 160 - 12.0	z16007663 - 140 - 13.0	z16007664 - 140 - 13.0	z16007667 - 160 - 12.2	z17011012 - 400 - 3.6
z17011014 - 400 - 3.6	z17011016 - 140 - 9.0	z17011022 - 400 - 3.7	z17011024 - 400 - 3.7	z17011027 - 100 - 11.0
z17011035 - 400 - 3.7	z17011036 - 400 - 3.7	z17011040 - 400 - 3.6	z18008066 - 400 - 3.5	z18008073 - 180 - 9.0
z18008078 - 140 - 13.0	z18009225 - 140 - 13.0	z19012420 - 140 - 13.0		

80 rolls are worn and will need to be replaced within the next year:

046634 - 400 - 4.0	3016196-2 - 120 - 12.0	3016199-3 - 380 - 5.0	aa2013651 - 460 - 3.8	aa2413645 - 420 - 4.0
aa2413648 - 280 - 7.5	aa2413649 - 380 - 5.0	aa2413650 - 460 - 3.8	aa2413652 - 460 - 3.8	aa2413653 - 460 - 3.8
ad007096 - 460 - 3.8	ds007093 - 460 - 3.8	h100479-1 - 380 - 5.0	h100479-2 - 380 - 5.0	h100479-4 - 420 - 4.0
h100479-6 - 420 - 4.0	h100479-7 - 420 - 4.0	h100749-1 - 140 - 12.5	h100749-3 - 180 - 9.5	h100750-1 - 130 - 13.5
h100750-7 - 140 - 12.5	h100751-3 - 200 - 8.5	h100751-6 - 160 - 10.5	h100751-9 - 160 - 10.5	kk74444 - 280 - 8.0
kk74445 - 280 - 11.0	kk97627 - 180 - 7.3	s2401658 - 460 - 3.8	s2401718 - 460 - 3.8	s2401741 - 200 - 8.0
sa0007096 - 460 - 3.8	sa008591 - 150 - 9.0	sa008592 - 170 - 8.0	sa008593 - 200 - 7.5	sa008594 - 250 - 7.0
sa008595 - 300 - 6.0	sa008596 - 350 - 5.5	sa008597 - 380 - 5.0	sa008599 - 460 - 3.8	sa008600 - 460 - 3.8
sa008602 - 460 - 3.8	sa008603 - 460 - 3.8	sa008606 - 460 - 3.8	sa008608 - 460 - 3.8	sa008612 - 460 - 3.8
sa008613 - 460 - 3.8	sa008619 - 200 - 9.0	sa008624 - 340 - 5.5	sa008625 - 360 - 5.0	sd007094 - 460 - 3.8
sg49046-17 - 340 - 5.5	sg49046-18 - 380 - 5.0	sg49046-31 - 460 - 3.8	z45231 - 180 - 9.1	z48064 - 180 - 8.8
z48070 - 400 - 4.1	z48074 - 400 - 3.8	z56916 - 400 - 4.1	z56917 - 400 - 3.9	z16007646 - 280 - 7.0
z16007654 - 160 - 9.0	z16007659 - 400 - 4.0	z17011013 - 400 - 3.7	z17011020 - 280 - 7.1	z17011023 - 400 - 3.7
z17011029 - 180 - 8.8	z17011030 - 180 - 8.5	z17011031 - 280 - 6.9	z17011032 - 280 - 6.9	z17011034 - 400 - 3.7
z17011037 - 400 - 3.7	z18006928 - 280 - 6.6	z18008068 - 400 - 3.5	z18008070 - 280 - 7.0	z18008072 - 180 - 9.0
z18008076 - 160 - 12.9	z18008079 - 160 - 7.7	z18008080 - 120 - 15.0	z18009229 - 180 - 9.5	z18009230 - 280 - 7.0

The condition of the remaining rolls can be found in the table below.

№	Roll number	Roll length, mm	Nominal line screen lpcm	Ink transfer, cm3/m2	Measured line screen lpcm	Troika ink transfer, cm3/m2			Change in ink transfer	Bridge / Cell	Cleaning passes	Comment
						1	2	3				
1	h100479-7	1320	420	4.0	460	3.4	-	-	-15.00%	1/5	1	radial doctor-blade streaks. roll is worn.
2	sa0007096	1320	460	3.8	460	3.4	-	-	-10.53%	1/6	1	radial doctor-blade streaks. roll is worn.
3	sd007094	1320	460	3.8	460	2.9	-	-	-23.68%	1/5	1	radial doctor-blade streaks. roll is worn.
4	h100749-1	1320	140	12.5	140	7.7	-	-	-38.40%	1/9	1	streak 225 scratches 425 1250 spot 510 400.
5	ds007093	1320	460	3.8	460	3.4	-	-	-10.53%	1/5	1	dent 700 spots streaks. roll is worn.
6	h100479-4	1320	420	4.0	420	3.8	-	-	-5.00%	1/5	1	streaks 240 490 640 650 725 965 dent 315. roll is worn.
7	3016196-1	1320	140	10.0	140	7.3	-	-	-27.00%	1/9	1	streak 740.
8	h100748-1	870	130	13.5	130	11.3	-	-	-16.30%	1/18	1	streaks.
9	sa008588	1300	130	10.0	130	2.7	-	-	-73.00%	1/2	1	worn streaks scratch 1290. roll is heavily worn.
10	kk97627	1300	180	7.3	180	5.8	-	-	-20.55%	1/5	1	chip 1275 1280 streak 468 947. roll is worn.
11	sa008598	1300	420	4.5	420	4.2	-	-	-6.67%	1/7	1	dent 195 250. roll is slightly worn.
12	sa008594	1300	250	7.0	260	6.5	-	-	-7.14%	1/6	1	streak 40 scratch 195 260 chip 1280. roll is worn.
13	sa008596	1300	350	5.5	340	4.8	-	-	-12.73%	1/6	1	scratch 190 145 385 350 1140 1100 chip 230. roll is worn.
14	aa2413108	1300	420	4.0	420	4.0	-	-	0.00%	1/7	1	streak 165. roll is slightly worn.
15	h100751-9	1300	160	10.5	160	7.8	-	-	-25.71%	1/5	1	scratch 40 105 380 410 440. roll is worn.
16	17011017	1300	140	9.2	140	4.4	-	-	-52.17%	1/3	1	scratch 145 dent 15 105 165 294 worn. roll is heavily worn.
17	h100750-7	1300	140	12.5	140	9.0	-	-	-28.00%	1/6	1	dent 290 245 320 streak 520 700 520 scratch 570. roll is worn.
18	z45231	1300	180	9.1	180	4.8	-	-	-47.25%	1/4	1	streaks spot 290 400 770 520 dent 975 920 worn. roll is worn.
19	sa008622	1320	300	6.5	300	5.5	-	-	-15.38%	1/10	1	streak 740 220.
20	sa008600	1300	460	3.8	460	3.8	-	-	0.00%	1/6	1	streaks 315 360 365 1265. roll is worn.
21	z17011023	1300	400	3.7	400	3.0	-	-	-18.92%	1/5	1	dent 1170 1230 1305 190 200 streak 77 1153. roll is worn.
22	3016199-3	1300	380	5.0	360	4.6	-	-	-8.00%	1/6	1	roll is worn.
23	sa008591	1300	150	9.0	150	6.3	-	-	-30.00%	1/4	1	worn streak 880. roll is worn.
24	aa2413645	1300	420	4.0	420	4.0	-	-	0.00%	1/4	1	roll is worn.
25	z17011012	1300	400	3.6	400	2.5	-	-	-30.56%	1/3	1	cell walls are missing streak 263 890 dent 415 475 1200 1235 1250 1280 1295. roll is heavily worn.
26	aa2413643	1300	420	4.0	420	4.0	-	-	0.00%	1/7	1	scratch 20. roll is slightly worn.
27	z17011034	1300	400	3.7	400	3.0	-	-	-18.92%	1/4	1	streak 75 85 110 245 1040 1268 dent 1130 1205 1115 1085. roll is worn.
28	z26268	1300	180	9.8	180	5.0	-	-	-48.98%	1/3	1	dent 30 210 250 270 300 350 1170 1230 350 370 565. roll is heavily worn.
29	z45225	1300	140	9.5	140	4.1	-	-	-56.84%	1/3	1	worn streaks dent 1170. roll is heavily worn.
30	z17011036	1300	400	3.7	380	1.9	-	-	-48.65%	1/3	1	worn cell walls are missing streak 1133 dent 418 520. roll is heavily worn.

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						1	2	3				
31	z48067	1300	180	5.8	180	2.4	-	-	-58.62%	1/4	1	streaks dent 1295. roll is worn.
32	z56916	1300	400	4.1	420	4.1	-	-	0.00%	1/5	1	streaks 1140 dent 1195 1250. roll is worn.
33	h100751-6	1300	160	10.5	160	8.0	-	-	-23.81%	1/6	1	streaks. roll is worn.
34	z18009225	1300	140	13.0	140	2.8	-	-	-78.46%	1/2	1	worn dent 210 195 175 streaks. roll is heavily worn.
35	sa008618	1320	170	9.5	170	8.3	-	-	-12.63%	1/7	1	roll is slightly worn.
36	sa008621	1320	250	8.0	250	7.6	-	-	-5.00%	1/9	1	streak 1265 dent 1175 1150.
37	z18008066	1320	400	3.5	420	2.4	-	-	-31.43%	1/2	1	worn streak 1034 415 674 973 1265 dent 1005 1015 1023. roll is heavily worn.
38	h100479-2	1320	380	5.0	380	4.1	-	-	-18.00%	1/4	1	streaks. roll is worn.
39	z18008070	1320	280	7.0	280	6.3	-	-	-10.00%	1/6	1	dent 1160. roll is worn.
40	sa008625	1320	360	5.0	360	5.0	-	-	0.00%	1/5	1	streaks scratch 268. roll is worn.
41	sa008624	1320	340	5.5	340	5.3	-	-	-3.64%	1/6	1	streak 602 670 scratch 760. roll is worn.
42	h100479-1	1320	380	5.0	380	4.5	-	-	-10.00%	1/6	1	spots across the entire surface. roll is worn.
43	3016196-2	1320	120	12.0	120	7.6	-	-	-36.67%	1/5	1	worn streak 896 767. roll is worn.
44	z18008076	1320	160	12.9	160	9.7	-	-	-24.81%	1/5	1	streaks. roll is worn.
45	kk74445	1320	280	11.0	280	5.7	-	-	-48.18%	1/6	1	dent 1120 streaks chip 1090 1125 spot 260. roll is worn.
46	z18008069	1320	280	7.0	280	6.7	-	-	-4.29%	1/8	1	scratch 1219 1290 1050 450 spot 505 streak 217. roll is slightly worn.
47	z18008080	1320	120	15.0	120	11.2	-	-	-25.33%	1/5	1	streak 363 630 687 714 1057 dent 1130 1150 scratch 530 340. roll is worn.
48	z18008072	1320	180	9.0	180	7.1	-	-	-21.11%	1/5	1	worn streak 410 1021 scratch 345 1200. roll is worn.
49	z18008068	1320	400	3.5	420	2.3	-	-	-34.29%	1/4	1	streaks spot 270 wide streaks 110 293 661 805 1045 1160. roll is worn.
50	3016196-02	1320	120	12.0	120	8.6	-	-	-28.33%	1/7	1	chips at edges scratch 260. roll is slightly worn.
51	z19012420	1320	140	13.0	140	9.1	-	-	-30.00%	1/3	1	streak 94 356 dent 270 282 302 scratch 594 722. roll is heavily worn.
52	h100479-3	1320	420	4.0	420	3.6	-	-	-10.00%	1/11	1	streak 1233 603.
53	sa008619	1320	200	9.0	200	7.3	-	-	-18.89%	1/6	1	spot 60 70. roll is worn.
54	z18008073	1320	180	9.0	180	3.4	-	-	-62.22%	1/2	1	mechanical wear chips 640 660 585 320 360 streak 320 885. roll is heavily worn.
55	sa0088623	1320	320	6.0	300	5.5	-	-	-8.33%	1/10	1	streak 370 575 673.
56	h100749-4	1320	300	6.5	300	5.9	-	-	-9.23%	1/16	1	chip 890.
57	sa008616	1320	130	14.0	130	6.2	-	-	-55.71%	1/2	1	worn streaks scratch 220. roll is heavily worn.
58	s2401739	1320	330	4.0	330	3.8	-	-	-5.00%	1/14	1	streak 30 1210 dent 1125.
59	aa2413647	1320	180	10.0	180	9.1	-	-	-9.00%	1/18	1	streaks streak 30.
60	z18008078	1320	140	13.0	140	5.9	-	-	-54.62%	1/3	1	mechanical damage 80 scratch 1310 dent 270 300 streak 340 spot 150. roll is heavily worn.

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						1	2	3				
61	h100749-2	1320	140	12.5	140	9.3	-	-	-25.60%	1/7	1	chips at edges dents 215 170 150. roll is slightly worn.
62	h100479-5	1320	420	4.0	420	3.6	-	-	-10.00%	1/11	1	dent 740 1000 1160 1250 fine streaks.
63	sd007092	1320	460	3.8	460	3.6	-	-	-5.26%	1/10	1	streak 687 590 118 900.
64	h100479-6	1320	420	4.0	460	2.9	-	-	-27.50%	1/5	1	streak 97 203 297 377 788 892 1140. roll is worn.
65	s2401742	1320	240	6.5	240	5.8	-	-	-10.77%	1/13	1	streak 270.
66	s2401659	1320	460	3.8	460	3.2	-	-	-15.79%	1/10	1	
67	aa2413648	1320	280	7.5	280	6.7	-	-	-10.67%	1/6	1	
68	aa2413649	1320	380	5.0	380	3.8	-	-	-24.00%	1/4	1	roll is worn.
69	s2401740	1320	330	4.0	320	3.5	-	-	-12.50%	1/9	1	
70	s2401741	1320	200	8.0	200	7.6	-	-	-5.00%	1/6	1	streak 175. roll is worn.
71	aa2013651	1320	460	3.8	460	3.5	-	-	-7.89%	1/6	1	
72	sg4904612	1360	280	7.6	280	6.4	-	-	-15.79%	1/8	1	roll is worn.
73	s2401718	1320	460	3.8	460	3.4	-	-	-10.53%	1/5	1	streak 150 272 478 530 912. roll is worn.
74	aa2413652	1320	460	3.8	460	3.5	-	-	-7.89%	1/6	1	roll is slightly worn.
75	s2401660	1320	460	3.8	460	3.5	-	-	-7.89%	1/10	1	roll is worn.
76	z17011027	1300	100	11.0	100	3.2	-	-	-70.91%	1/2	1	streak 575 600. roll is worn.
77	sa008587	1300	110	13.0	110	5.4	-	-	-58.46%	1/2	1	streaks scratches 250.
78	z18009229	1300	180	9.5	180	5.9	-	-	-37.89%	1/4	1	worn. roll is heavily worn.
79	z17011037	1300	400	3.7	400	2.3	-	-	-37.84%	1/4	1	scratch 1030 1070 streak 938 280 worn. roll is heavily worn.
80	z48070	1300	400	4.1	400	3.3	-	-	-19.51%	1/4	1	streak 970 dent 1050 1080. roll is worn.
81	046633	1300	400	4.0	420	2.7	-	-	-32.50%	1/3	1	streaks streak 734 dent 1125 1175 1220. roll is worn.
82	046634	1300	400	4.0	420	2.7	-	-	-32.50%	1/4	1	streaks streak 55 128 1032 dent 222 231 257 1160 1000. roll is worn.
83	sg49046-30	1360	460	3.8	460	2.6	-	-	-31.58%	1/3	1	streak 34 747. roll is heavily worn.
84	h100750-1	1300	130	13.5	130	9.5	-	-	-29.63%	1/5	1	streak 650 798 1172. roll is worn.
85	z17011030	1300	180	8.5	180	5.5	-	-	-35.29%	1/4	1	streaks in places cell walls are missing. roll is heavily worn.
86	z17011014	1300	400	3.6	380	1.9	-	-	-47.22%	1/3	1	dent 255 268 273 273 303. roll is worn.
87	z17011021	1300	280	7.1	280	6.2	-	-	-12.68%	1/8	1	streak 285 835 dent 460. roll is worn.
88	046635	1300	400	4.0	400	3.2	-	-	-20.00%	1/7	1	cell walls are missing streak 36 52 163 233 1228 842 970 dent 330 340 362 342 300 1165 1280. roll is heavily worn.
89	z16007654	870	160	9.0	160	7.2	-	-	-20.00%	1/5	1	streak 1035 dent 85 1050. roll is slightly worn.
90	3016198-2	870	180	9.0	180	6.9	-	-	-23.33%	1/7	1	scratch 1253. roll is slightly worn.

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						1	2	3				
91	z16007659	870	400	4.0	400	2.9	-	-	-27.50%	1/4	1	streak 120 409 689. roll is worn.
92	z16007663	870	140	13.0	140	5.5	-	-	-57.69%	1/3	1	streaks. roll is slightly worn.
93	z16007646	870	280	7.0	280	4.6	-	-	-34.29%	1/4	1	streak 860 streaks. roll is worn.
94	sa008613	870	460	3.8	460	3.8	-	-	0.00%	1/6	1	worn streak 739 748 streaks scratch 860. roll is heavily worn.
95	alt17447	870	140	13.0	140	4.4	-	-	-66.15%	1/2	1	streak 112 254. roll is worn.
96	aa2413650	1320	460	3.8	460	3.2	-	-	-15.79%	1/6	1	spots streak 129 151 158. roll is worn.
97	aa2413653	1320	460	3.8	460	3.4	-	-	-10.53%	1/5	1	worn spots. roll is heavily worn.
98	z18008079	1320	160	7.7	160	5.6	-	-	-27.27%	1/5	1	streaks. roll is worn.
99	aa2409897	1320	130	12.0	130	10.0	-	-	-16.67%	1/14	1	streaks. roll is worn.
100	ad007096	1320	460	3.8	460	3.1	-	-	-18.42%	1/6	1	streak 134. roll is worn.
101	z45229	1300	180	9.0	180	3.2	-	-	-64.44%	1/3	1	streak 900.
102	sa008592	1300	170	8.0	170	6.3	-	-	-21.25%	1/4	1	streak 759. roll is worn.
103	alt17454	1300	80	18.0	80	17.2	-	-	-4.44%	1/11	1	worn streak 78 875 100 65 50 1255 dent 213 234 1243 1265. roll is heavily worn.
104	sg49046-9	1360	180	10.0	180	8.1	-	-	-19.00%	1/7	1	worn streak 110 scratch 390 400 414 510 523 535 555 dent 1185. roll is worn.
105	sg49046-31	1360	460	3.8	460	3.2	-	-	-15.79%	1/6	1	dent 450 467 493 530 580 streak 780.
106	sg49046-5	1360	160	11.0	170	8.7	-	-	-20.91%	1/8	1	streaks scratch 205 chips at edges. roll is slightly worn.
107	sg49046-20	1360	380	5.0	400	3.1	-	-	-38.00%	1/3	1	streak 40. roll is worn.
108	sg49046-14	1360	280	7.5	280	7.0	-	-	-6.67%	1/8	1	streak 480 430. roll is slightly worn.
109	sa008602	1300	460	3.8	460	3.4	-	-	-10.53%	1/6	1	spot 1335 streak 877 scratch 80. roll is heavily worn.
110	z17011016	1300	140	9.0	110	3.2	-	-	-64.44%	1/3	1	scratch 1270. roll is slightly worn.
111	sa008593	1300	200	7.5	200	4.3	-	-	-42.67%	1/4	1	scratch 40 130 1120 90 spots many. roll is worn.
112	z48062	1300	180	8.5	180	3.4	-	-	-60.00%	1/3	1	worn. roll is heavily worn.
113	h100751-1	1300	200	8.5	200	7.9	-	-	-7.06%	1/9	1	
114	kk74444	1300	280	8.0	280	5.9	-	-	-26.25%	1/4	1	streaks many dent 55 worn scratches 55 spots 260 210 180. roll is worn.
115	z45224	1300	140	9.5	150	3.5	-	-	-63.16%	1/3	1	scratch 80 streaks. roll is heavily worn.
116	z17011024	1300	400	3.7	420	1.5	-	-	-59.46%	1/2	1	
117	h100749-3	1320	180	9.5	180	7.7	-	-	-18.95%	1/5	1	chips at edges scratch 140 dent 1200 spot 1165 335 260. roll is worn.
118	sg4904611	1360	240	8.5	250	8.5	-	-	0.00%	1/9	1	worn chips at edges scratch 250 dent 45. roll is heavily worn.
119	h100750-4	1300	140	12.5	140	11.9	-	-	-4.80%	1/13	1	
120	h100748-2	870	300	6.5	300	5.0	-	-	-23.08%	1/7	1	wear spot 1190 1150 590 570 550 streaks scratch 25 dent 1240. roll is heavily worn.

№	Roll number	Roll length, mm	Nominal line screen lpcm	Ink transfer, cm3/m2	Measured line screen lpcm	Troika ink transfer, cm3/m2			Change in ink transfer	Bridge / Cell	Cleaning passes	Comment
						1	2	3				
121	sa008609	870	460	3.8	460	3.5	-	-	-7.89%	1/10	1	spot many across the entire roll chips 1220 1270. roll is worn.
122	z16007651	870	180	9.2	180	2.2	-	-	-76.09%	1/2	1	chip 278 streak 814.
123	z16007652	870	160	12.0	160	5.2	-	-	-56.67%	1/3	1	
124	sa008607	870	460	3.8	460	3.2	-	-	-15.79%	1/10	1	
125	aa2413872	870	420	4.0	420	3.8	-	-	-5.00%	1/7	1	spot 500 635 streaks at edges. roll is slightly worn.
126	h100748-3	870	140	12.5	140	5.4	-	-	-56.80%	1/4	1	spot 380.
127	sa008608	870	460	3.8	460	3.5	-	-	-7.89%	1/6	1	worn. roll is heavily worn.
128	aa2413869	870	340	5.5	340	4.7	-	-	-14.55%	1/9	1	streaks at edges , 640. roll is heavily worn.
129	s2401658	1320	460	3.8	460	3.5	-	-	-7.89%	1/6	1	
130	sa008612	870	460	3.8	460	3.8	-	-	0.00%	1/6	1	streak at edge. roll is slightly worn.
131	z16007667	870	160	12.2	170	3.7	-	-	-69.67%	1/2	1	streak 610. roll is worn.
132	z16007650	870	160	12.3	160	3.1	-	-	-74.80%	1/2	1	spots. roll is worn.
133	sg49046-15	1360	300	6.5	300	5.5	-	-	-15.38%	1/10	1	streak at edge.
134	sg49046-25	1360	420	4.0	420	4.0	-	-	0.00%	1/7	1	streaks. roll is worn.
135	sg49046-27	1360	420	4.0	420	3.6	-	-	-10.00%	1/7	1	roll is worn.
136	sg49046-3	1360	130	12.0	130	5.8	-	-	-51.67%	1/3	1	worn. roll is heavily worn.
137	sg49046-6	1360	180	10.0	180	7.2	-	-	-28.00%	1/10	1	worn streaks. roll is heavily worn.
138	sg49046-4	1360	160	11.0	160	8.4	-	-	-23.64%	1/8	1	streaks streak 123.
139	sg49046-1	1360	130	12.0	130	9.8	-	-	-18.33%	1/24	1	. roll is slightly worn.
140	z48064	1300	180	8.8	180	5.2	-	-	-40.91%	1/6	1	chips at edges. roll is slightly worn.
141	sg49046-19	1360	380	5.0	380	5.0	-	-	0.00%	1/12	1	cell walls are damaged streaks. roll is heavily worn.
142	z56917	1300	400	3.9	420	3.9	-	-	0.00%	1/5	1	dents 34 scratch 460 chips at edges.
143	z48069	1300	280	7.4	280	6.8	-	-	-8.11%	1/8	1	streaks 295 564 spot 1180 scratch 28. roll is slightly worn.
144	17011018	1300	180	8.5	180	3.8	-	-	-55.29%	1/3	1	not worn, no visible damage.
145	z17011031	1300	280	6.9	280	5.4	-	-	-21.74%	1/6	1	edge chips worn dent 190 248. roll is worn.
146	z17011013	1300	400	3.7	400	2.5	-	-	-32.43%	1/4	1	streak 1135 64.
147	z48065	1300	180	8.8	180	2.3	-	-	-73.86%	1/3	1	chips at edges streaks streak 345 795 spot 85. roll is worn.
148	sg4904610	1360	240	8.5	240	8.5	-	-	0.00%	1/13	1	
149	h100748-6	870	180	9.5	180	3.3	-	-	-65.26%	1/3	1	dent 390 415 445 460 490 320 330 345 365 770 streak 275 chips at edges. roll is slightly worn.
150	z17011040	870	400	3.6	420	2.2	-	-	-38.89%	1/3	1	worn scratch 1240 spots 1280. roll is heavily worn.

№	Roll number	Roll length, mm	Nominal line screen lpcm	Ink transfer, cm3/m2	Measured line screen lpcm	Troika ink transfer, cm3/m2			Change in ink transfer	Bridge / Cell	Cleaning passes	Comment
						1	2	3				
151	aa2413870	870	340	5.5	360	5.3	-	-	-3.64%	1/8	1	dents 155 180 220. roll is worn.
152	z16007664	870	140	13.0	140	3.7	-	-	-71.54%	1/2	1	dents 370 340 scratch 45 spots. roll is worn.
153	3016198-3	870	220	8.0	220	6.1	-	-	-23.75%	1/13	1	scratch 72 spots. roll is heavily worn.
154	sg49046-18	1360	380	5.0	420	3.8	-	-	-24.00%	1/5	1	
155	sg49046-23	1360	420	4.0	420	4.0	-	-	0.00%	1/7	1	worn streaks. roll is heavily worn.
156	sg49046-17	1360	340	5.5	360	4.9	-	-	-10.91%	1/6	1	wear streaks 65 130. roll is heavily worn.
157	z17011022	1300	400	3.7	420	1.8	-	-	-51.35%	1/3	1	streak 855. roll is slightly worn.
158	sa008599	1300	460	3.8	460	3.5	-	-	-7.89%	1/6	1	wear streak 300. roll is heavily worn.
159	h100750-6	1300	140	12.5	140	5.9	-	-	-52.80%	1/3	1	streak 95.
160	046639	1300	180	9.9	180	4.4	-	-	-55.56%	1/3	1	roll is worn.
161	sa008590	1300	150	9.0	160	3.7	-	-	-58.89%	1/3	1	streaks streak 50 1335 chips at edges. roll is slightly worn.
162	z17011032	1300	280	6.9	280	6.4	-	-	-7.25%	1/6	1	streak 1260 chips at edges. roll is worn.
163	z17011020	1300	280	7.1	280	6.7	-	-	-5.63%	1/6	1	streaks cell walls are missing. roll is heavily worn.
164	a2724009	1300	280	5.5	280	4.3	-	-	-21.82%	1/8	1	spot 1335 chips at edges. roll is worn.
165	sa008606	1300	460	3.8	460	2.3	-	-	-39.47%	1/4	1	streaks wear cell walls are missing. roll is heavily worn.
166	sa008603	1300	460	3.8	460	2.3	-	-	-39.47%	1/4	1	dent 250 290 scratch 1020 470. roll is heavily worn.
167	sa008597	1300	380	5.0	400	4.5	-	-	-10.00%	1/4	1	streak 1070 bumps 300 scrap. roll is heavily worn.
168	sa008595	1300	300	6.0	300	4.7	-	-	-21.67%	1/5	1	spot 1260 streaks. roll is worn.
169	h100748-4	870	140	12.5	140	5.9	-	-	-52.80%	1/3	1	dents 95 114 305 360. roll is worn.
170	z18006928	1300	280	6.6	280	5.5	-	-	-16.67%	1/5	1	chip 75 streak 385. roll is slightly worn.
171	h100751-3	1300	200	8.5	200	7.3	-	-	-14.12%	1/6	1	dent 240 285. roll is worn.
172	z17011029	1300	180	8.8	180	6.2	-	-	-29.55%	1/5	1	roll is worn.
173	z17011035	1300	400	3.7	400	2.0	-	-	-45.95%	1/3	1	dent 1200 1290 streak 1115. roll is worn.
174	z48074	1300	400	3.8	400	3.0	-	-	-21.05%	1/4	1	streak dent 1235. roll is worn.
175	z18006927	1300	280	7.0	280	5.5	-	-	-21.43%	1/8	1	worn streaks. roll is heavily worn.
176	sa008610	870	460	3.8	460	3.8	-	-	0.00%	1/10	1	
177	sa008614	870	460	3.8	460	3.8	-	-	0.00%	1/10	1	
178	z18009230	1300	280	7.0	280	5.1	-	-	-27.14%	1/5	1	scratch 1200 chip 1000. roll is worn.

Change in ink transfer:

- No measurements were taken. You can request a full anilox roll inspection from our manager.
- The ink transfer value exceeds the nominal by 10 percent or more.
- The ink transfer drop is between 0% and 15%. The roller's ink transfer is within normal range.
- The ink transfer drop is between 15% and 30%. The roller's ink transfer has slightly decreased.
- The ink transfer of the roll has decreased by 30–50%. Ink transfer has significantly dropped. This must be taken into account during printing. The roll will need to be replaced within a year.
- The ink transfer drop is between 50% and 100%. The roller's ink transfer no longer meets specifications. The roll must be replaced.

Bridge / Cell:

- 1/9 and above.
- From 1/7 to 1/8 – roll slightly worn.
- From 1/4 to 1/6 – roll worn. The roll will need to be replaced within a year.
- 1/3 and below – roll heavily worn. The roll must be replaced.

We can offer you new anilox rolls from European and Indian manufacturers with warranty:

Ekaterina Hagel, +49 178 716 8270.

Thank you for ordering the mobile laser cleaning with LaserEcoClean technology. All cells in your anilox rollers have been completely freed from polymer and organic residues. Additionally, a comprehensive anilox roll inspection using the LEC Customer Portal system has been performed.
If you are using the free inspection report, we have already analyzed a few of your rollers as part of this complimentary diagnostic service.

If you need an inspection of your entire anilox roll inventory, please contact our manager at e.hagel@laserecoclean.de.

The LEC Customer Portal inspection helps you identify which rolls are worn and require immediate replacement, and which ones will need to be replaced within the next year. By using the diagnosis annually, you can track the wear rate of your rolls and make timely decisions on roll replacement.

All information is provided as is, without warranty.

Page №1. Roll "h100479-7". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100479-7".	Photo of the anilox roll surface

Roll designations:

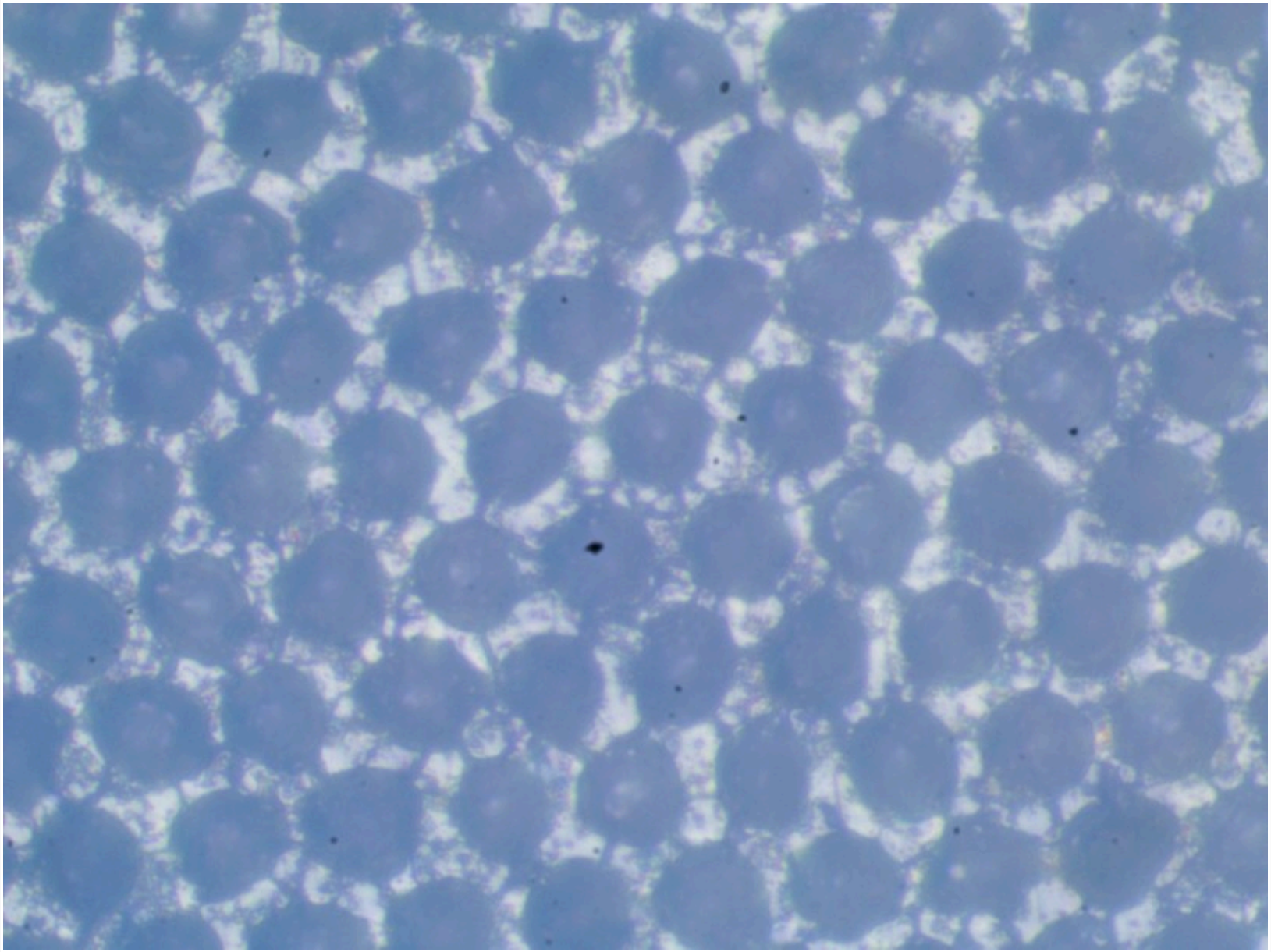
Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 15%

Bridge / Cell: 1 / 5
Depth before / after: 13 / 13 µm
Depth decreased by: 0%



Comment
radial doctor-blade streaks.
Roll is worn.

Page №2. Roll "sa0007096". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa0007096".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

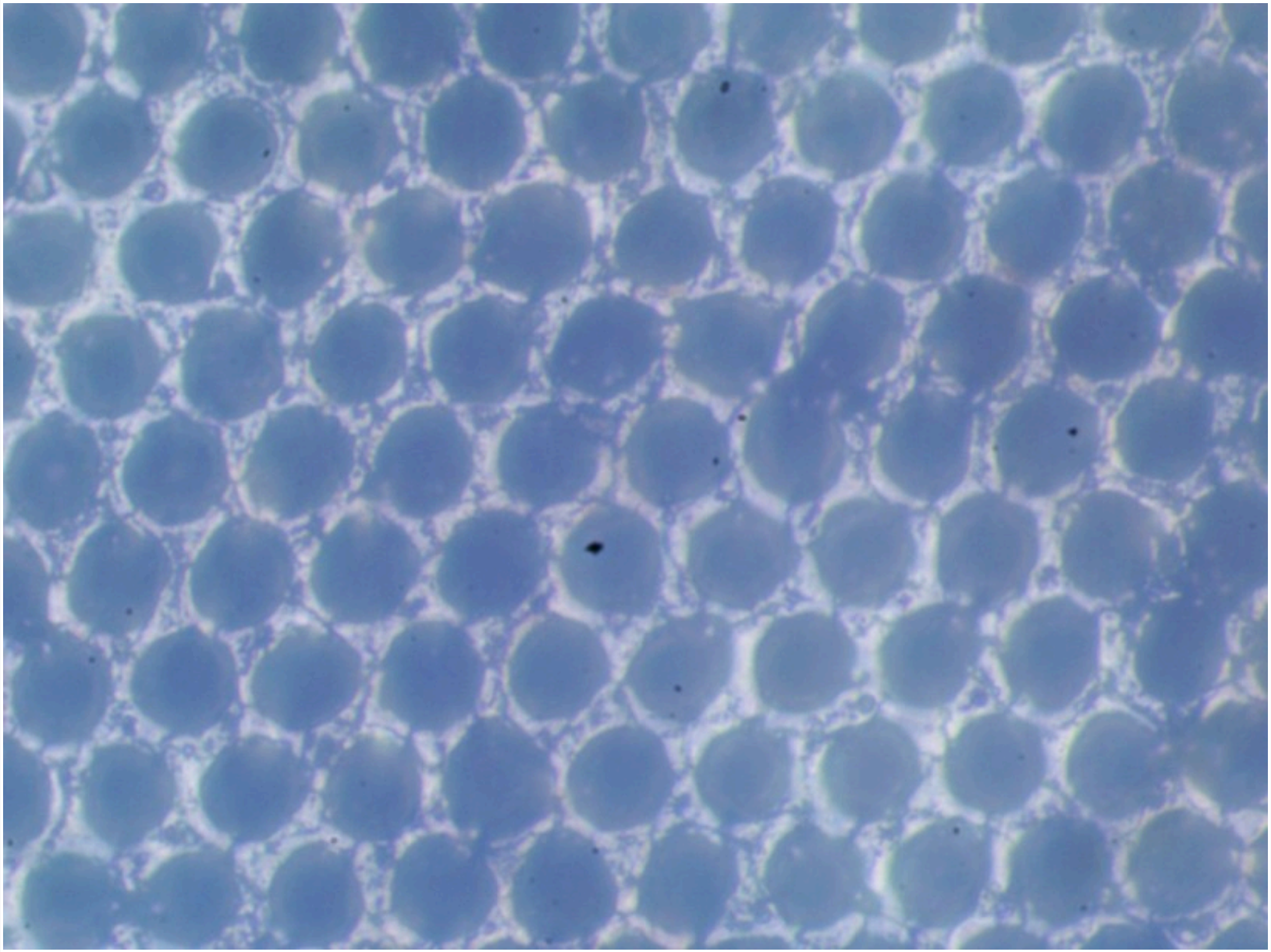
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10.53%

Bridge / Cell: 1 / 6
Depth before / after: 11.5 / 11.5 µm
Depth decreased by: 0%

Comment
radial doctor-blade streaks.
Roll is worn.



Page №3. Roll "sd007094". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sd007094".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

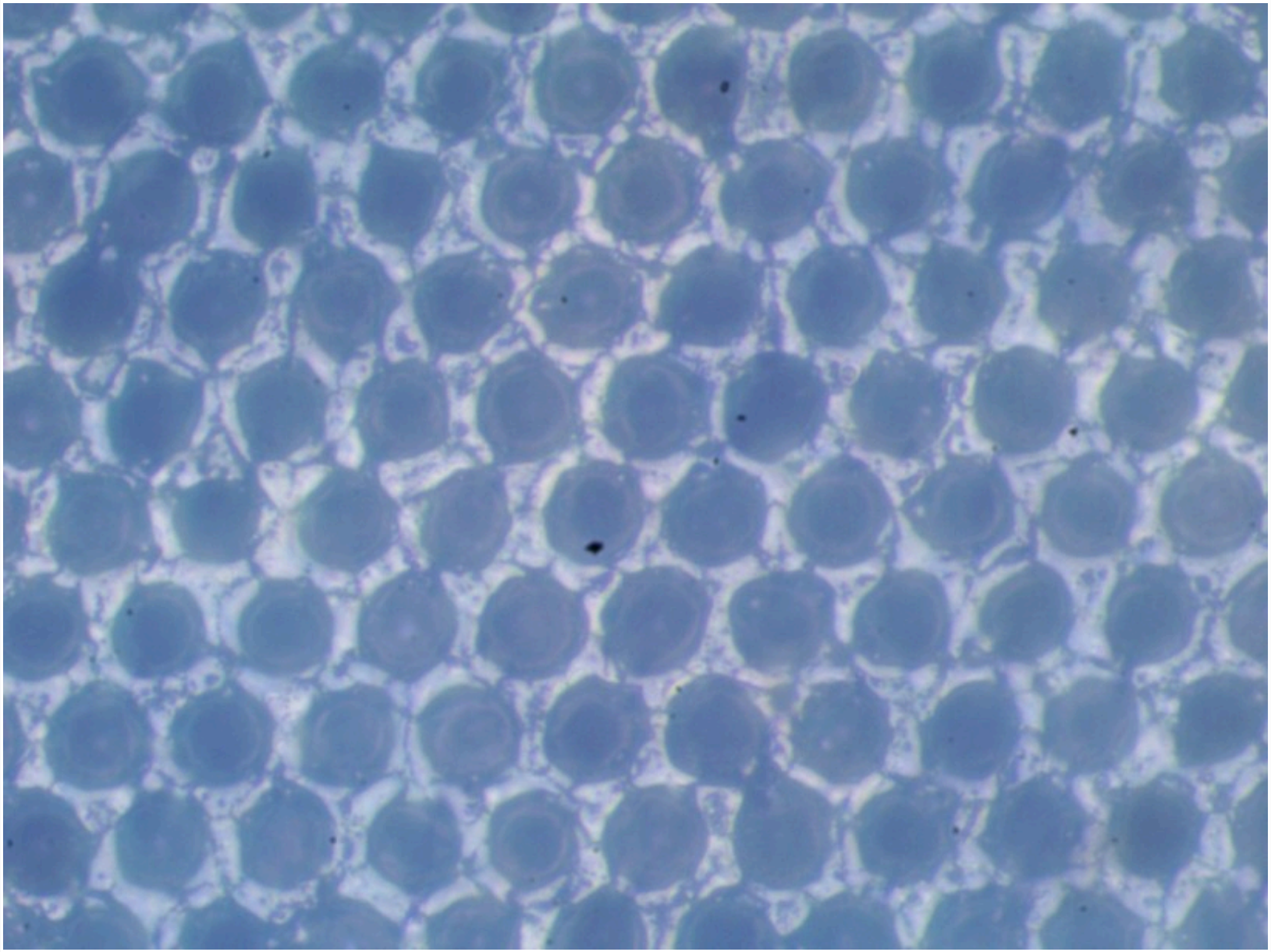
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	2.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 23.68%

Bridge / Cell: 1 / 5
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
radial doctor-blade streaks.
Roll is worn.



Page №4. Roll "h100749-1". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100749-1".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	12.5	cm^3/m^2

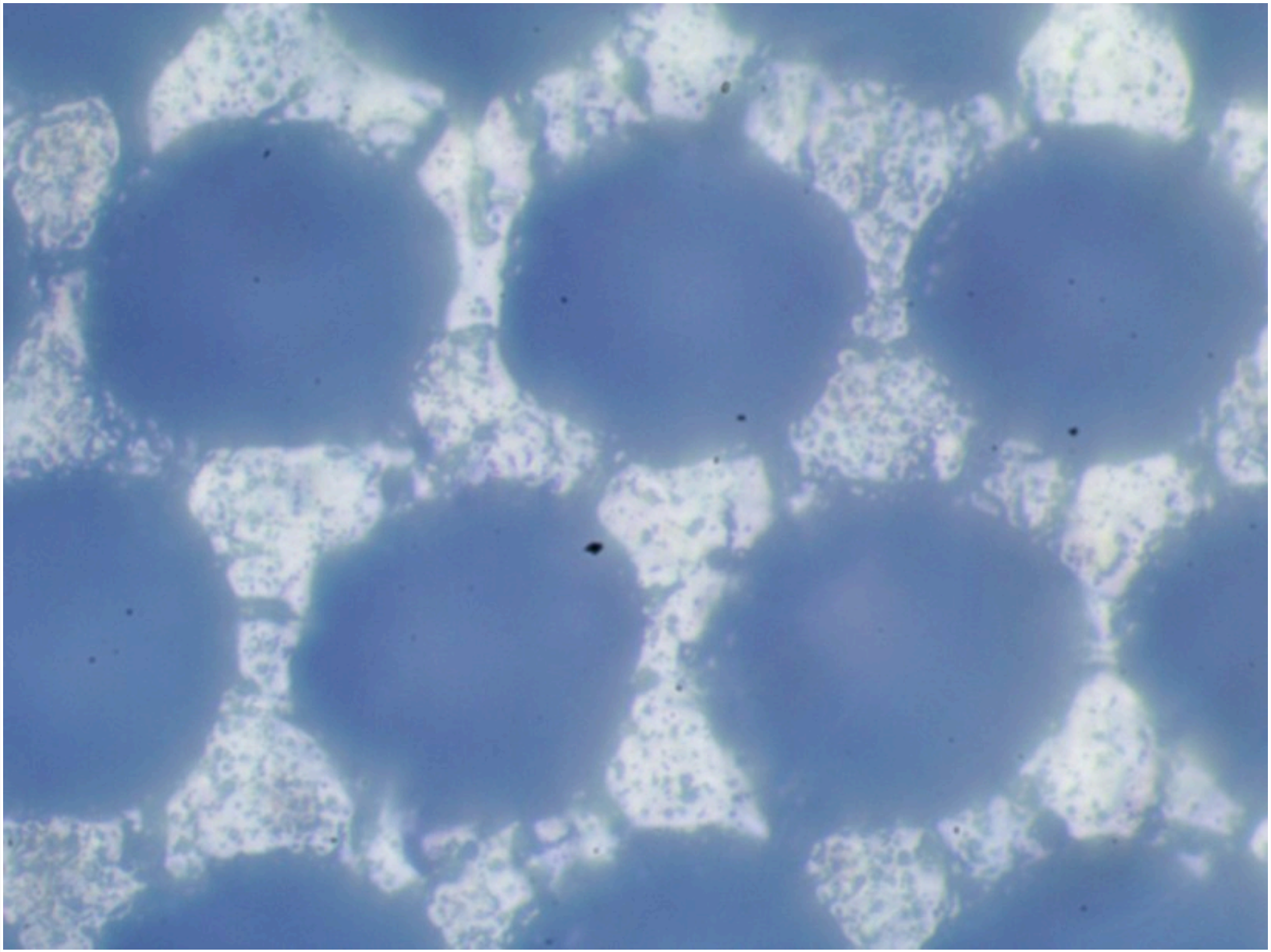
LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	7.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 38.4%

Bridge / Cell: 1 / 9
Depth before / after: 24 / 24 µm
Depth decreased by: 0%

Comment
streak 225 scratches 425 1250 spot 510 400.



Page №5. Roll "ds007093". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "ds007093".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

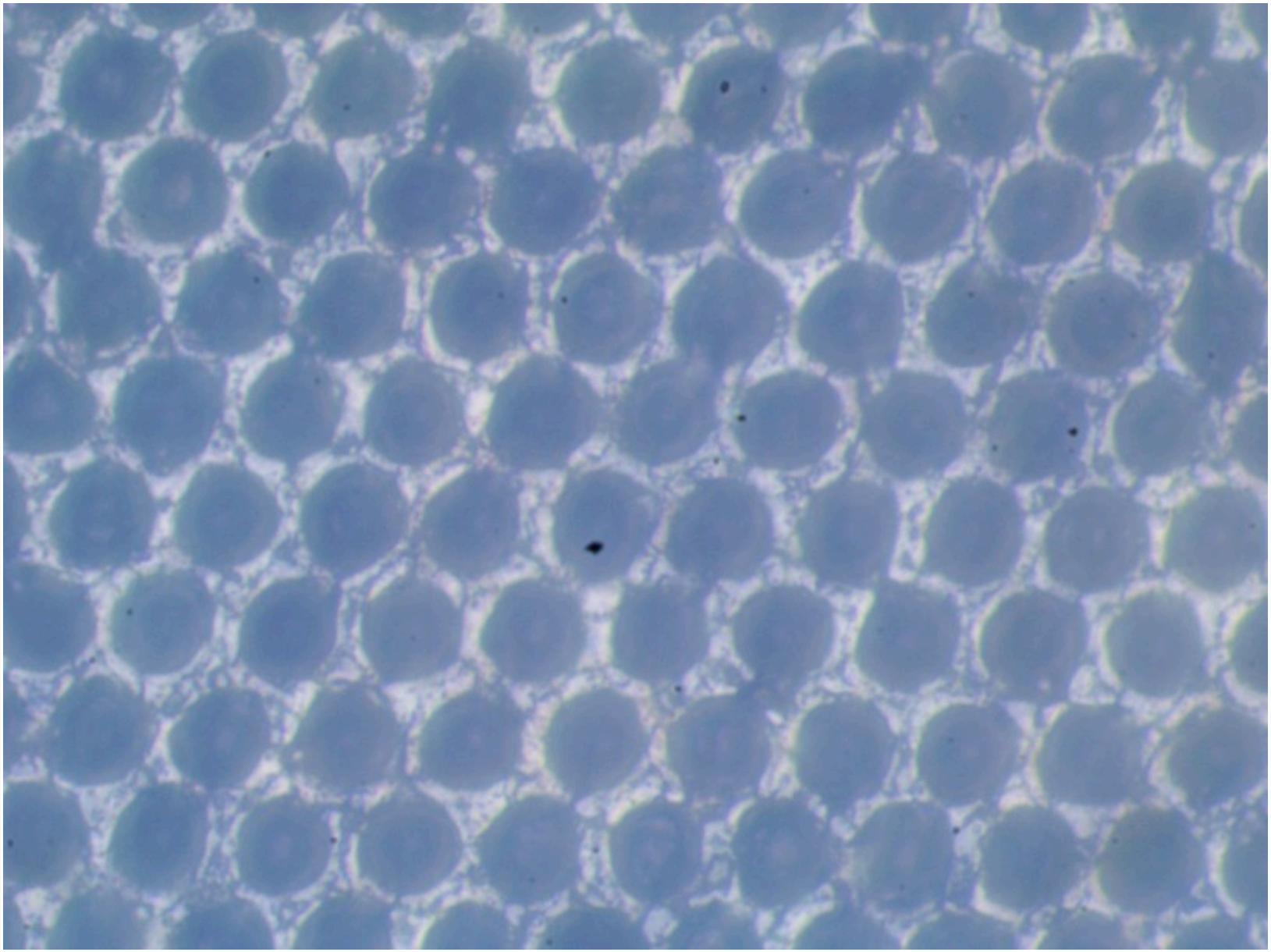
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10.53%

Bridge / Cell: 1 / 5
Depth before / after: 13 / 13 µm
Depth decreased by: 0%

Comment
dent 700 spots streaks.
Roll is worn.



Page №6. Roll "h100479-4". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100479-4".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

LEC measurements by Troika:

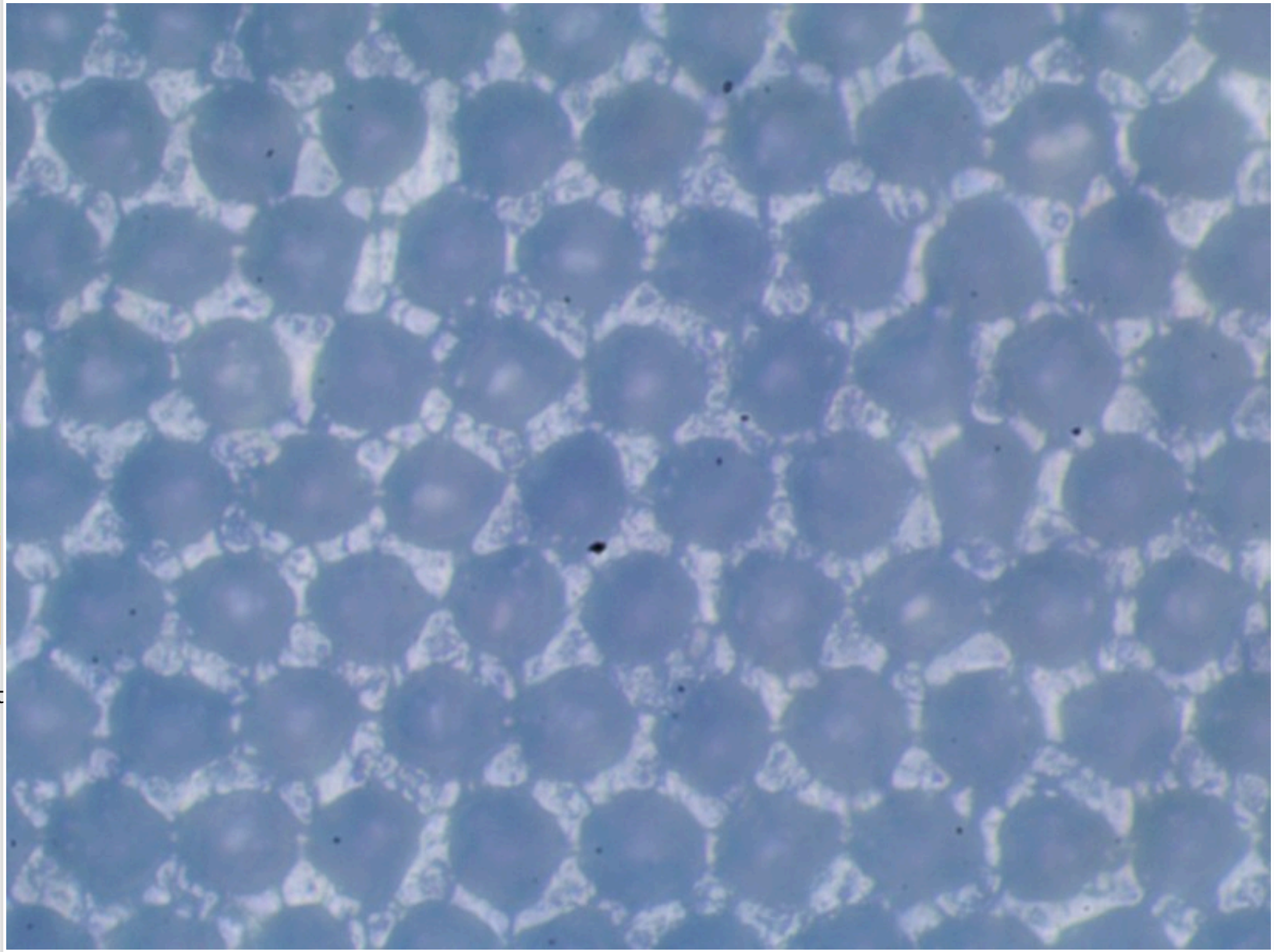
Measured line screen	420	lpcm
Vol	3.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 5%

Bridge / Cell: 1 / 5
Depth before / after: 14 / 14 µm
Depth decreased by: 0%

Comment
streaks 240 490 640 650 725 965 dent 315.

Roll is worn.



Page №7. Roll "3016196-1". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "3016196-1".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	10.0	cm^3/m^2

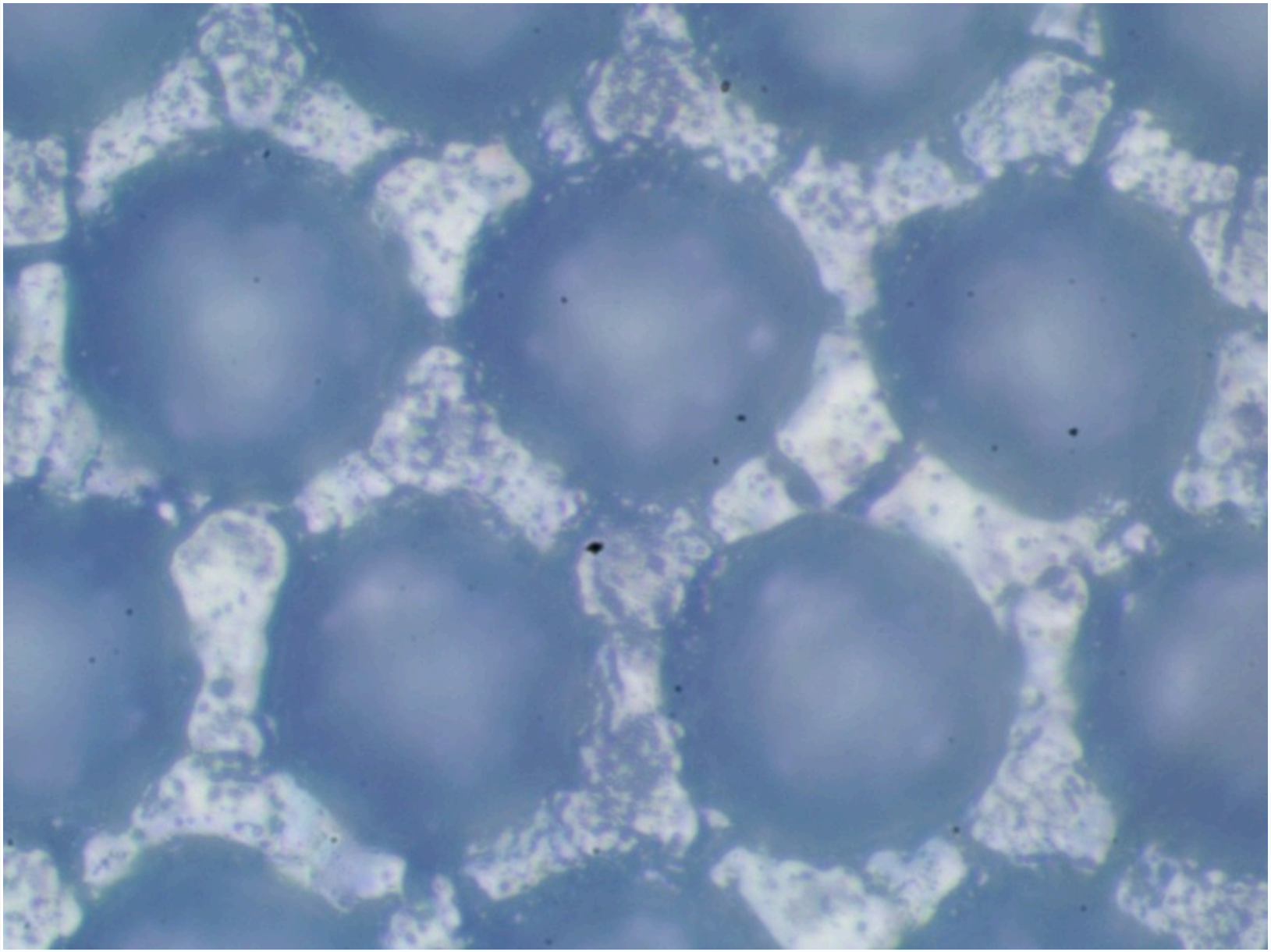
LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	7.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 27%

Bridge / Cell: 1 / 9
Depth before / after: 23 / 23 µm
Depth decreased by: 0%

Comment
streak 740.



Page №8. Roll "h100748-1". Length: 870 mm. Photos with magnification: x200. Cleaning passes: 1

Roll "h100748-1".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	130	lpcm
Vol	13.5	cm^3/m^2

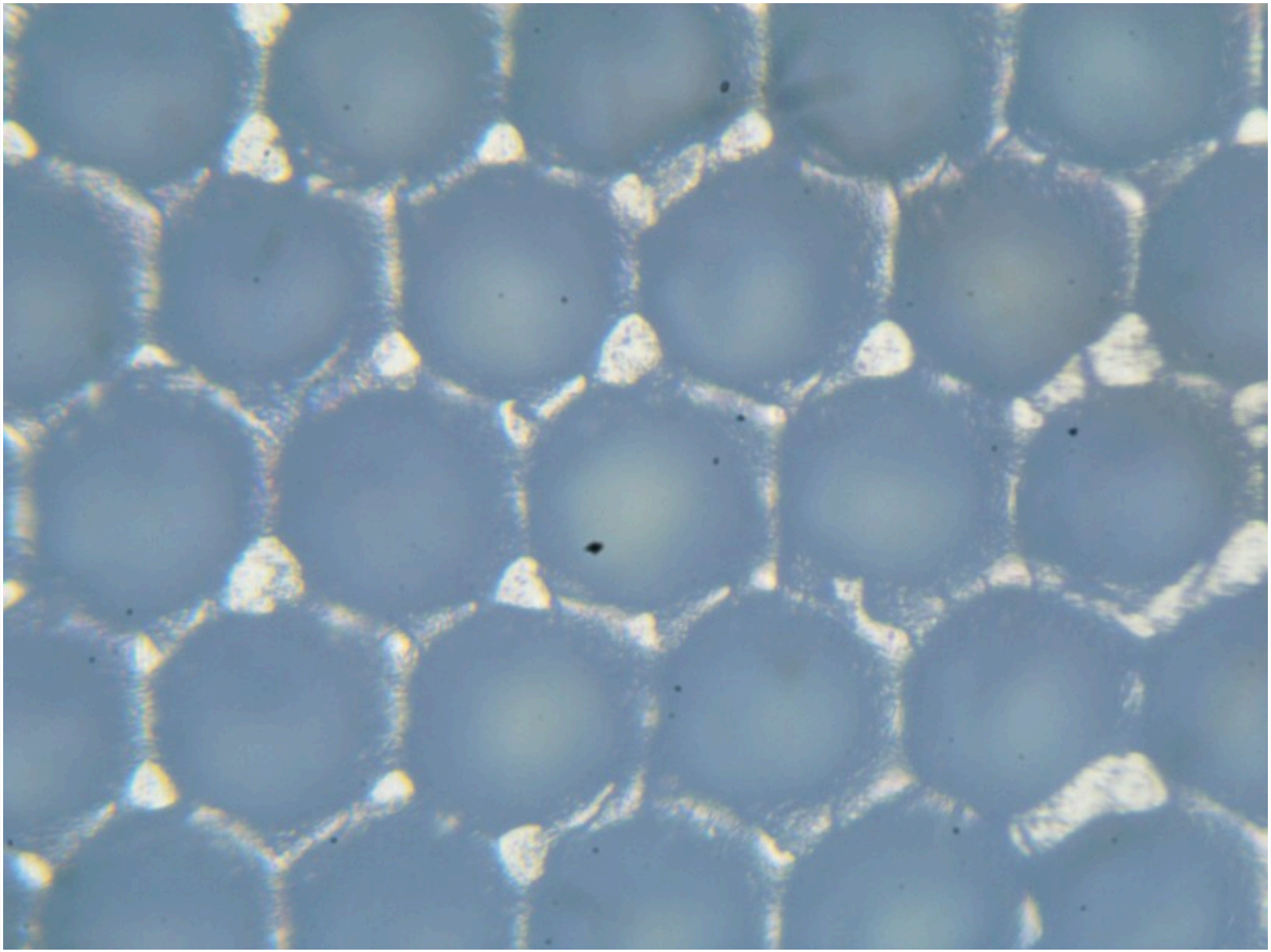
LEC measurements by Troika:

Measured line screen	130	lpcm
Vol	11.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 16.3%

Bridge / Cell: 1 / 18
Depth before / after: 32 / 32 µm
Depth decreased by: 0%

Comment
streaks.



Page №9. Roll "sa008588". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008588".	Photo of the anilox roll surface

Roll designations:

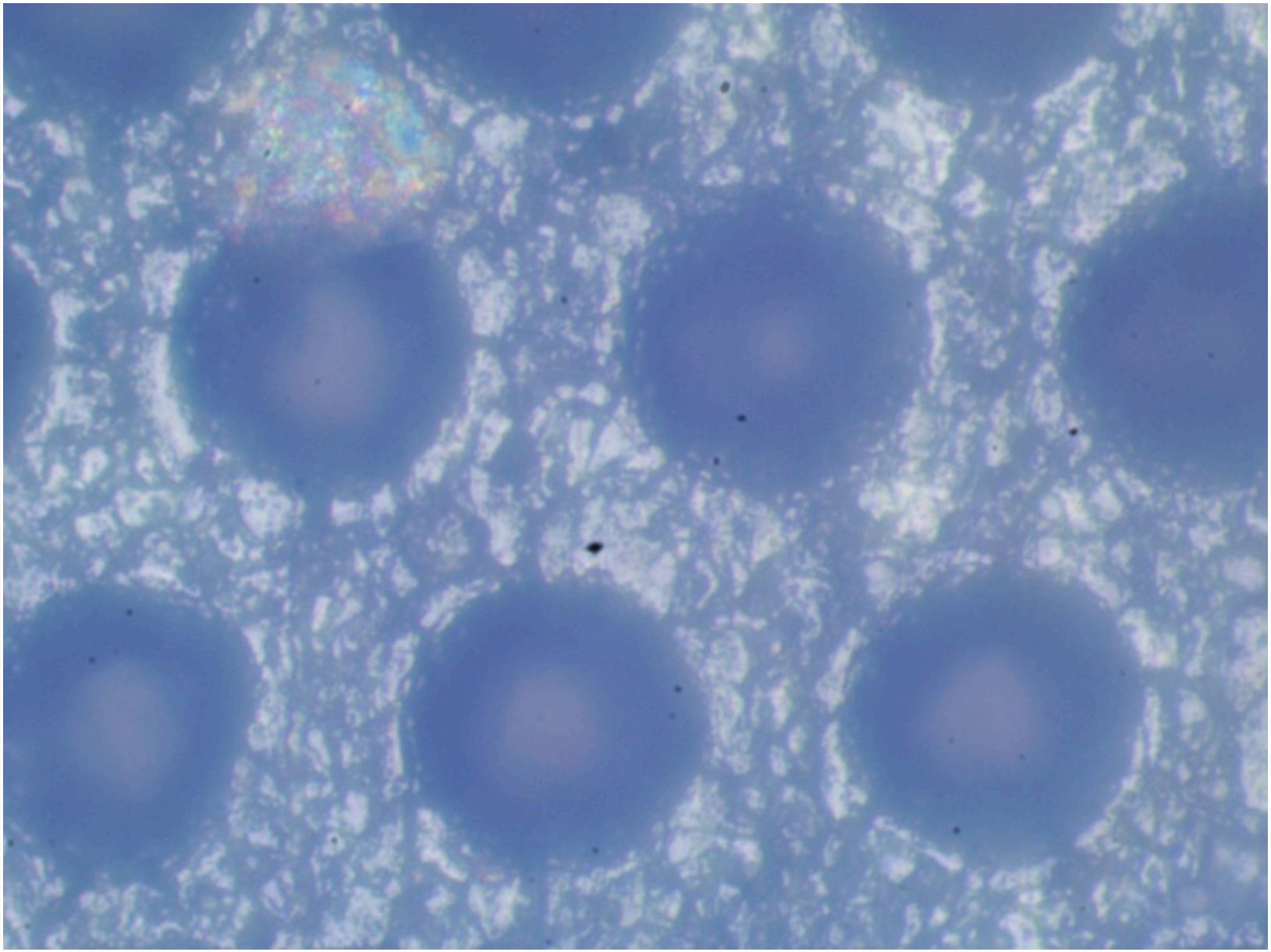
Nominal line screen	130	lpcm
Vol	10.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	130	lpcm
Vol	2.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 73%

Bridge / Cell: 1 / 2
Depth before / after: 14 / 14 µm
Depth decreased by: 0%



Comment
worn streaks scratch 1290.
Roll is heavily worn.

Page №10. Roll "kk97627". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "kk97627".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	7.3	cm^3/m^2

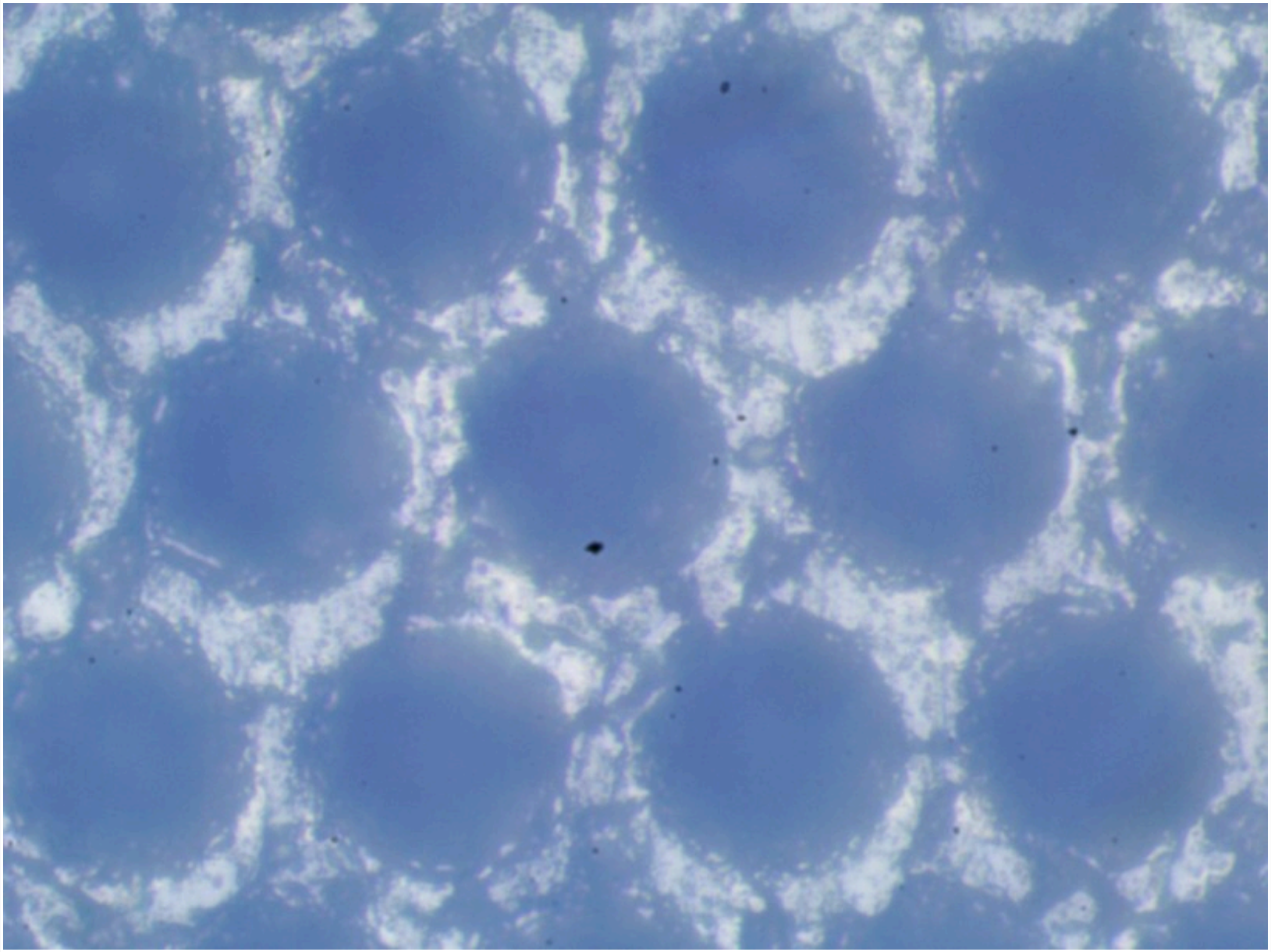
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	5.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 20.55%

Bridge / Cell: 1 / 5
Depth before / after: 22 / 22 µm
Depth decreased by: 0%

Comment
chip 1275 1280 streak 468 947.
Roll is worn.



Page №11. Roll "sa008598". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008598".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.5	cm^3/m^2

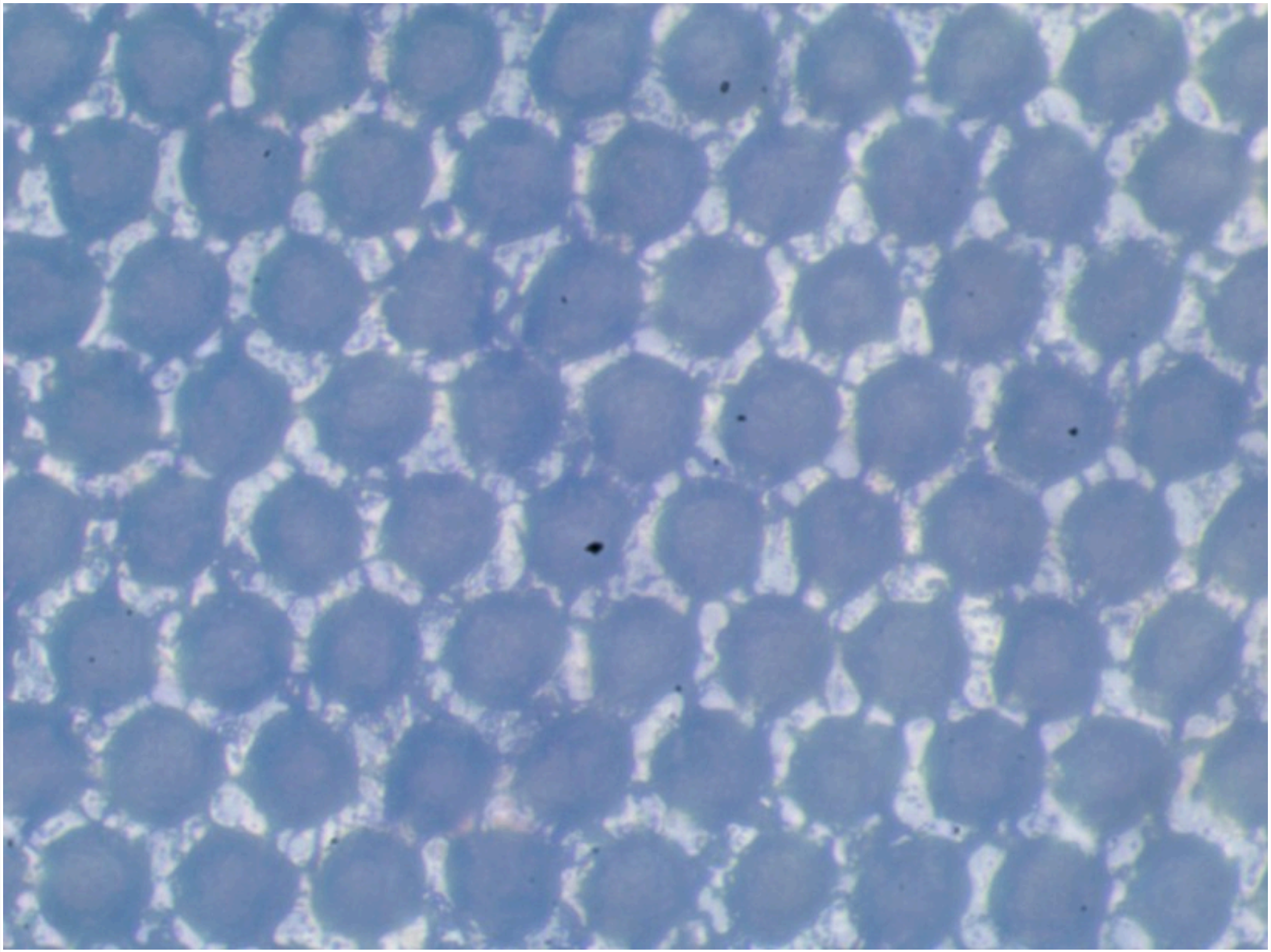
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	4.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 6.67%

Bridge / Cell: 1 / 7
Depth before / after: 14 / 14 µm
Depth decreased by: 0%

Comment
dent 195 250.
Roll is slightly worn.



Page №12. Roll "sa008594". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008594".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	250	lpcm
Vol	7.0	cm^3/m^2

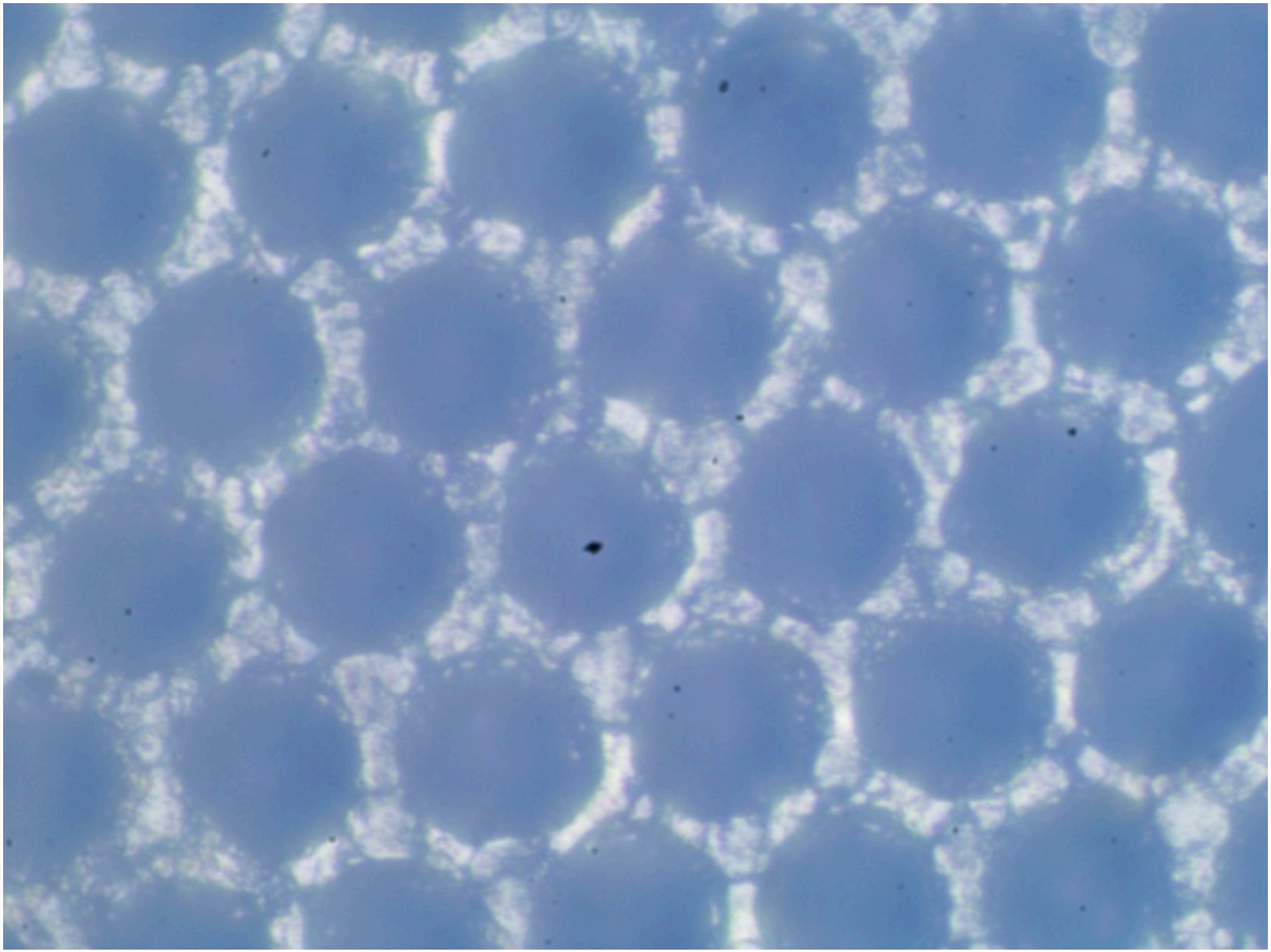
LEC measurements by Troika:

Measured line screen	260	lpcm
Vol	6.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 7.14%

Bridge / Cell: 1 / 6
Depth before / after: 23 / 23 µm
Depth decreased by: 0%

Comment
streak 40 scratch 195 260 chip 1280.
Roll is worn.



Page №13. Roll "sa008596". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008596".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	350	lpcm
Vol	5.5	cm^3/m^2

LEC measurements by Troika:

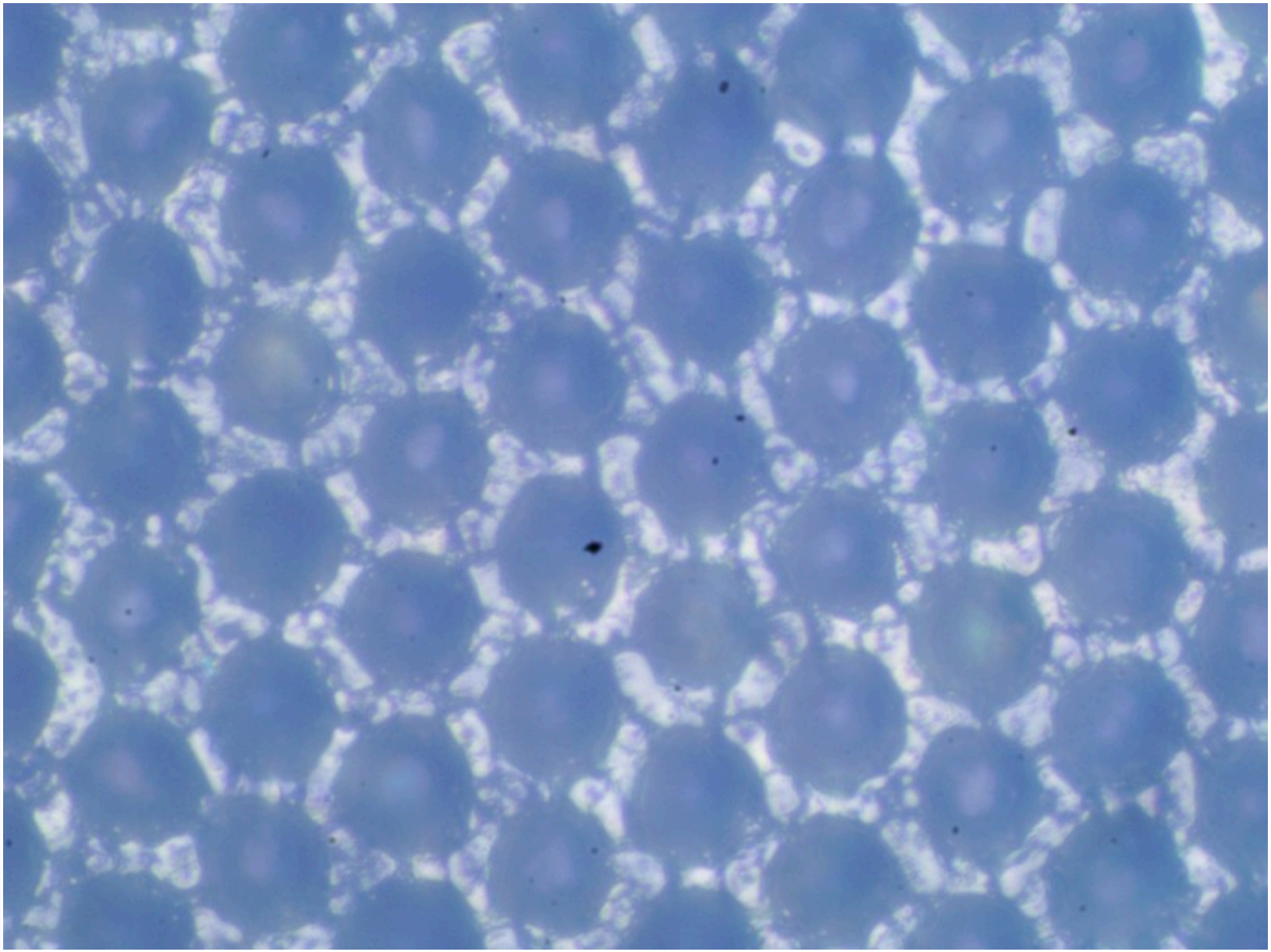
Measured line screen	340	lpcm
Vol	4.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 12.73%

Bridge / Cell: 1 / 6
Depth before / after: 16.5 / 16.5 µm
Depth decreased by: 0%

Comment
scratch 190 145 385 350 1140 1100 chip 230.

Roll is worn.



Page №14. Roll "aa2413108". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413108".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

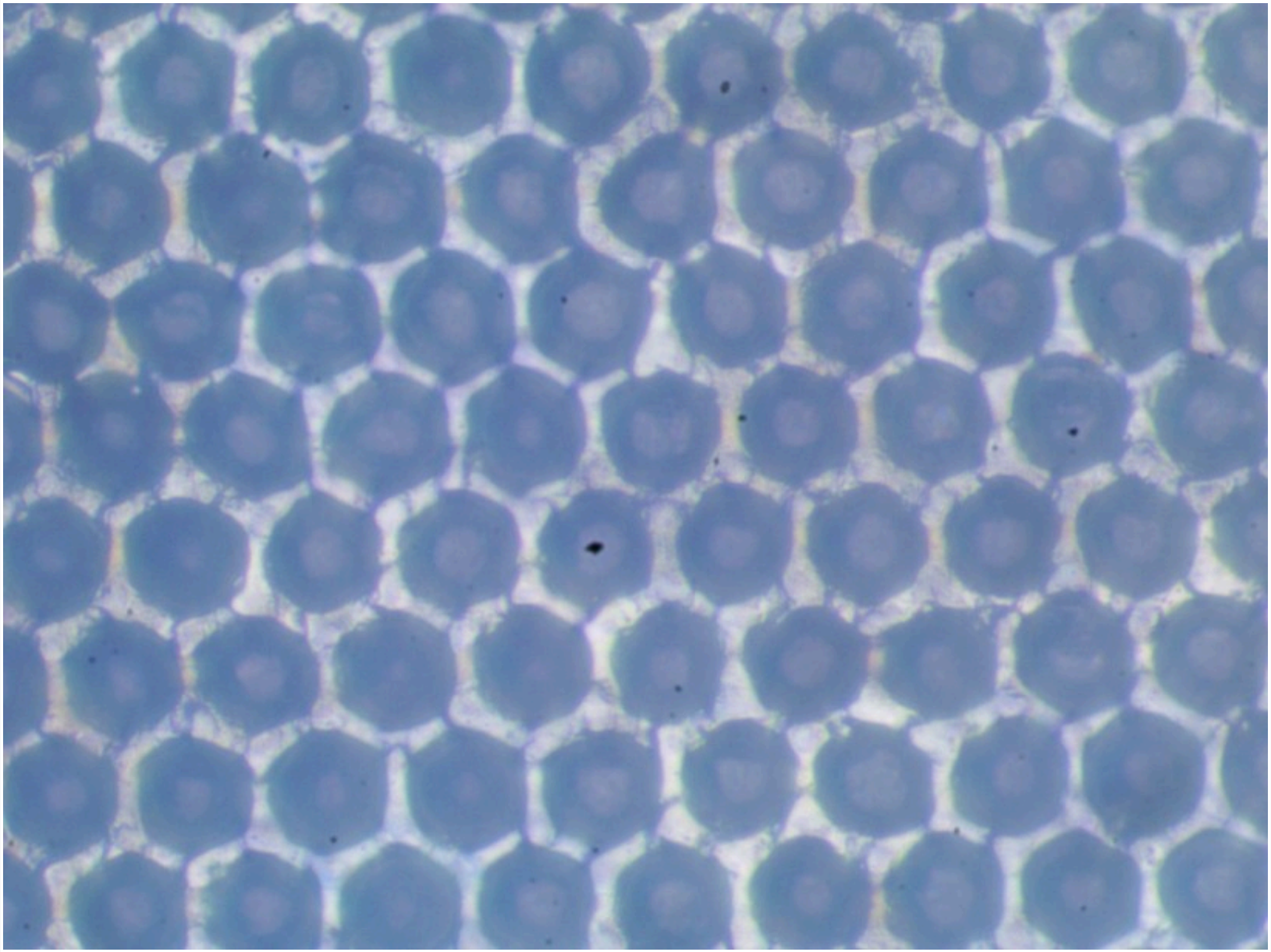
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	4.00	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 7
Depth before / after: 13.5 / 13.5 µm
Depth decreased by: 0%

Comment
streak 165.
Roll is slightly worn.



Page №15. Roll "h100751-9". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100751-9".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	160	lpcm
Vol	10.5	cm^3/m^2

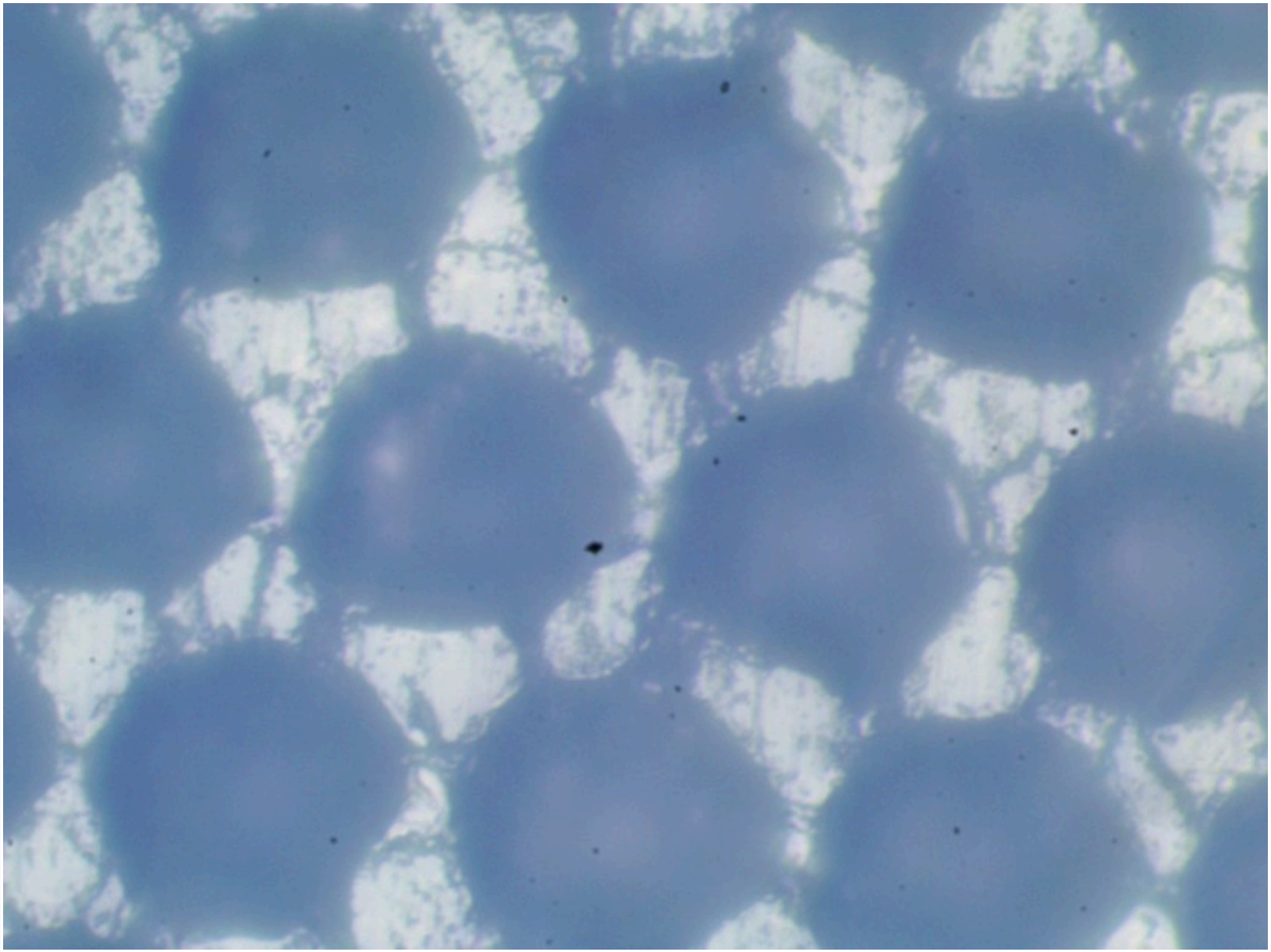
LEC measurements by Troika:

Measured line screen	160	lpcm
Vol	7.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 25.71%

Bridge / Cell: 1 / 5
Depth before / after: 28 / 28 µm
Depth decreased by: 0%

Comment
scratch 40 105 380 410 440.
Roll is worn.



Page №16. Roll "17011017". Length: 1300 mm. Photos with magnification: x200. Cleaning passes: 1

Roll "17011017".	Photo of the anilox roll surface

Roll designations:

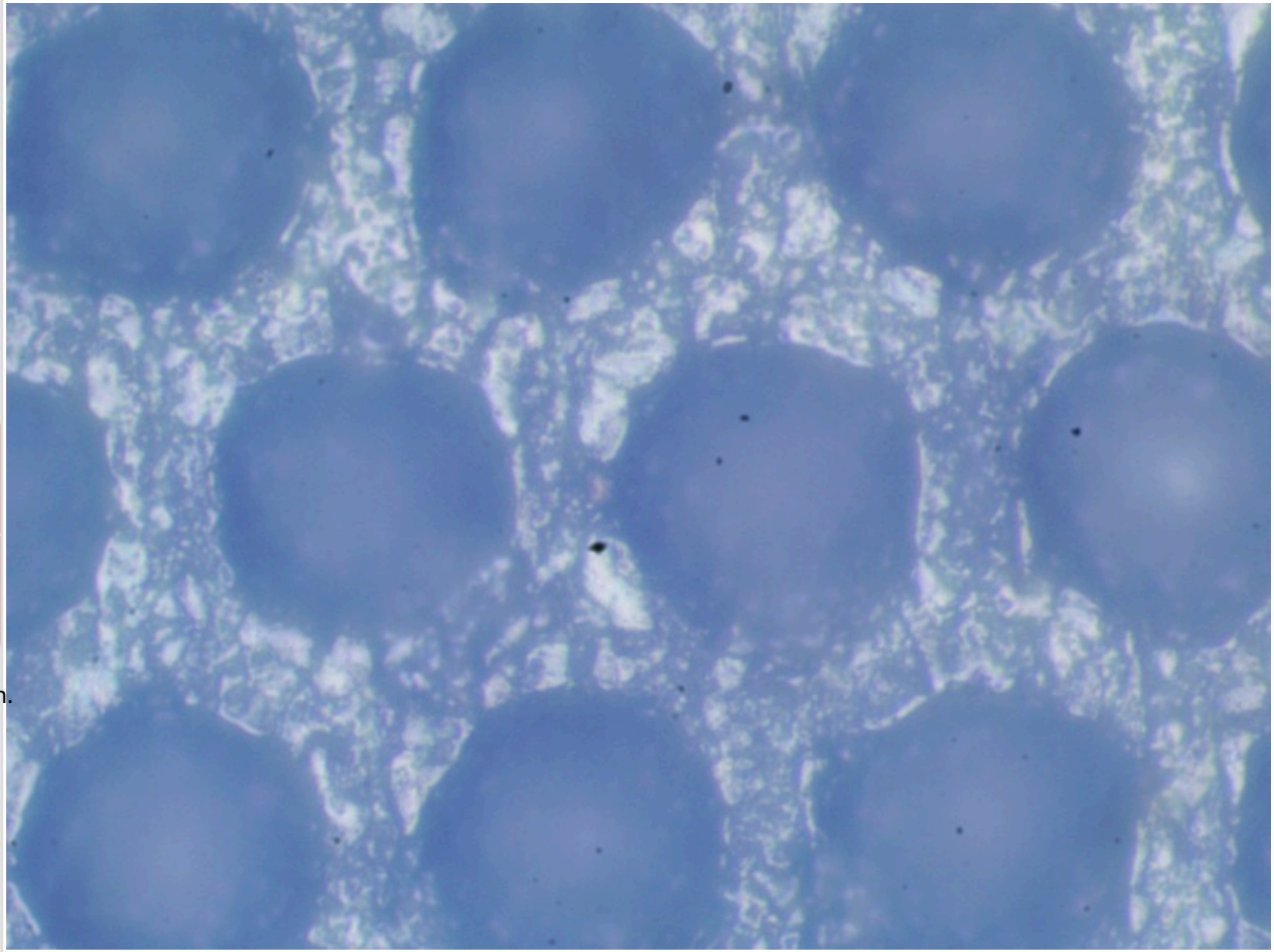
Nominal line screen	140	lpcm
Vol	9.2	cm^3/m^2

LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	4.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 52.17%

Bridge / Cell: 1 / 3
Depth before / after: 21 / 21 µm
Depth decreased by: 0%



Comment
scratch 145 dent 15 105 165 294 worn.

Roll is heavily worn.

Page №17. Roll "h100750-7". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100750-7".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	12.5	cm^3/m^2

LEC measurements by Troika:

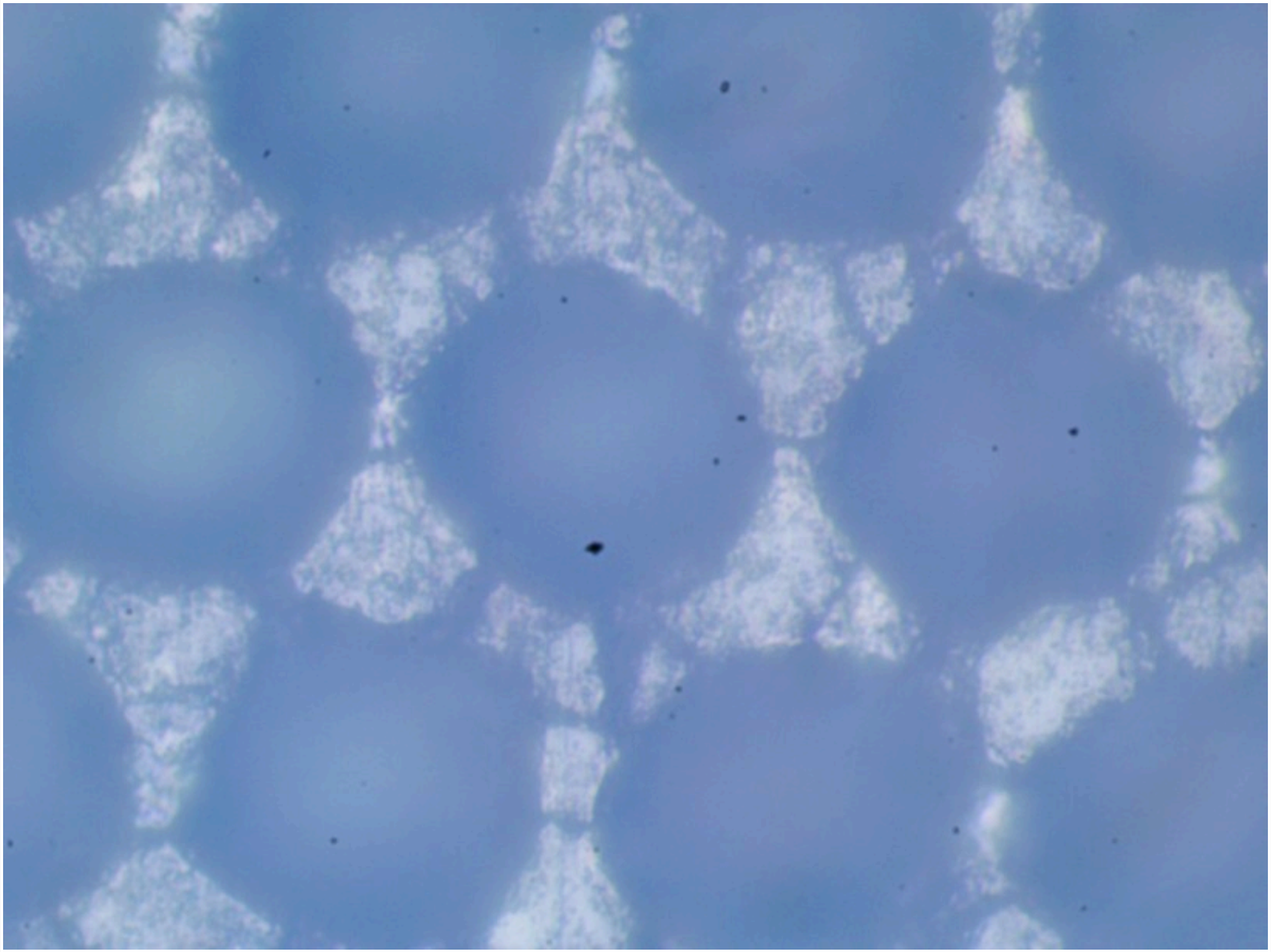
Measured line screen	140	lpcm
Vol	9.00	cm^3/m^2

Ink transfer volume decrease from the nominal value: 28%

Bridge / Cell: 1 / 6
Depth before / after: 31 / 31 µm
Depth decreased by: 0%

Comment
dent 290 245 320 streak 520 700 520 scratch 570.

Roll is worn.



Page №18. Roll "z45231". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z45231".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	9.1	cm^3/m^2

LEC measurements by Troika:

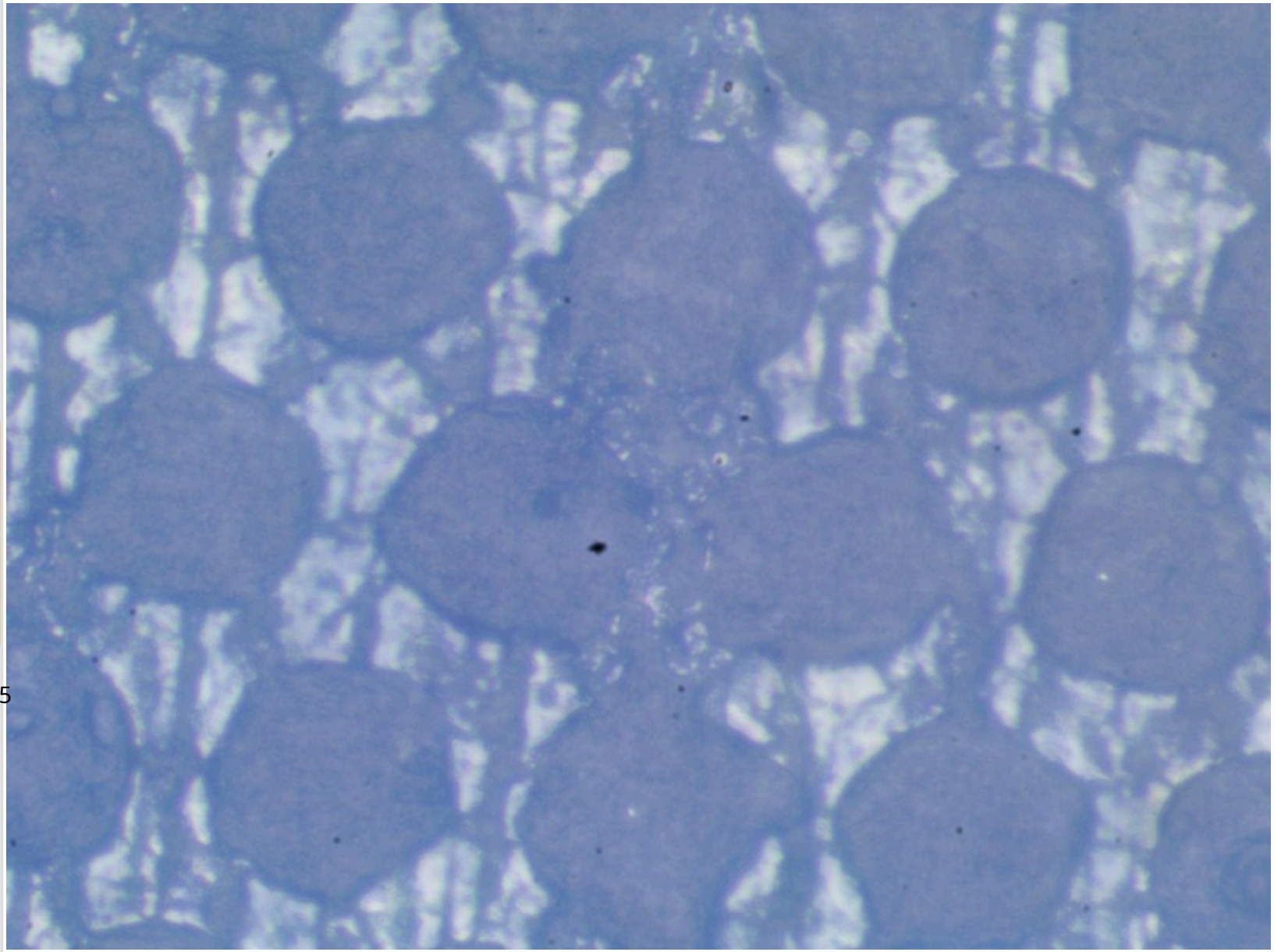
Measured line screen	180	lpcm
Vol	4.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 47.25%

Bridge / Cell: 1 / 4
Depth before / after: 20 / 20 µm
Depth decreased by: 0%

Comment
streaks spot 290 400 770 520 dent 975 920 worn.

Roll is worn.



Page №19. Roll "sa008622". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008622".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	300	lpcm
Vol	6.5	cm^3/m^2

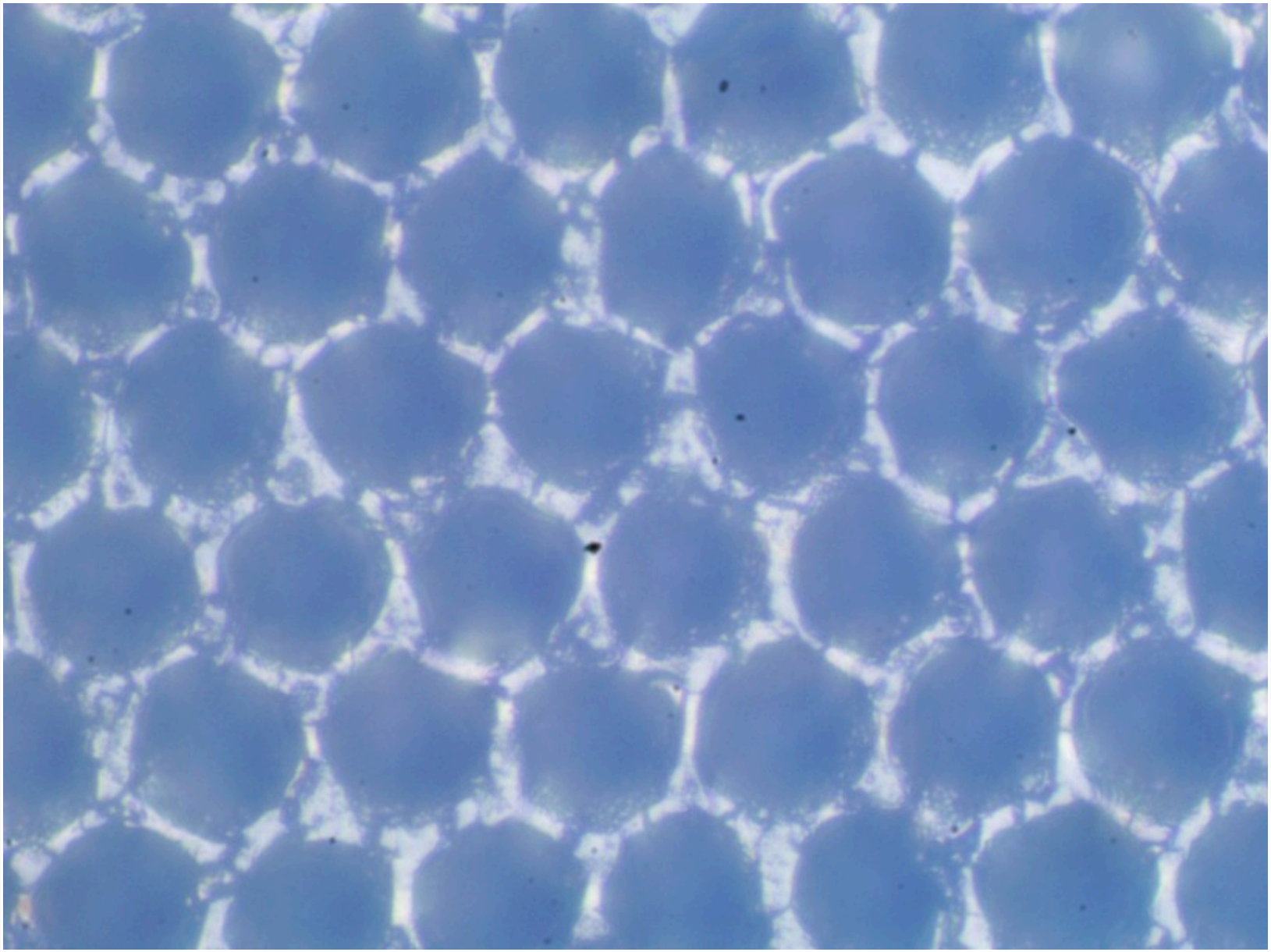
LEC measurements by Troika:

Measured line screen	300	lpcm
Vol	5.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 15.38%

Bridge / Cell: 1 / 10
Depth before / after: 17 / 17 µm
Depth decreased by: 0%

Comment
streak 740 220.



Page №20. Roll "sa008600". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008600".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

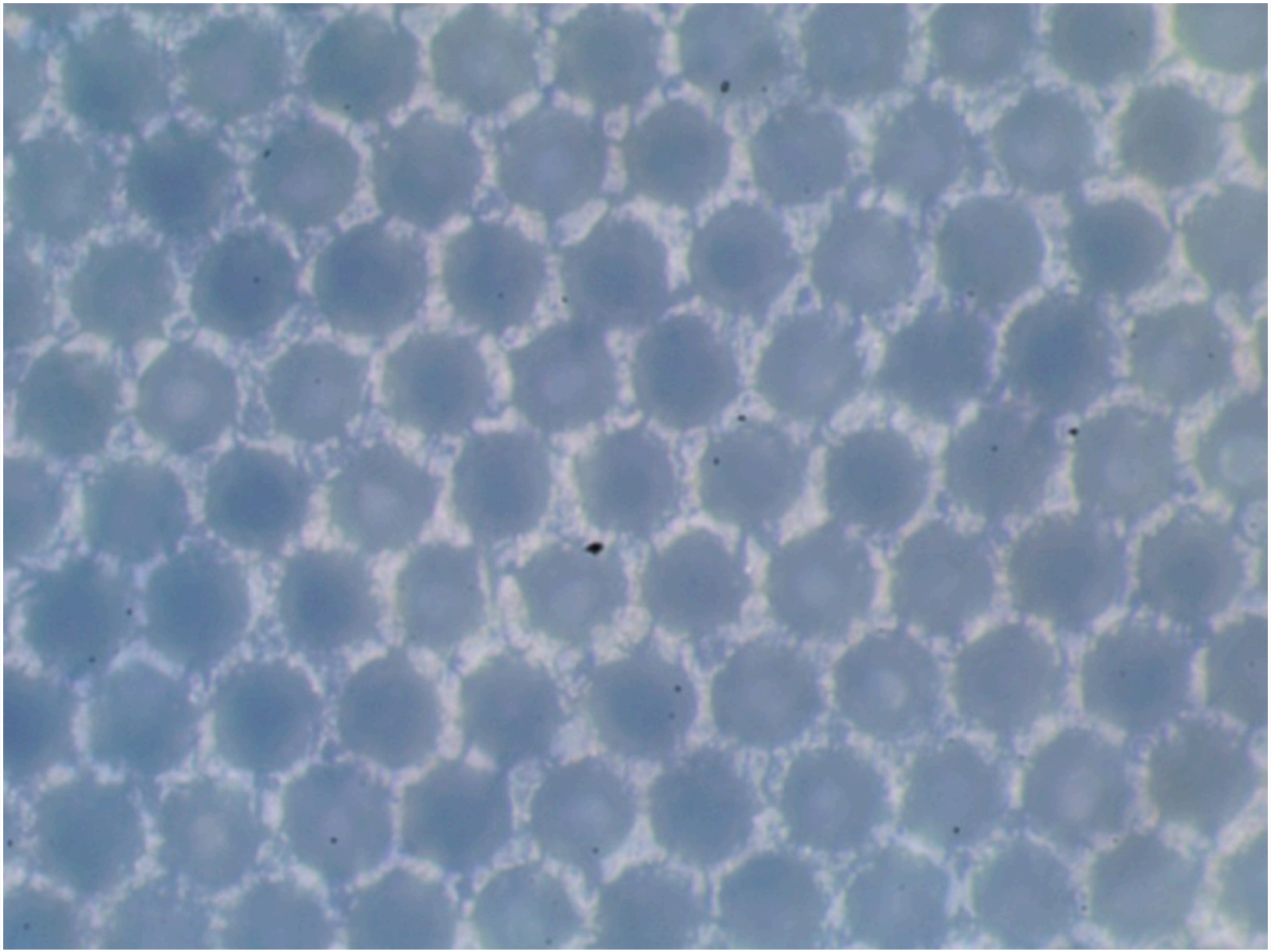
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.80	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 6
Depth before / after: 13.5 / 13.5 µm
Depth decreased by: 0%

Comment
streaks 315 360 365 1265.
Roll is worn.



Page №21. Roll "z17011023". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011023".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.7	cm^3/m^2

LEC measurements by Troika:

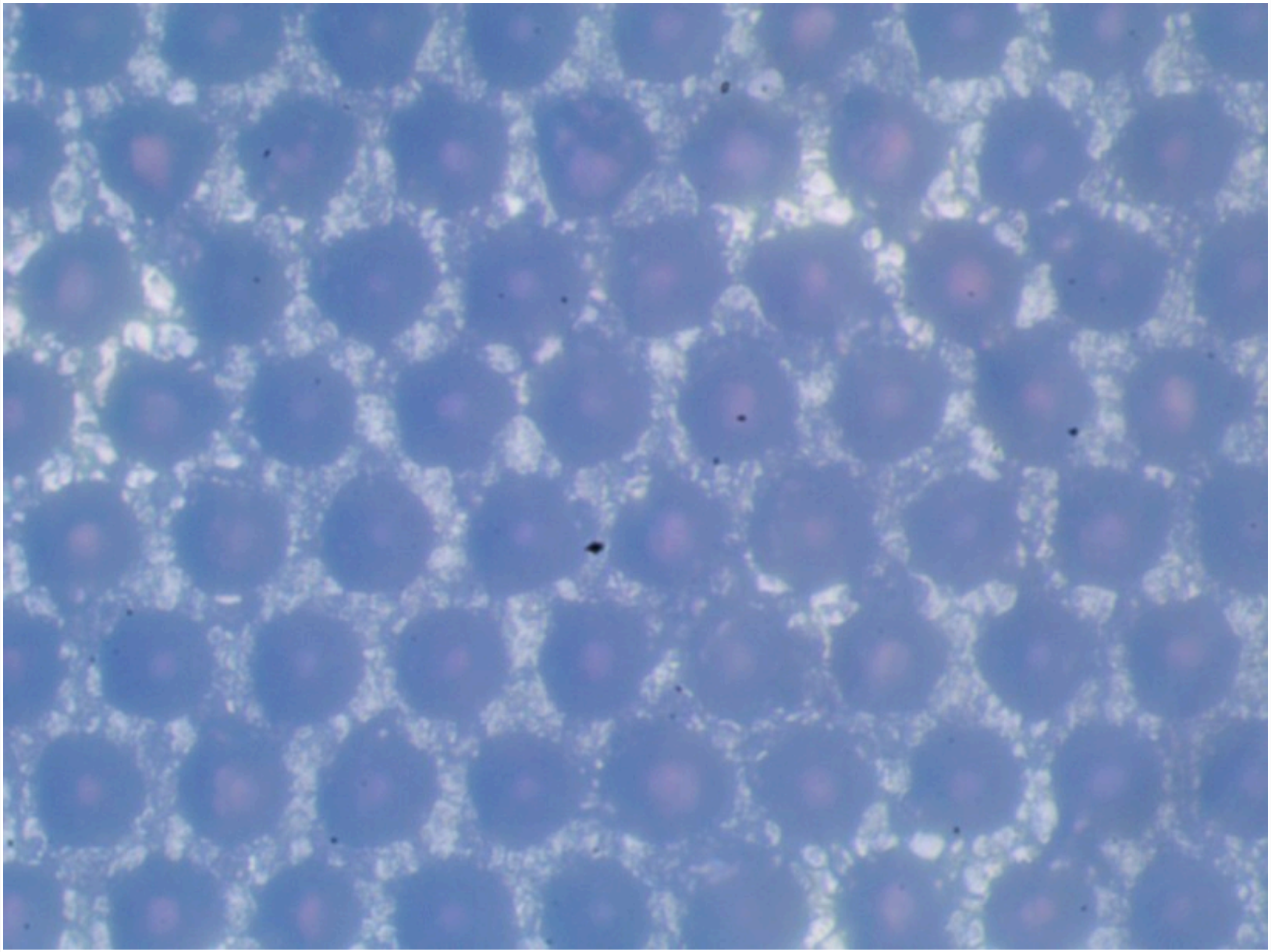
Measured line screen	400	lpcm
Vol	3.00	cm^3/m^2

Ink transfer volume decrease from the nominal value: 18.92%

Bridge / Cell: 1 / 5
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
dent 1170 1230 1305 190 200 streak 77 1153.

Roll is worn.



Page №22. Roll "3016199-3". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "3016199-3".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	380	lpcm
Vol	5.0	cm^3/m^2

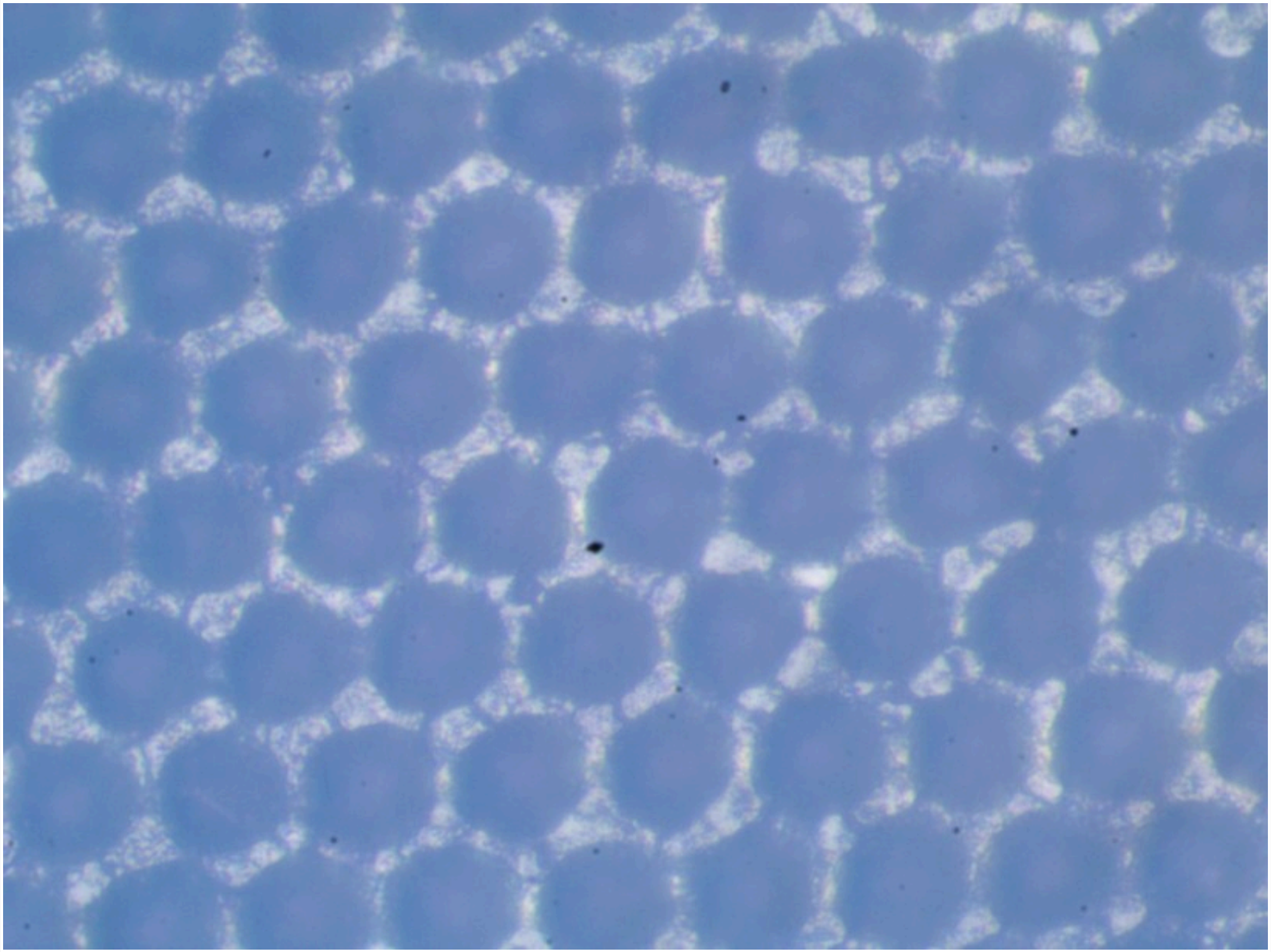
LEC measurements by Troika:

Measured line screen	360	lpcm
Vol	4.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 8%

Bridge / Cell: 1 / 6
Depth before / after: 16 / 16 µm
Depth decreased by: 0%

Comment
Roll is worn.



Page №23. Roll "sa008591". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008591".	Photo of the anilox roll surface

Roll designations:

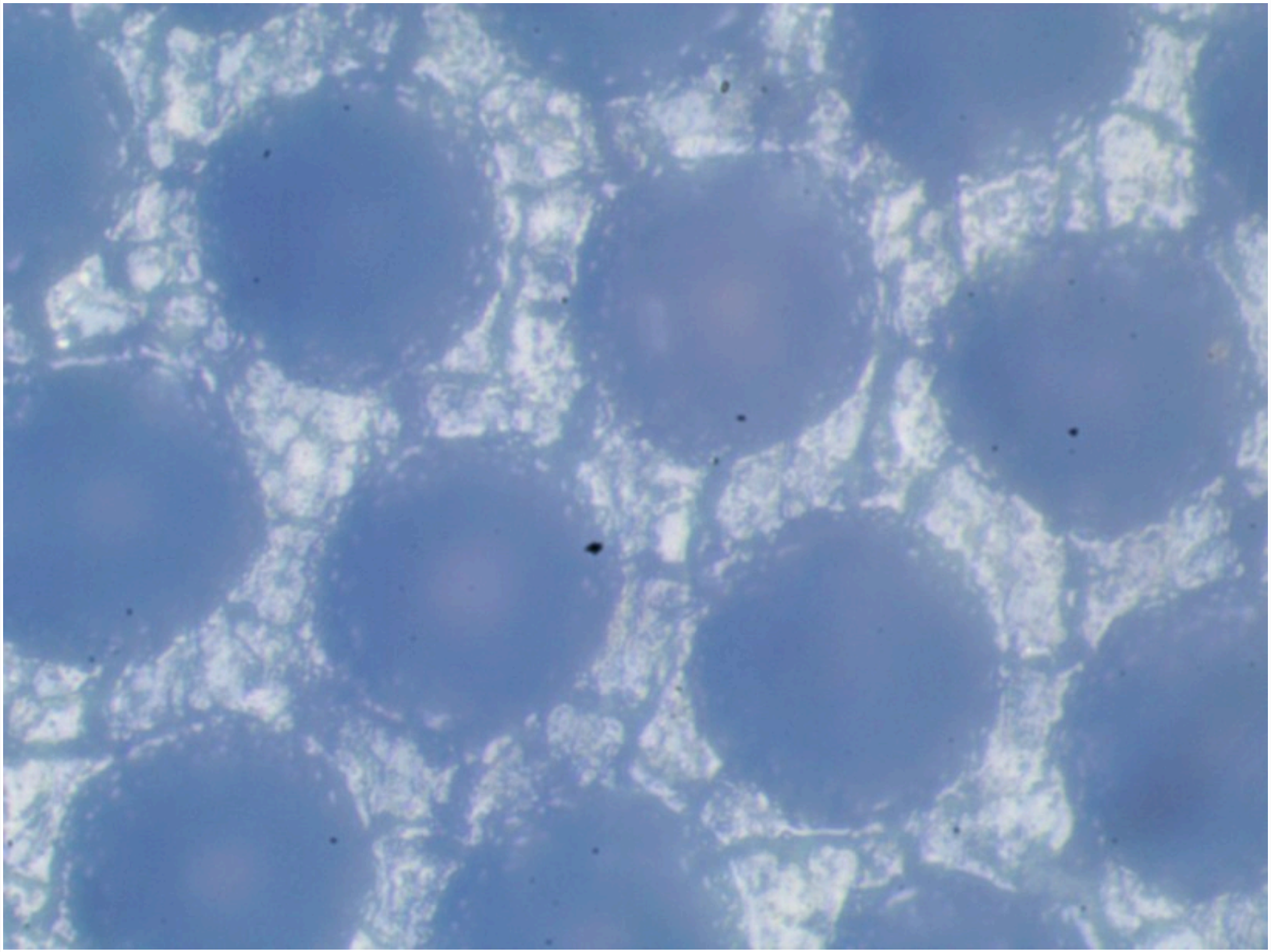
Nominal line screen	150	lpcm
Vol	9.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	150	lpcm
Vol	6.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 30%

Bridge / Cell: 1 / 4
Depth before / after: 26 / 26 µm
Depth decreased by: 0%



Comment
worn streak 880.
Roll is worn.

Page №24. Roll "aa2413645". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413645".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

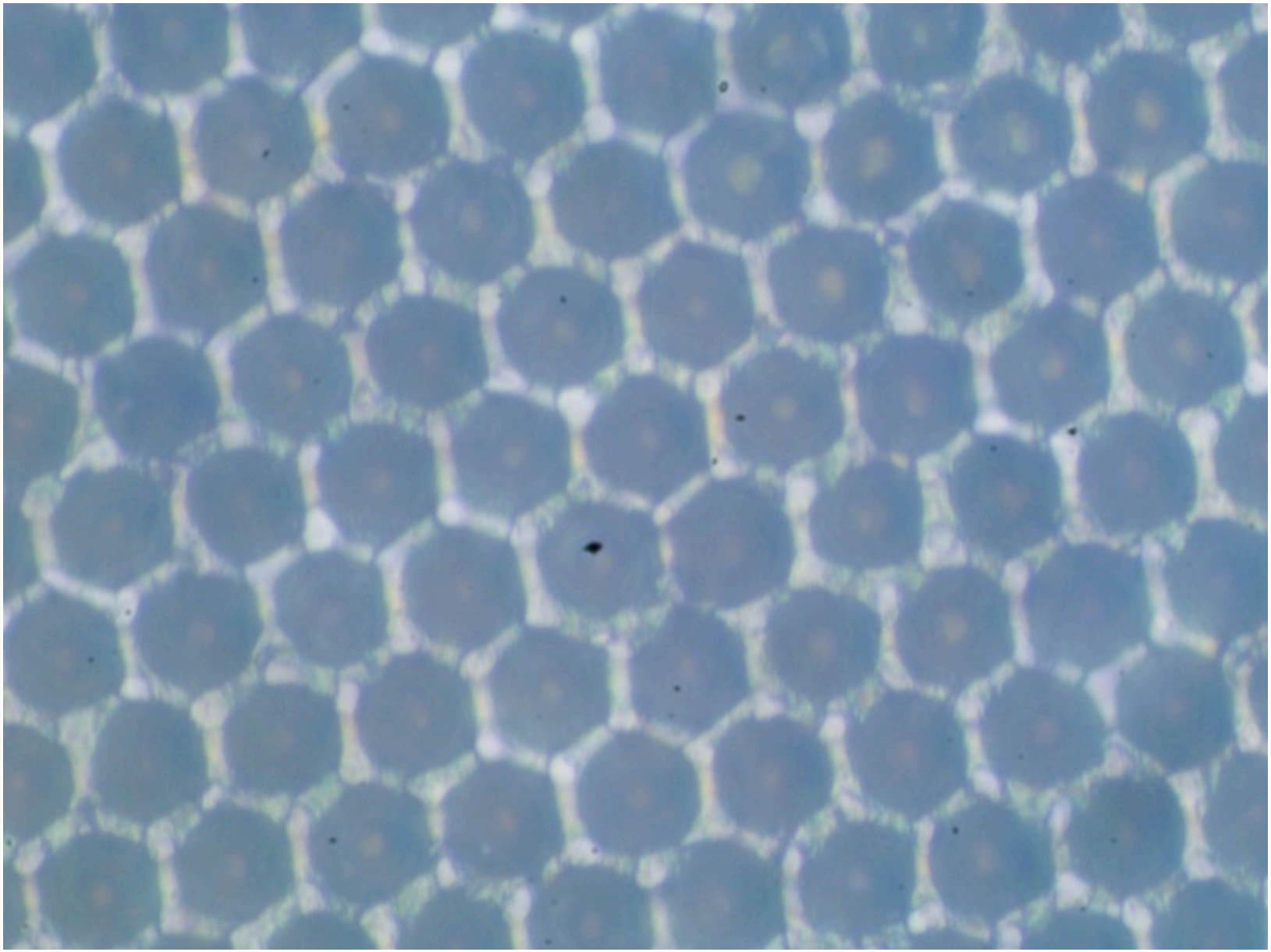
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	4.00	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 4
Depth before / after: 16 / 16 µm
Depth decreased by: 0%

Comment
Roll is worn.



Page №25. Roll "z17011012". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011012".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.6	cm^3/m^2

LEC measurements by Troika:

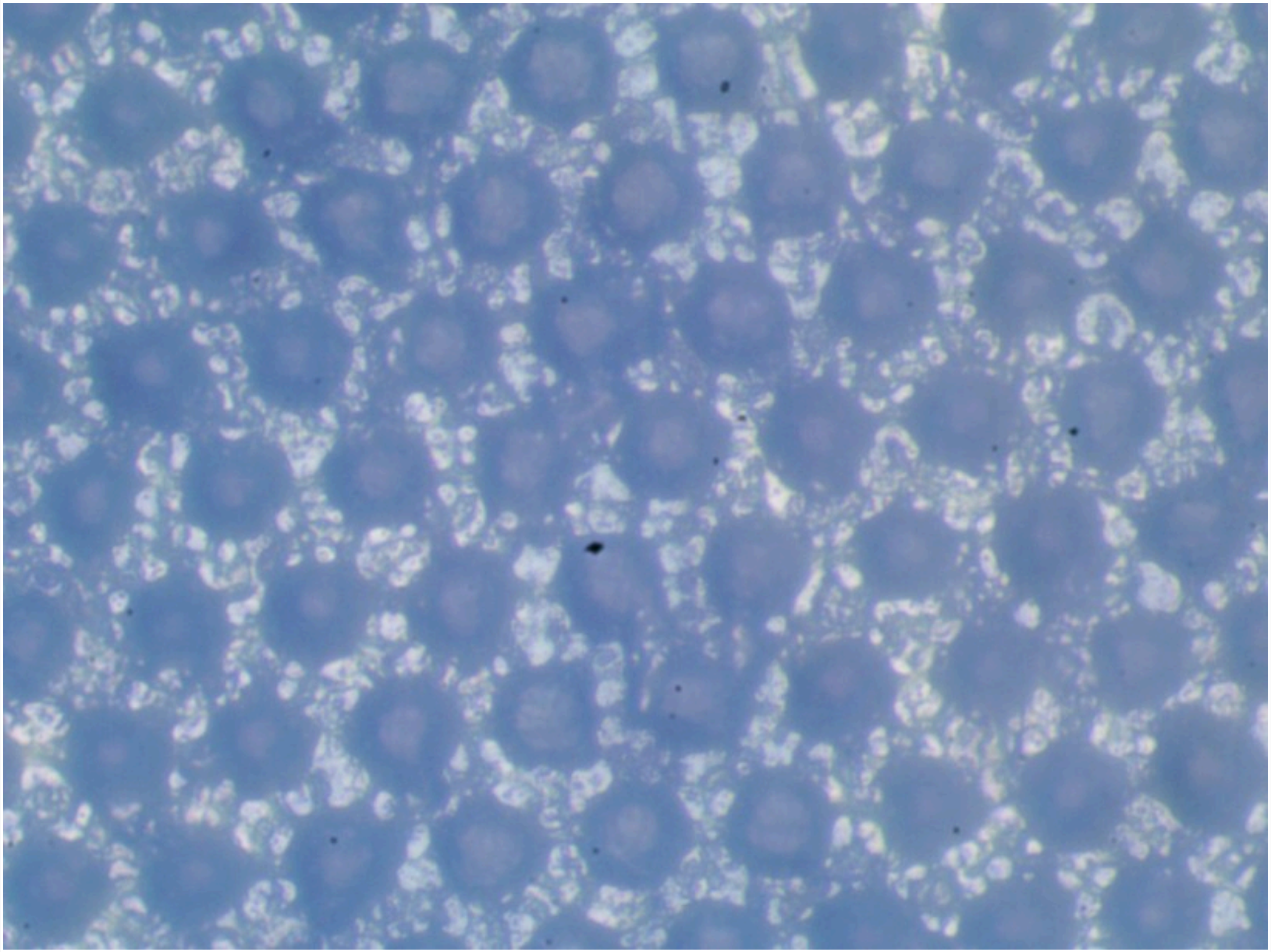
Measured line screen	400	lpcm
Vol	2.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 30.56%

Bridge / Cell: 1 / 3
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
cell walls are missing streak 263 890 dent 415 475 1200

1235 1250 1280 1295.
Roll is heavily worn.



Page №26. Roll "aa2413643". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413643".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

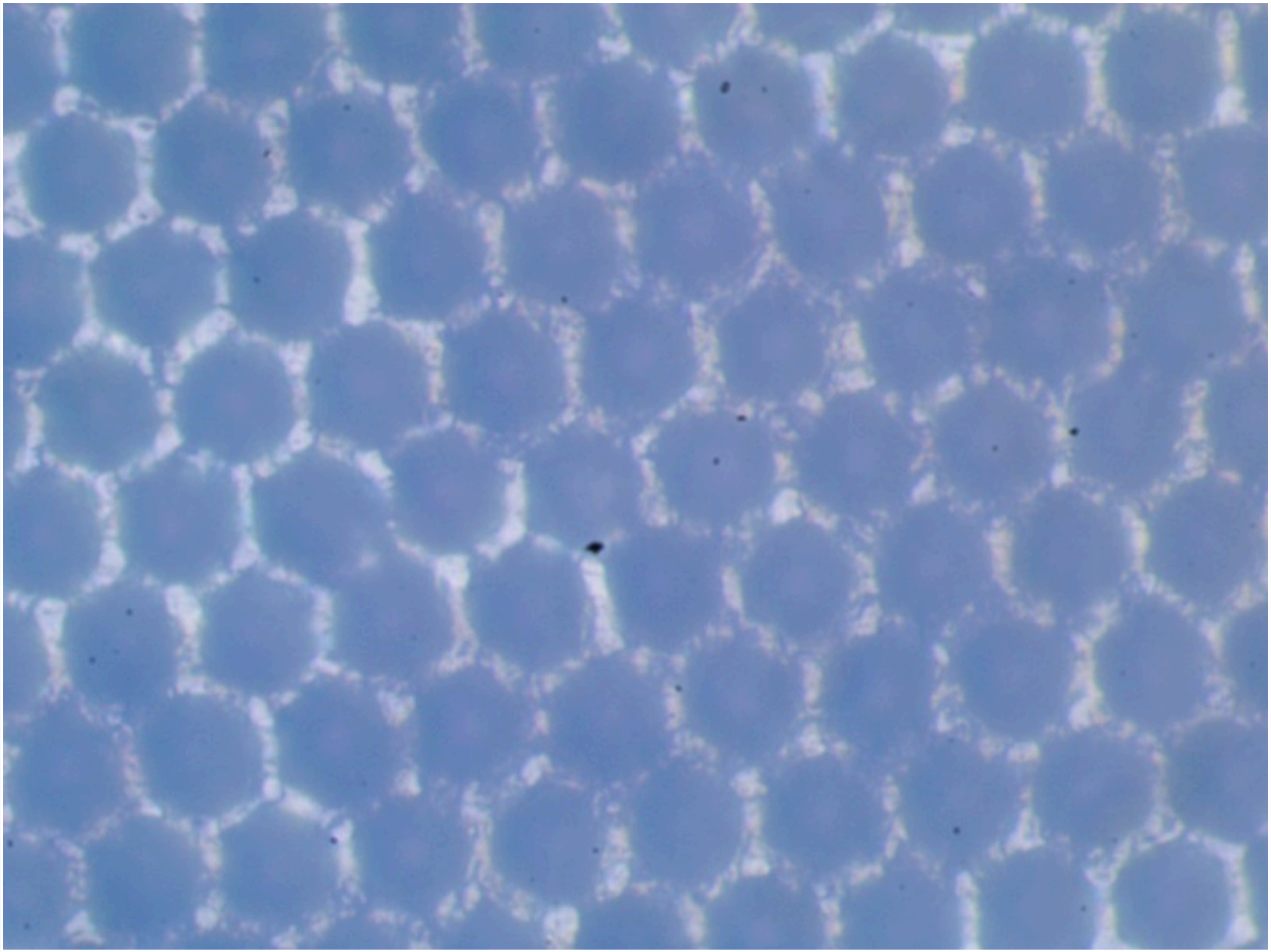
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	4.00	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 7
Depth before / after: 13.5 / 13.5 µm
Depth decreased by: 0%

Comment
scratch 20.
Roll is slightly worn.



Page №27. Roll "z17011034". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011034".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.7	cm^3/m^2

LEC measurements by Troika:

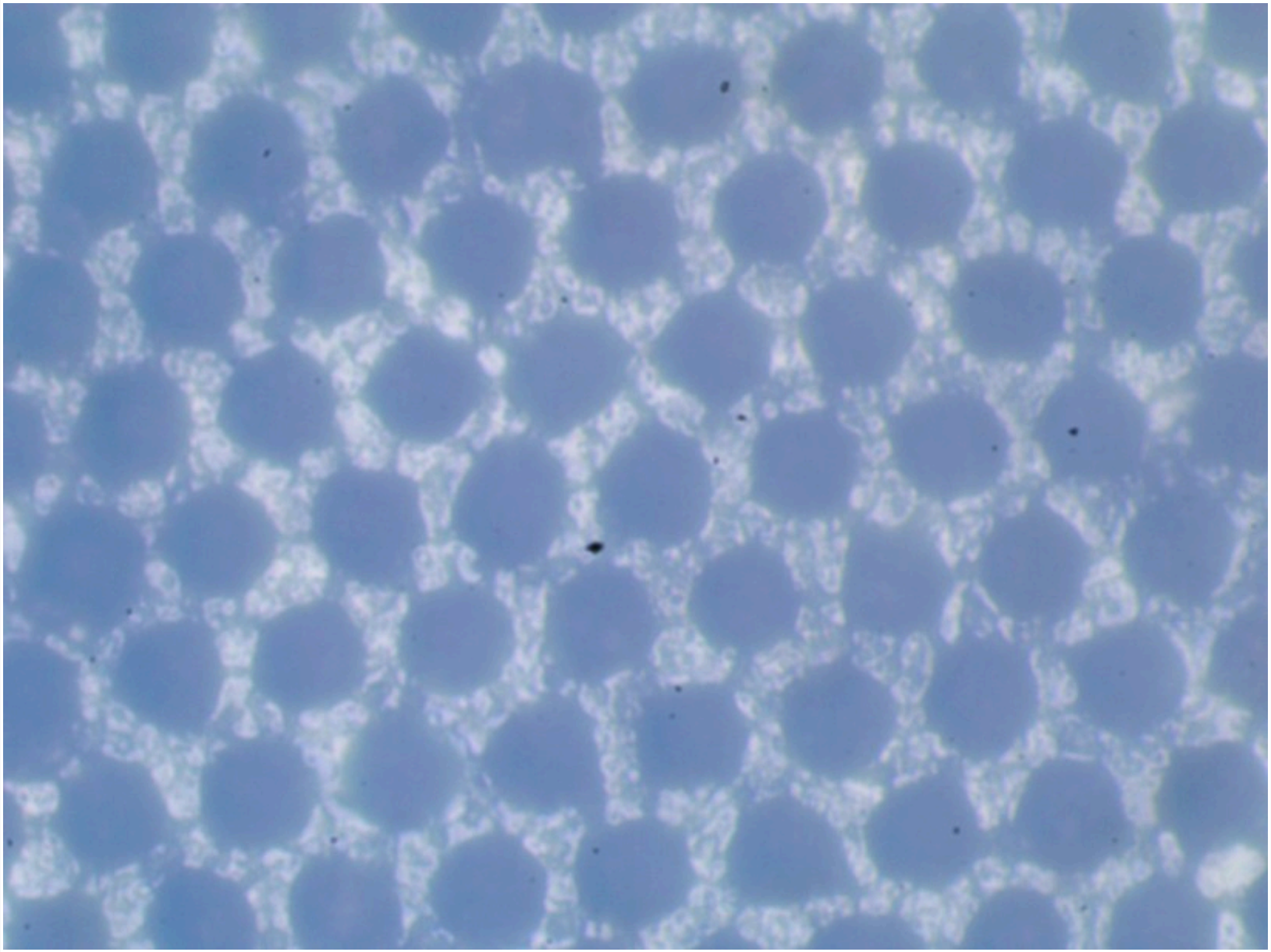
Measured line screen	400	lpcm
Vol	3.00	cm^3/m^2

Ink transfer volume decrease from the nominal value: 18.92%

Bridge / Cell: 1 / 4
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment
streak 75 85 110 245 1040 1268 dent 1130 1205 1115 1085.

Roll is worn.



Page №28. Roll "z26268". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z26268".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	9.8	cm^3/m^2

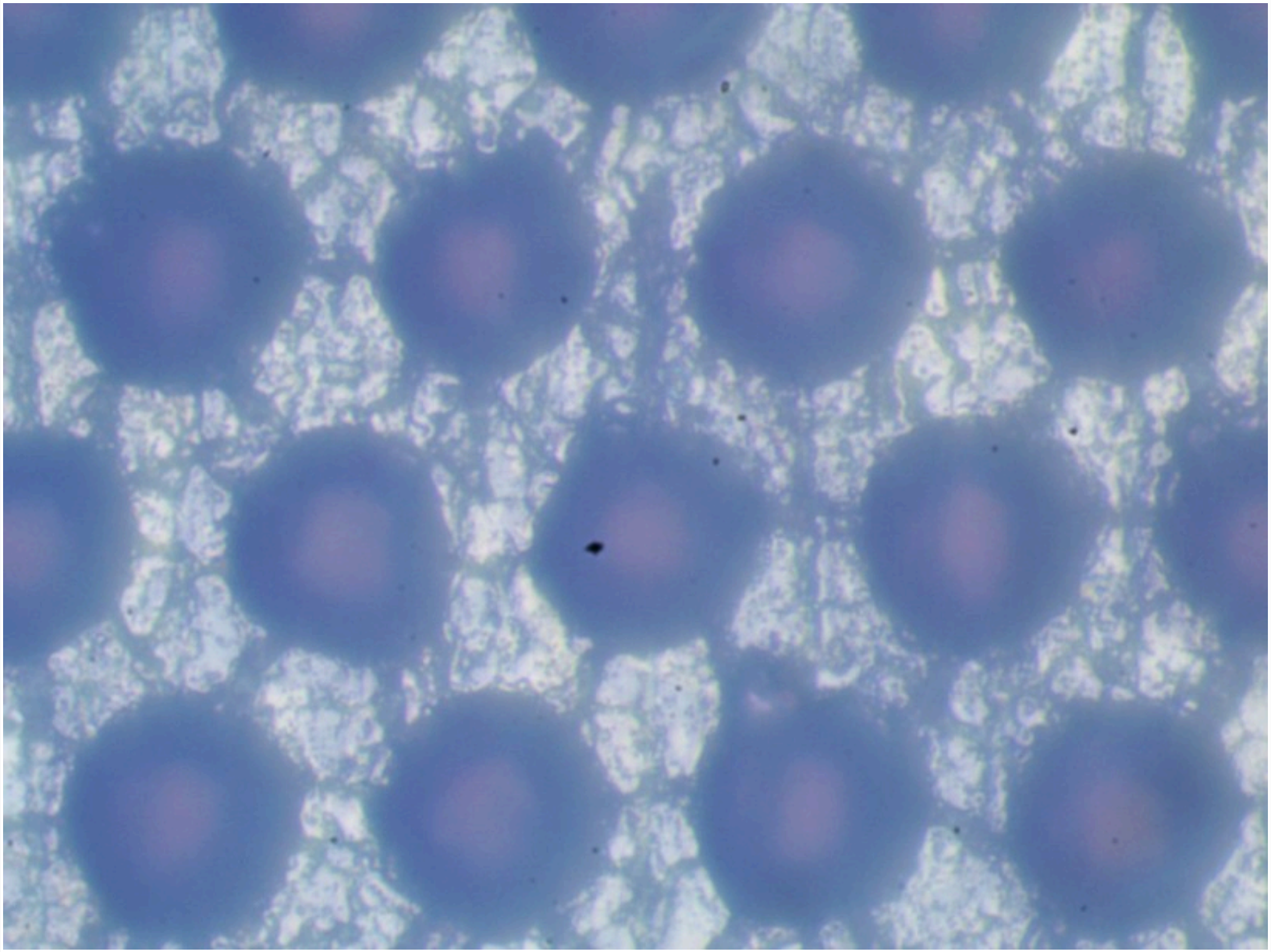
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	5.00	cm^3/m^2

Ink transfer volume decrease from the nominal value: 48.98%

Bridge / Cell: 1 / 3
Depth before / after: 23 / 23 µm
Depth decreased by: 0%

Comment
dent 30 210 250 270 300 350
1170 1230 350 370 565.
Roll is heavily worn.



Page №29. Roll "z45225". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z45225".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	9.5	cm^3/m^2

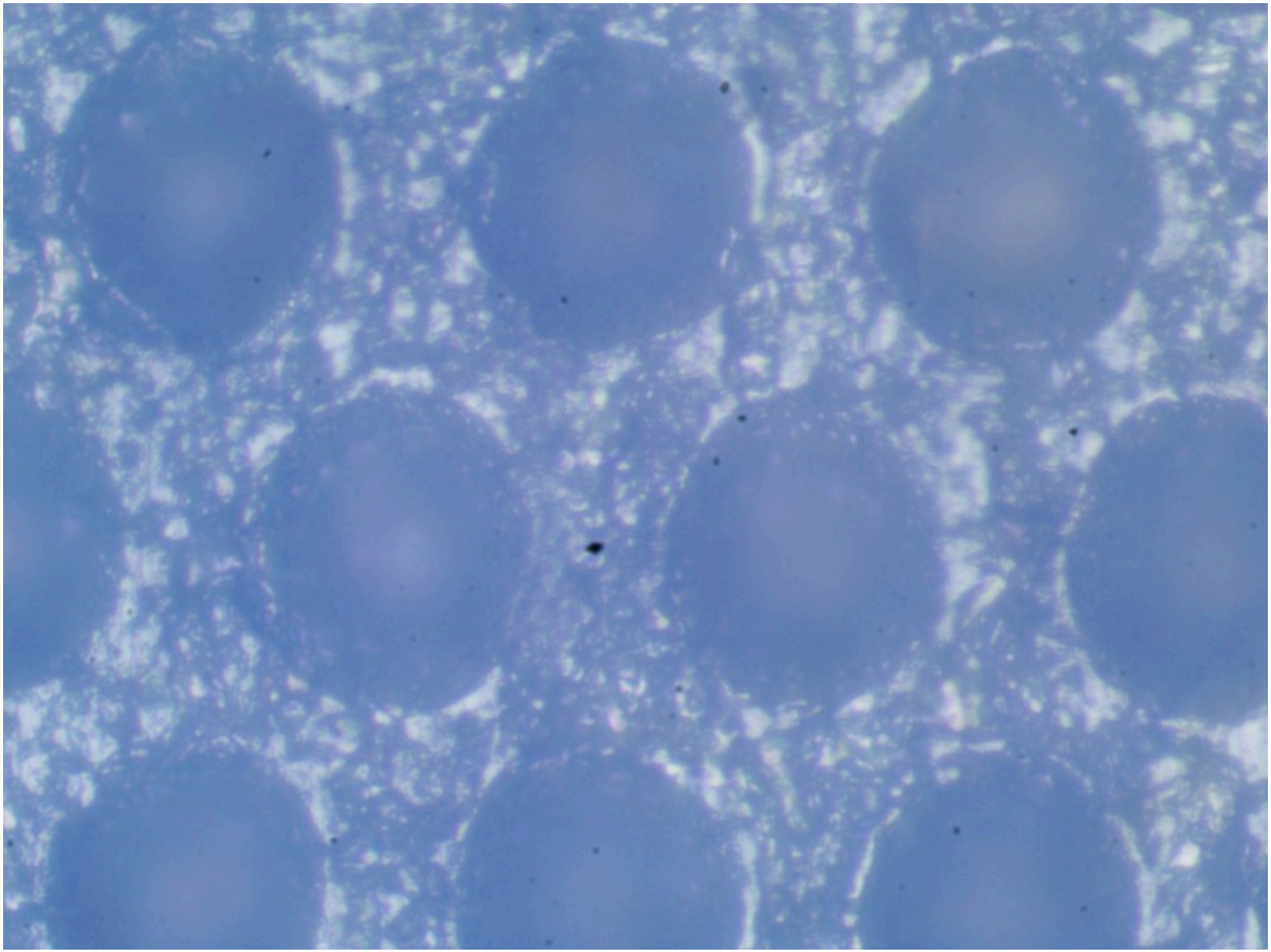
LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	4.10	cm^3/m^2

Ink transfer volume decrease from the nominal value: 56.84%

Bridge / Cell: 1 / 3
Depth before / after: 18 / 18 µm
Depth decreased by: 0%

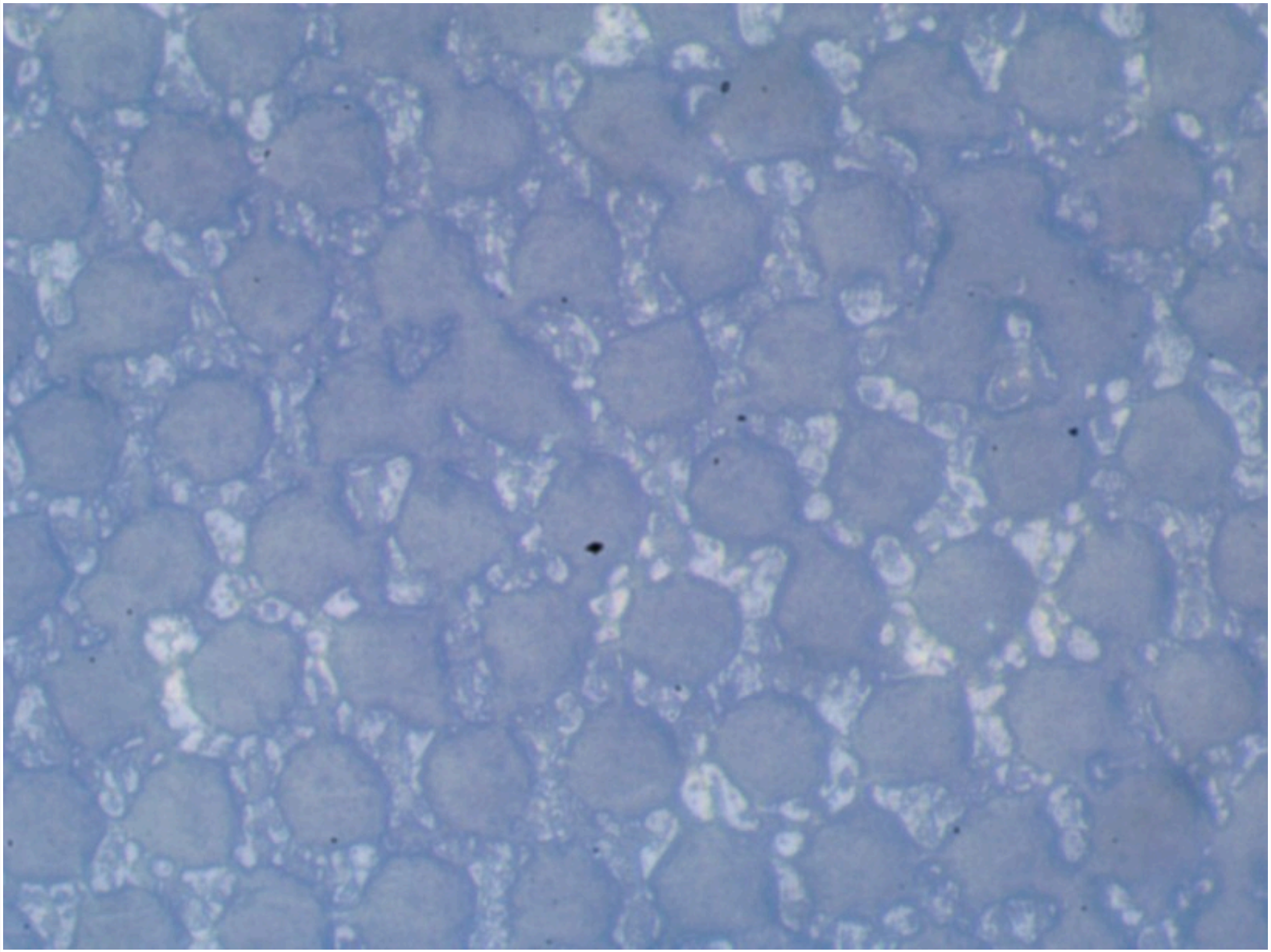
Comment
worn streaks dent 1170.
Roll is heavily worn.



Page №30. Roll "z17011036". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011036".

Photo of the anilox roll surface



Roll designations:

Nominal line screen	400	lpcm
Vol	3.7	cm^3/m^2

LEC measurements by Troika:

Measured line screen	380	lpcm
Vol	1.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 48.65%

Bridge / Cell: 1 / 3
Depth before / after: 8 / 8 µm
Depth decreased by: 0%

Comment
worn cell walls are missing streak 1133 dent 418 520.

Roll is heavily worn.

Page №31. Roll "z48067". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z48067".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	5.8	cm^3/m^2

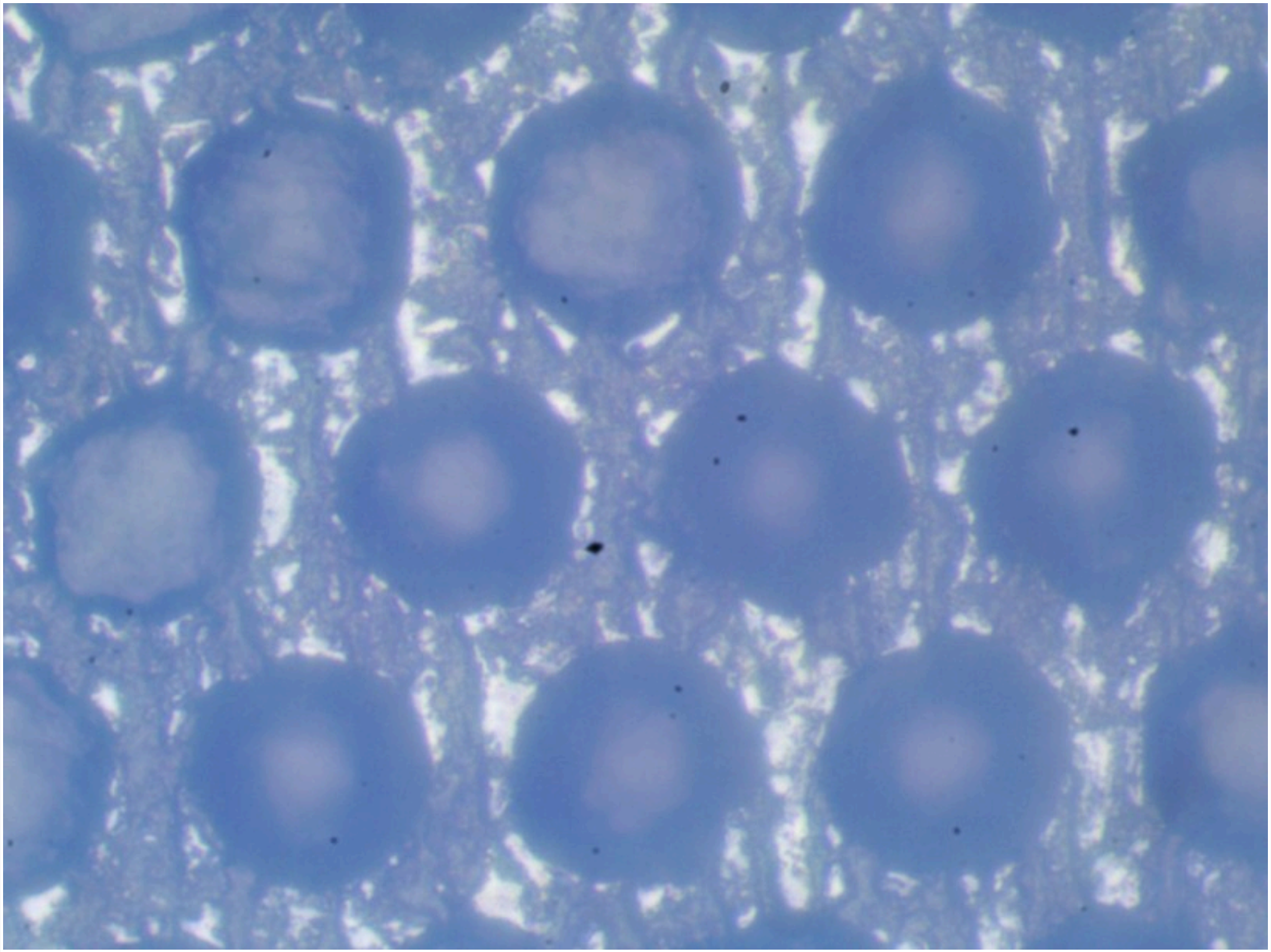
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	2.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 58.62%

Bridge / Cell: 1 / 4
Depth before / after: 10 / 10 µm
Depth decreased by: 0%

Comment
streaks dent 1295.
Roll is worn.



Page №32. Roll "z56916". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z56916".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	4.1	cm^3/m^2

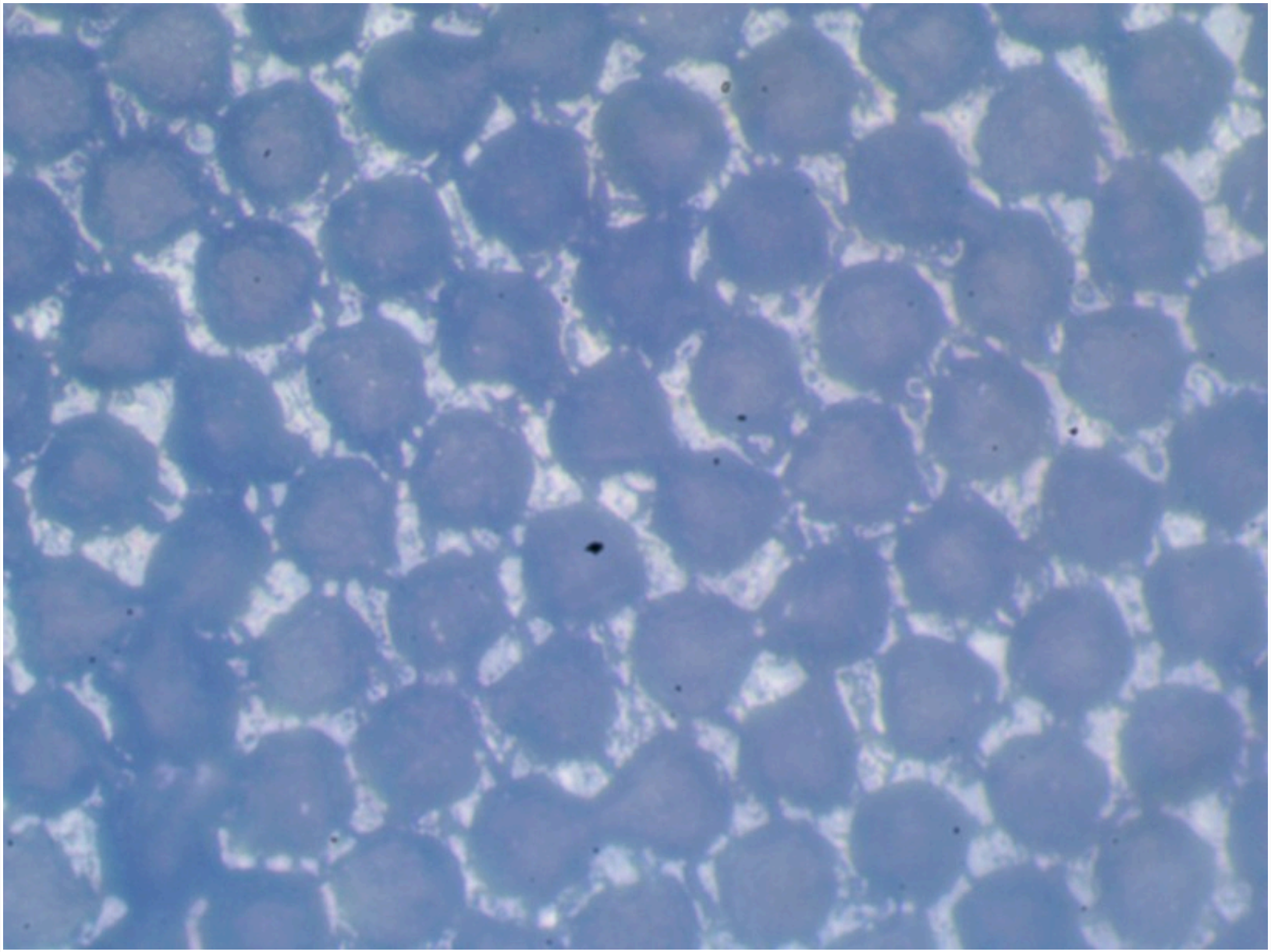
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	4.10	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 5
Depth before / after: 14.5 / 14.5 µm
Depth decreased by: 0%

Comment
streaks 1140 dent 1195 1250.
Roll is worn.



Page №33. Roll "h100751-6". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100751-6".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	160	lpcm
Vol	10.5	cm^3/m^2

LEC measurements by Troika:

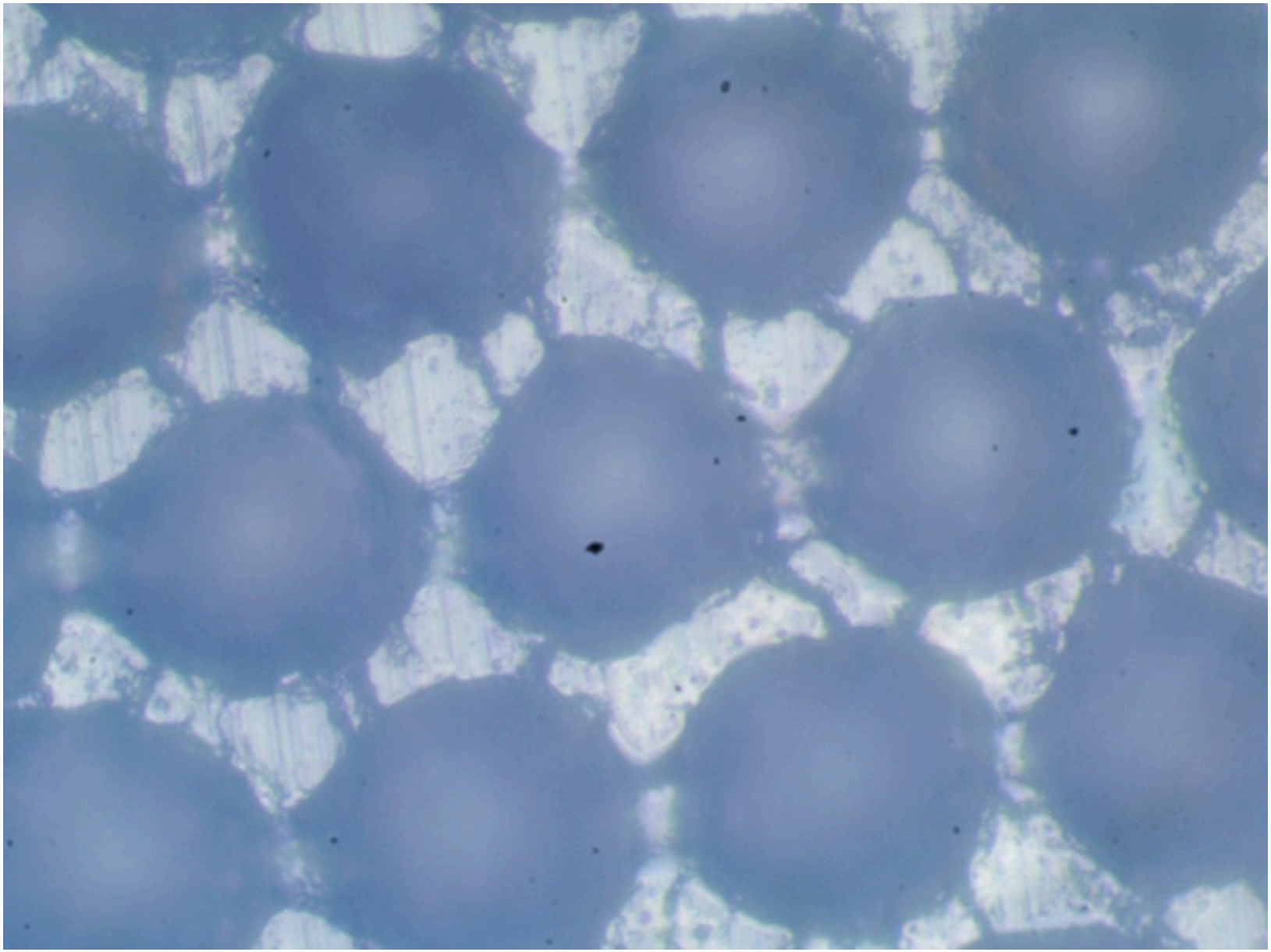
Measured line screen	160	lpcm
Vol	8.00	cm^3/m^2

Ink transfer volume decrease from the nominal value: 23.81%

Bridge / Cell: 1 / 6
Depth before / after: 28 / 28 µm
Depth decreased by: 0%

Comment

streaks.
Roll is worn.



Page №34. Roll "z18009225". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18009225".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	13.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	2.80	cm^3/m^2

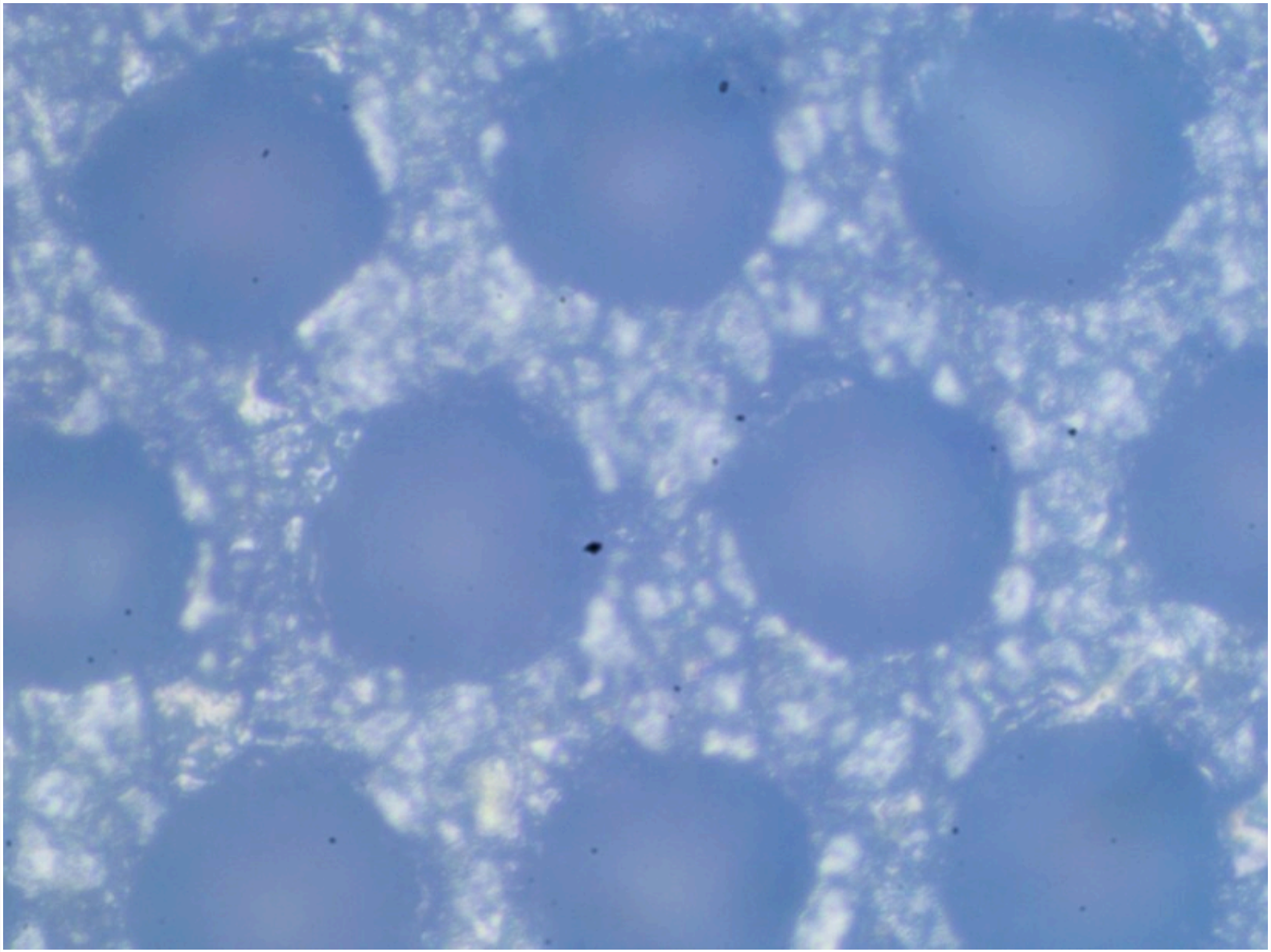
Ink transfer volume decrease from the nominal value: 78.46%

Bridge / Cell: 1 / 2
Depth before / after: 15 / 15 µm
Depth decreased by: 0%

Comment

worn dent 210 195 175 streaks.

Roll is heavily worn.



Page №35. Roll "sa008618". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008618".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	170	lpcm
Vol	9.5	cm^3/m^2

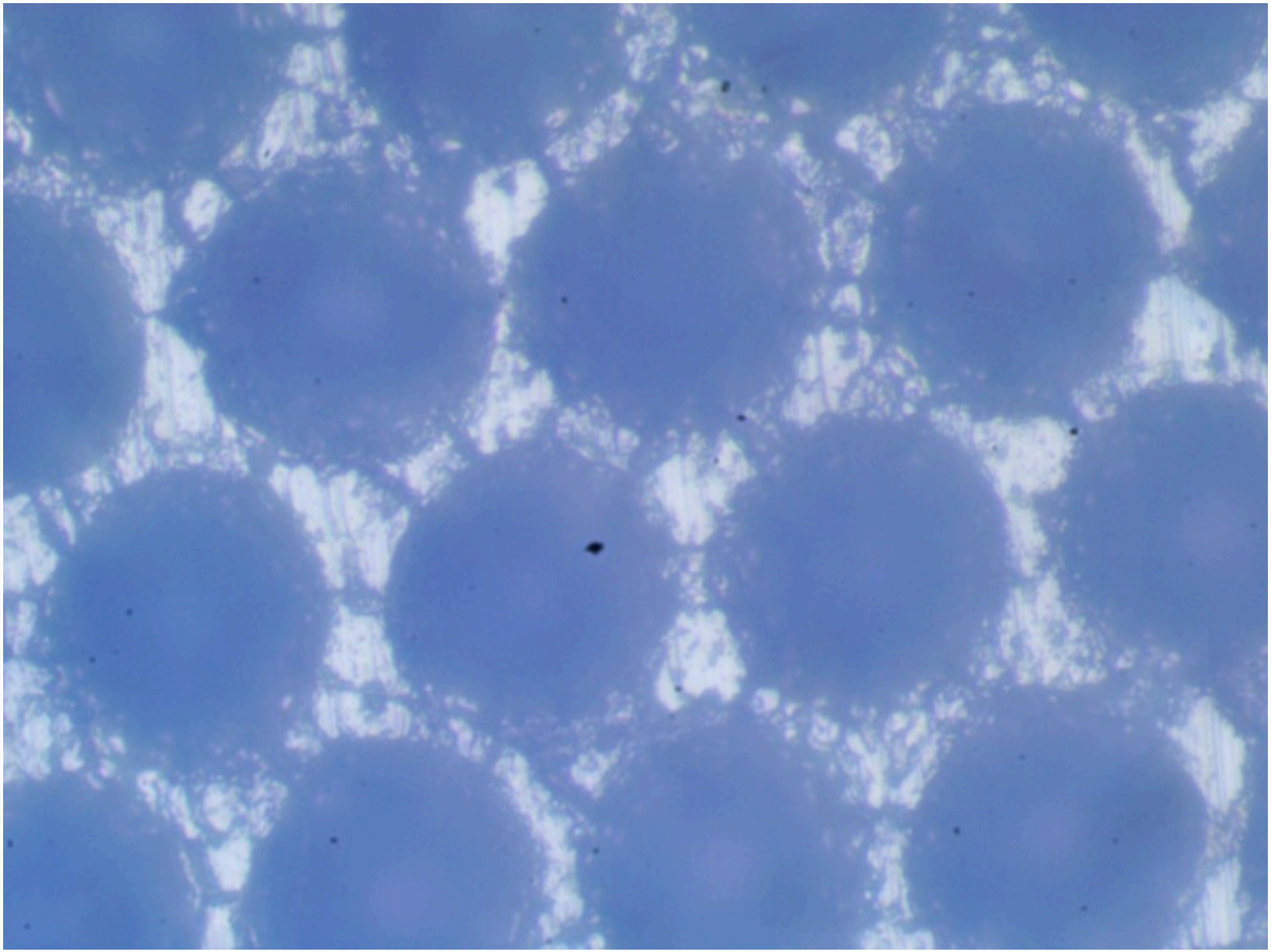
LEC measurements by Troika:

Measured line screen	170	lpcm
Vol	8.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 12.63%

Bridge / Cell: 1 / 7
Depth before / after: 28 / 28 µm
Depth decreased by: 0%

Comment
Roll is slightly worn.



Page №36. Roll "sa008621". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008621".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	250	lpcm
Vol	8.0	cm^3/m^2

LEC measurements by Troika:

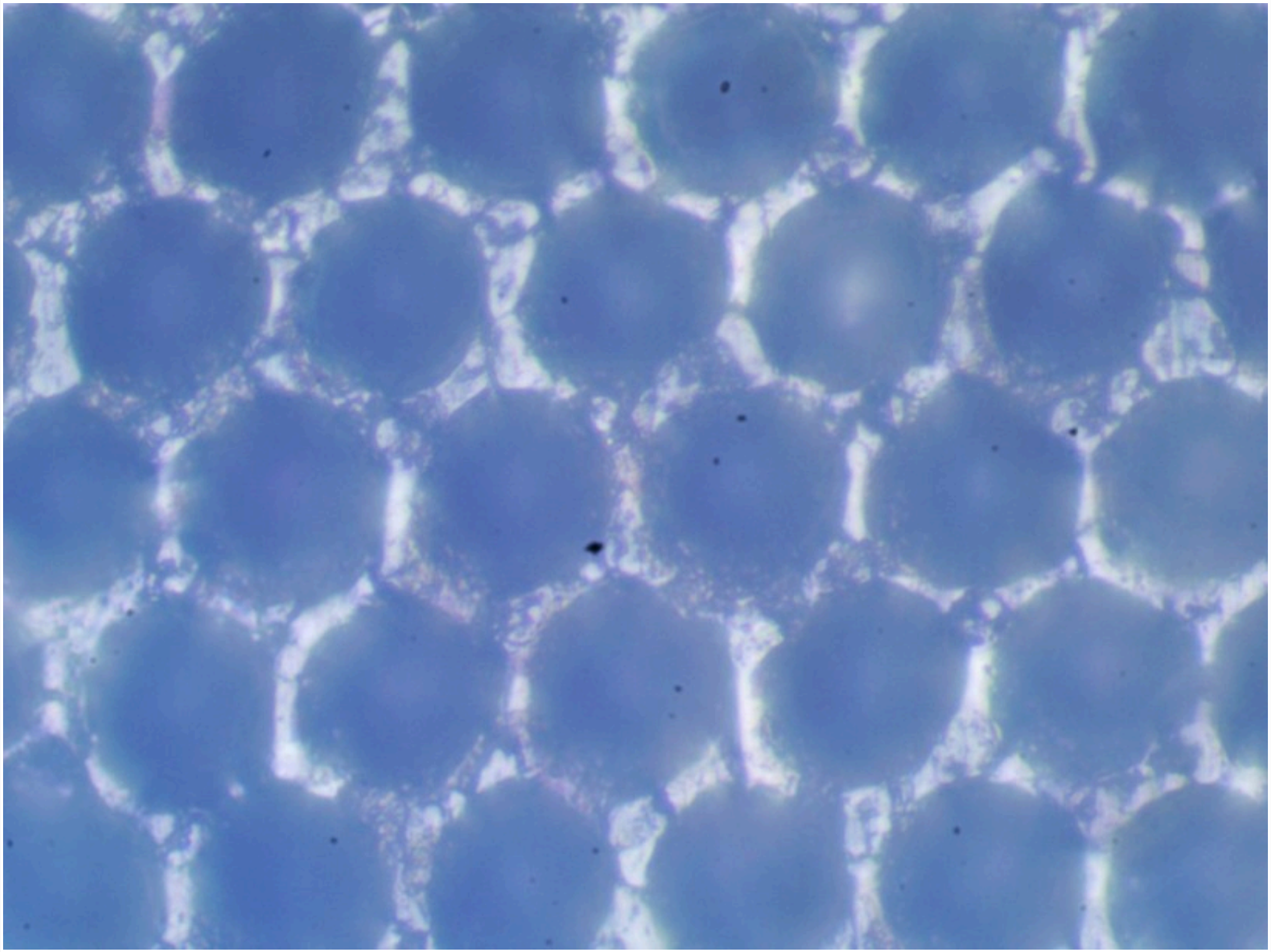
Measured line screen	250	lpcm
Vol	7.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 5%

Bridge / Cell: 1 / 9
Depth before / after: 24 / 24 µm
Depth decreased by: 0%

Comment

streak 1265 dent 1175 1150.



Page №37. Roll "z18008066". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18008066".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.5	cm^3/m^2

LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	2.40	cm^3/m^2

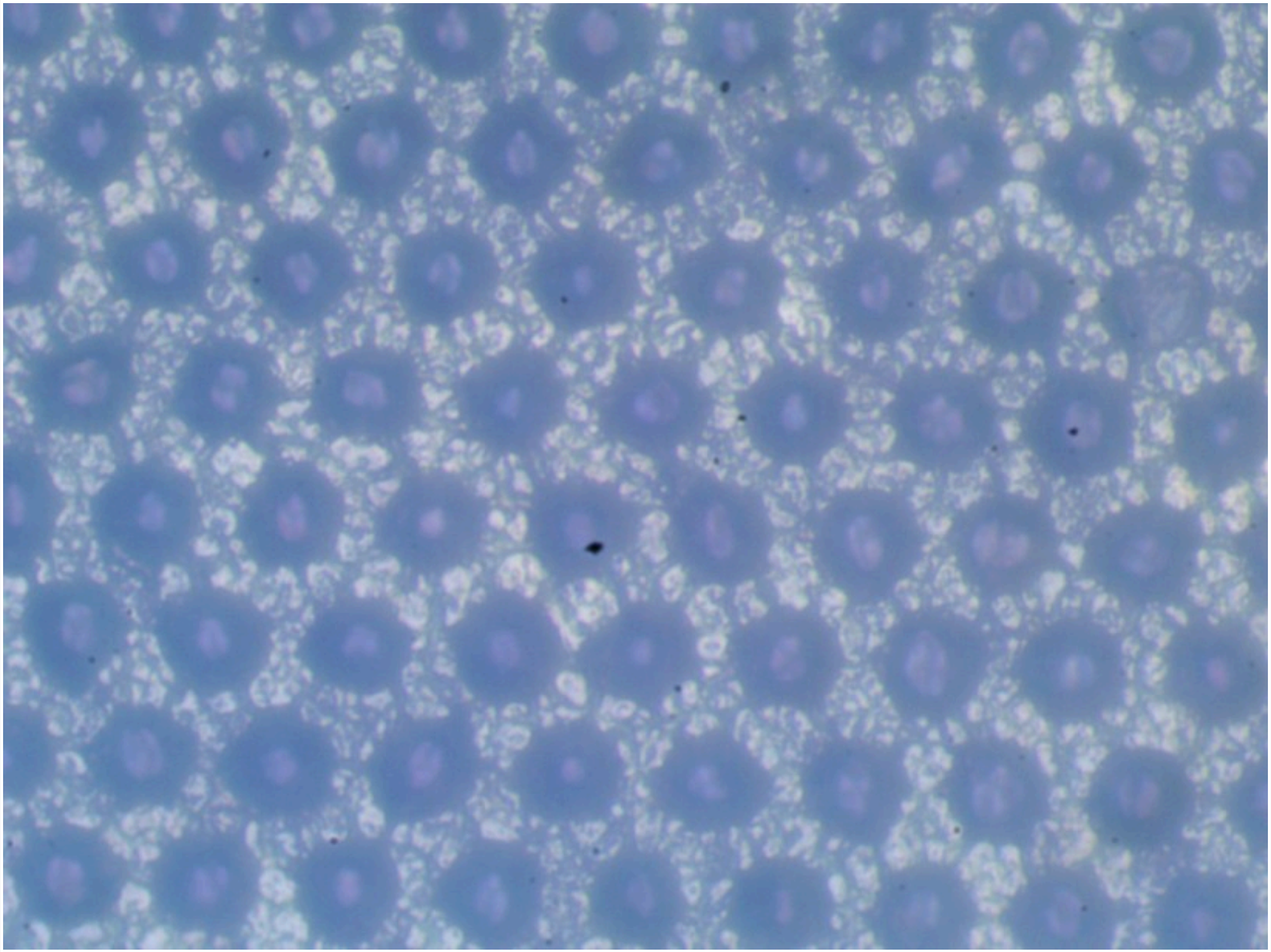
Ink transfer volume decrease from the nominal value: 31.43%

Bridge / Cell: 1 / 2
Depth before / after: 14 / 14 µm
Depth decreased by: 0%

Comment

worn streak 1034 415 674 973 1265 dent 1005 1015 1023.

Roll is heavily worn.



Page №38. Roll "h100479-2". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100479-2".	Photo of the anilox roll surface

Roll designations:

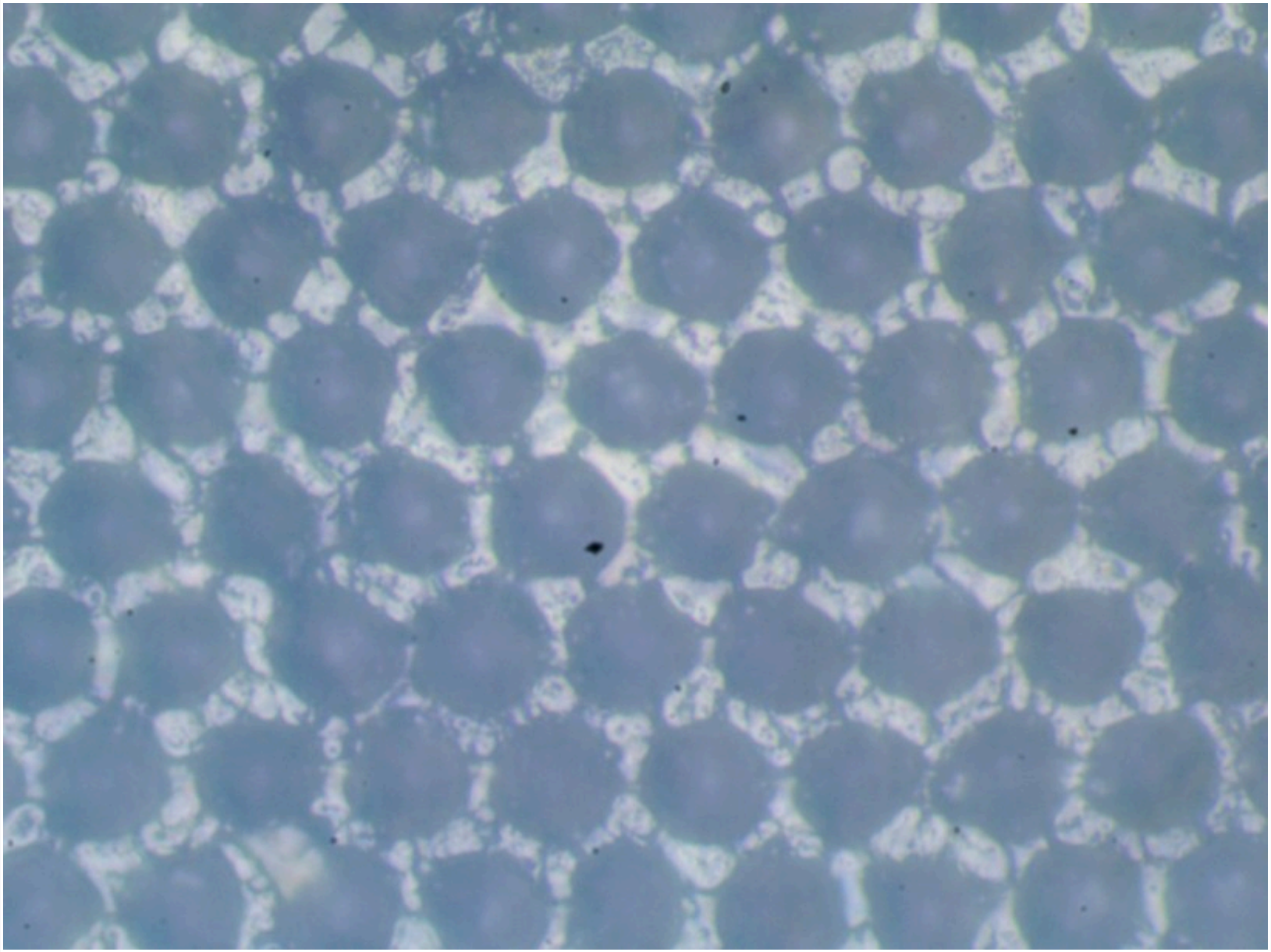
Nominal line screen	380	lpcm
Vol	5.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	380	lpcm
Vol	4.10	cm^3/m^2

Ink transfer volume decrease from the nominal value: 18%

Bridge / Cell: 1 / 4
Depth before / after: 16 / 16 µm
Depth decreased by: 0%



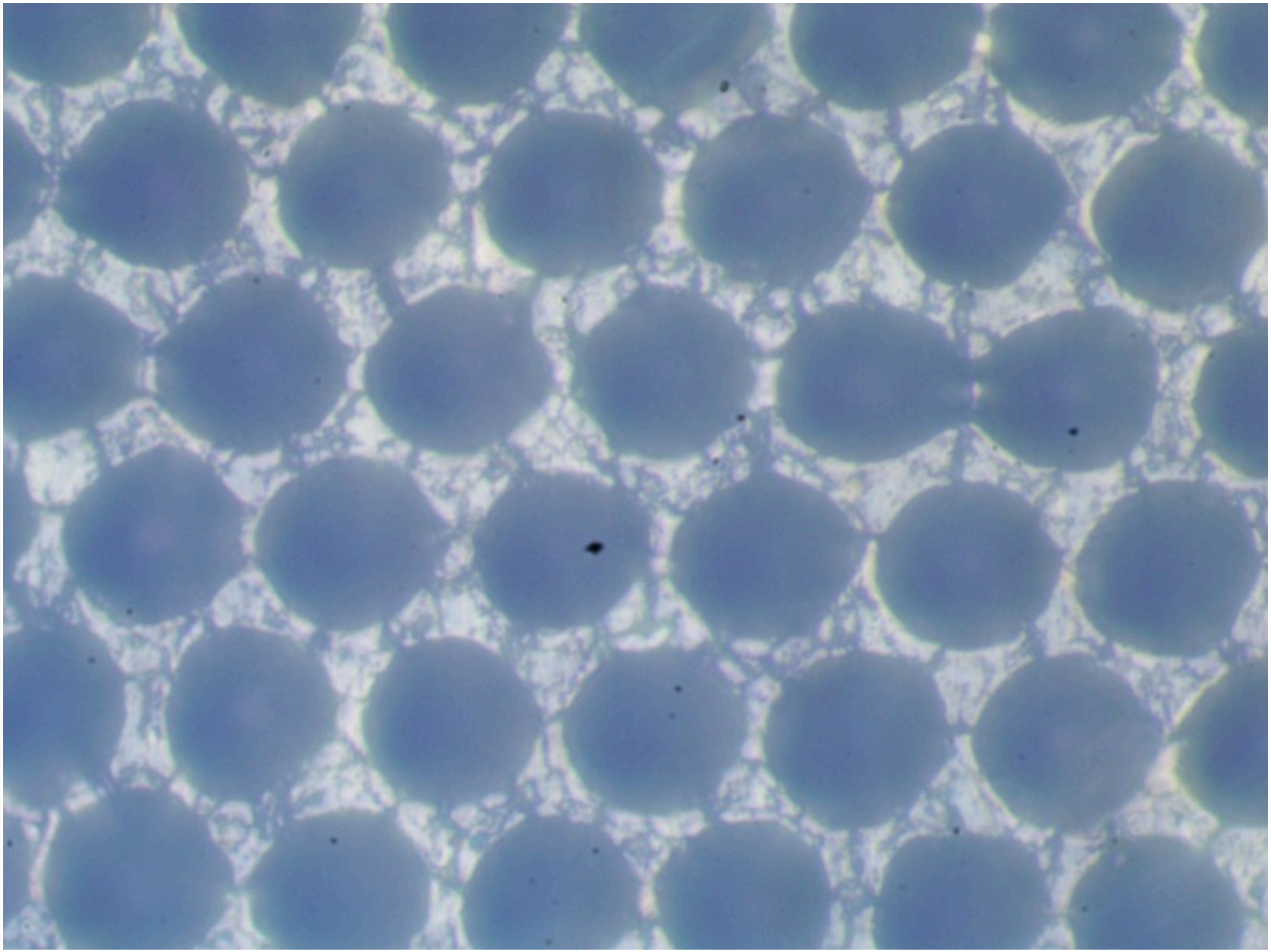
Comment

streaks.
Roll is worn.

Page №39. Roll "z18008070". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18008070".

Photo of the anilox roll surface



Roll designations:

Nominal line screen	280	lpcm
Vol	7.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	6.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10%

Bridge / Cell: 1 / 6
Depth before / after: 21.5 / 21.5 µm
Depth decreased by: 0%

Comment

dent 1160.
Roll is worn.

Page №40. Roll "sa008625". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008625".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	360	lpcm
Vol	5.0	cm^3/m^2

LEC measurements by Troika:

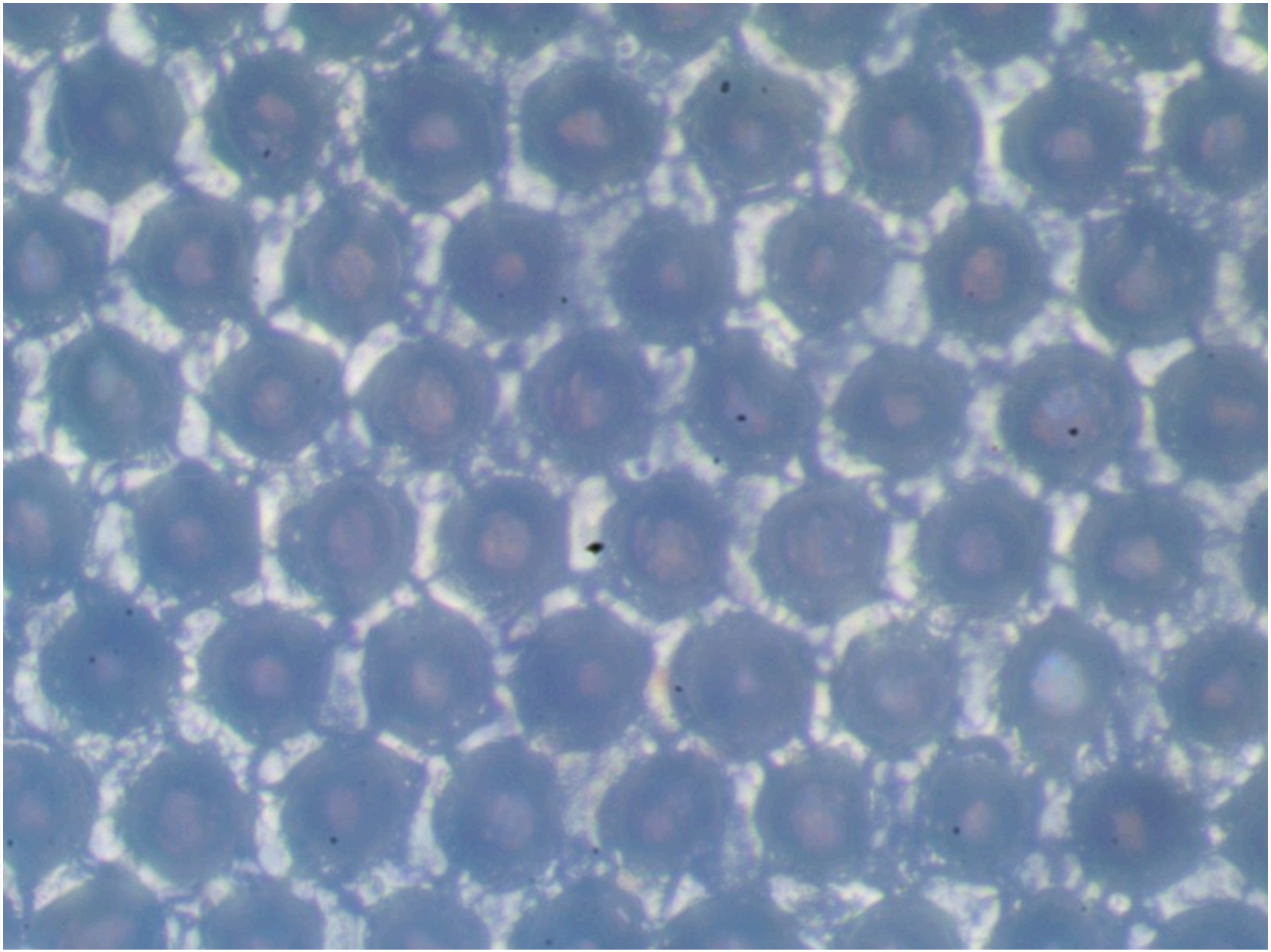
Measured line screen	360	lpcm
Vol	5.00	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 5
Depth before / after: 19 / 19 µm
Depth decreased by: 0%

Comment

streaks scratch 268.
Roll is worn.



Page №41. Roll "sa008624". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008624".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	340	lpcm
Vol	5.5	cm^3/m^2

LEC measurements by Troika:

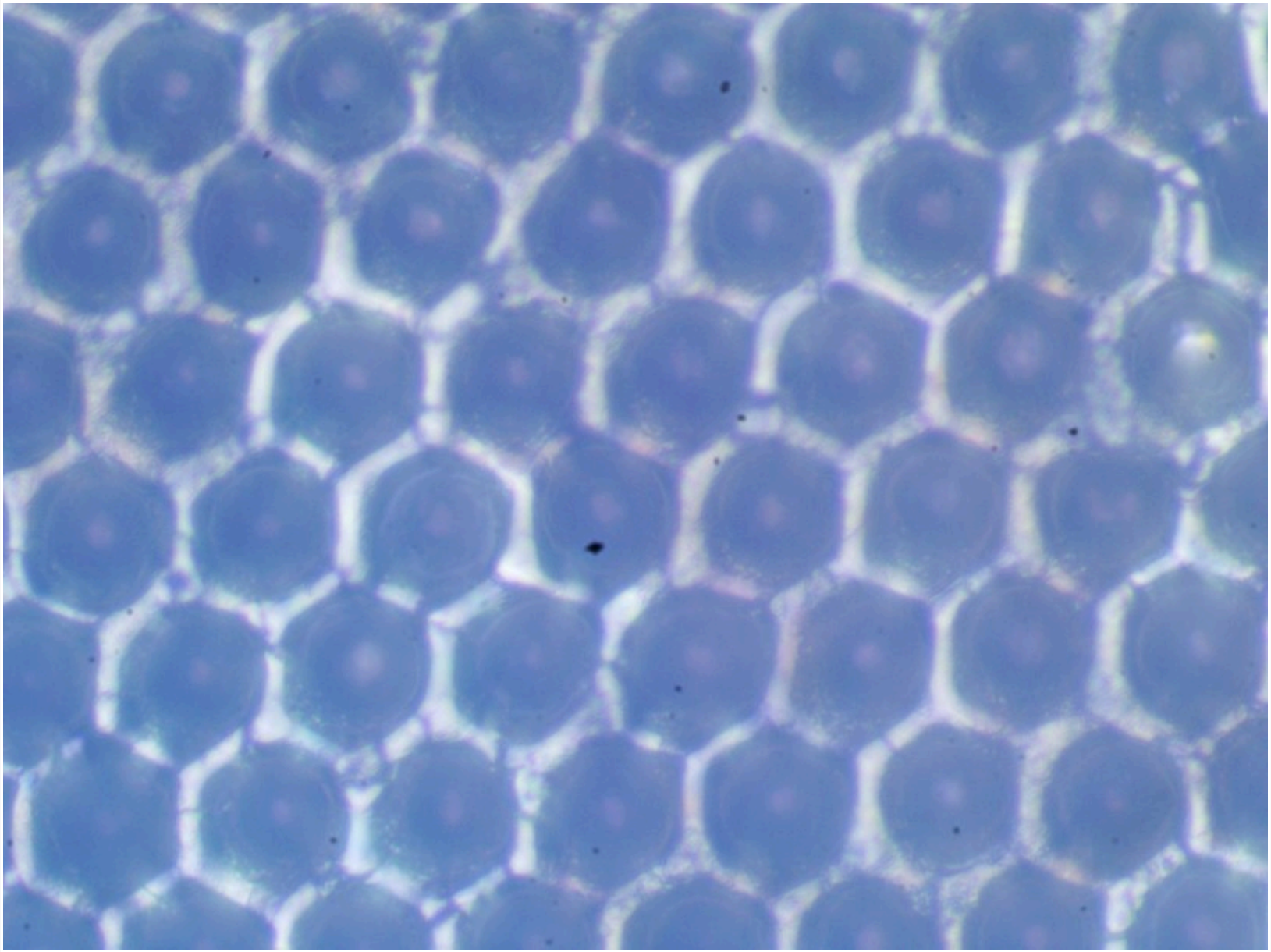
Measured line screen	340	lpcm
Vol	5.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 3.64%

Bridge / Cell: 1 / 6
Depth before / after: 18 / 18 µm
Depth decreased by: 0%

Comment

streak 602 670 scratch 760.
Roll is worn.



Page №42. Roll "h100479-1". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100479-1".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	380	lpcm
Vol	5.0	cm^3/m^2

LEC measurements by Troika:

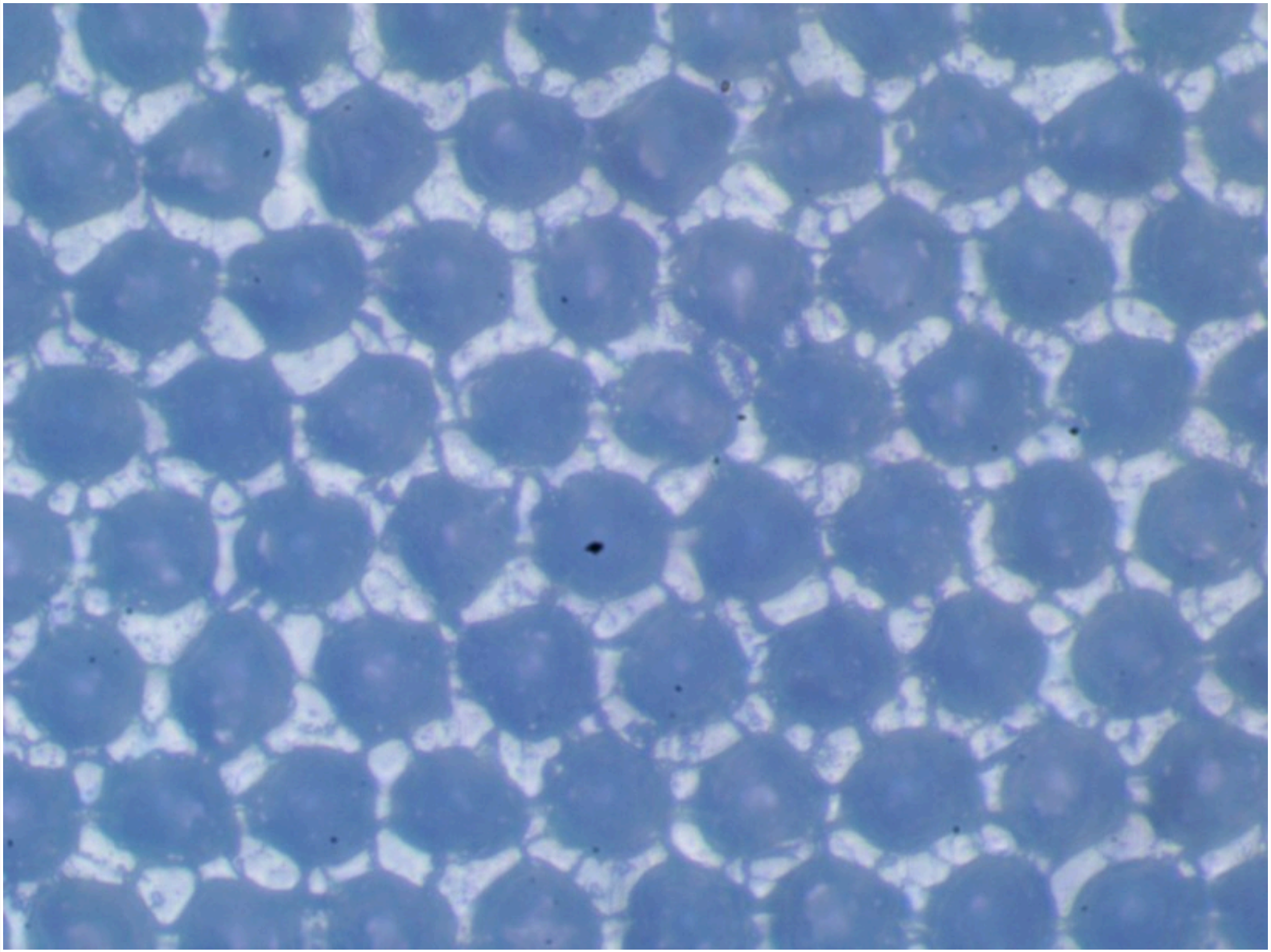
Measured line screen	380	lpcm
Vol	4.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10%

Bridge / Cell: 1 / 6
Depth before / after: 16 / 16 µm
Depth decreased by: 0%

Comment

spots across the entire surface.
Roll is worn.



Page №43. Roll "3016196-2". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "3016196-2".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	120	lpcm
Vol	12.0	cm^3/m^2

LEC measurements by Troika:

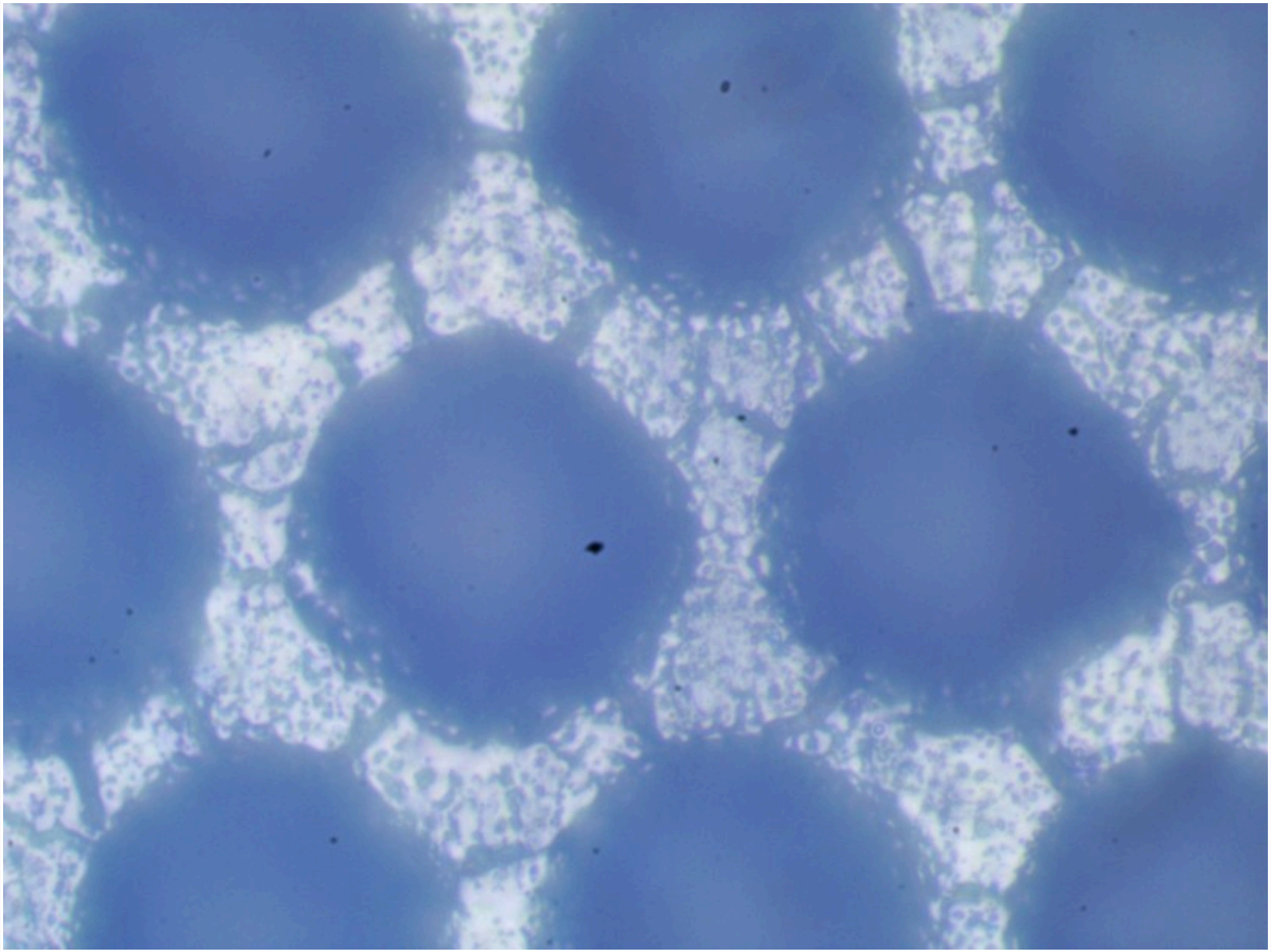
Measured line screen	120	lpcm
Vol	7.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 36.67%

Bridge / Cell: 1 / 5
Depth before / after: 28 / 28 µm
Depth decreased by: 0%

Comment

worn streak 896 767.
Roll is worn.



Page №44. Roll "z18008076". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18008076".	Photo of the anilox roll surface

Roll designations:

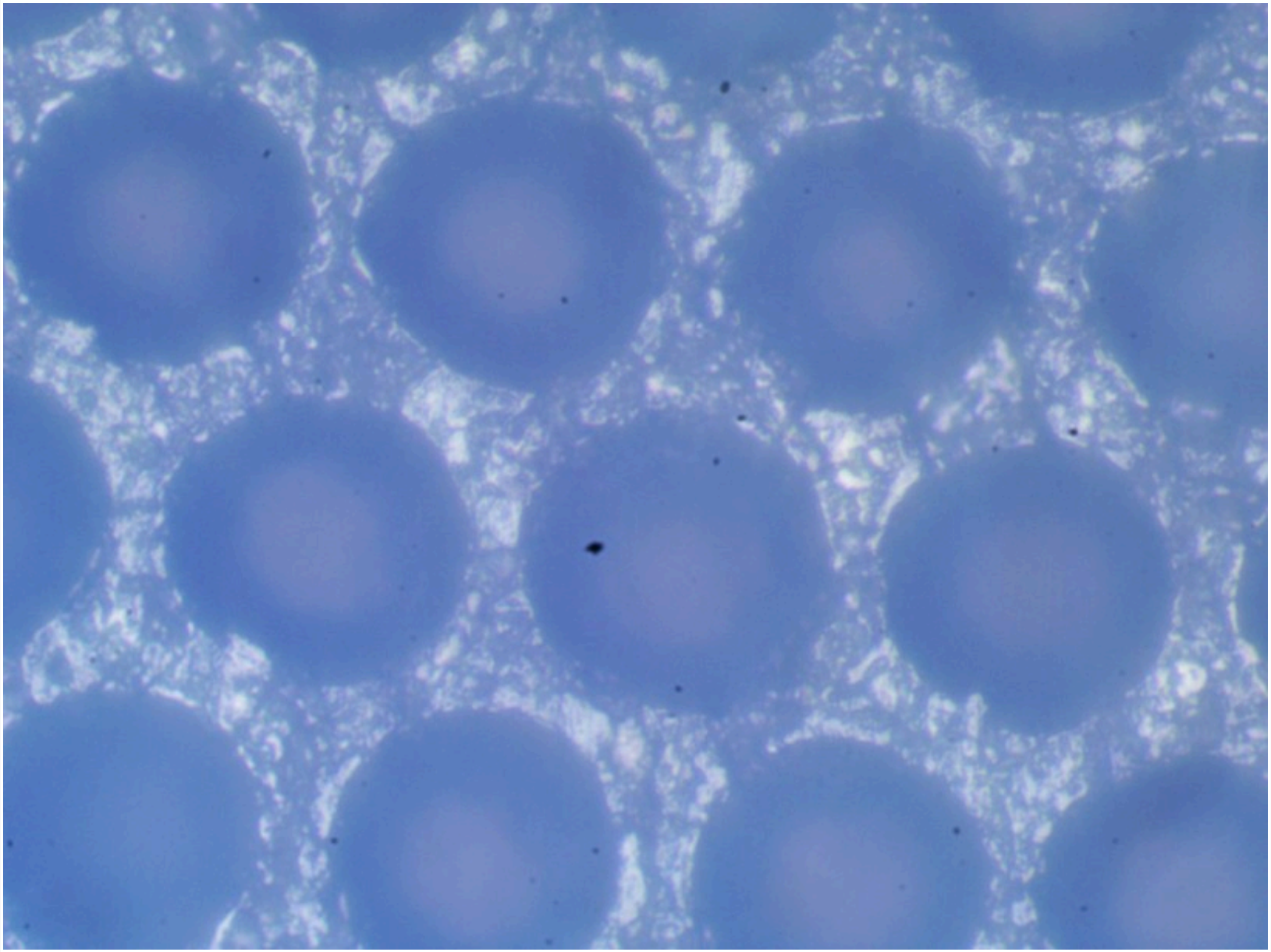
Nominal line screen	160	lpcm
Vol	12.9	cm^3/m^2

LEC measurements by Troika:

Measured line screen	160	lpcm
Vol	9.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 24.81%

Bridge / Cell: 1 / 5
Depth before / after: 36 / 36 µm
Depth decreased by: 0%



Comment

streaks.
Roll is worn.

Page №45. Roll "kk74445". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "kk74445".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	11.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	5.70	cm^3/m^2

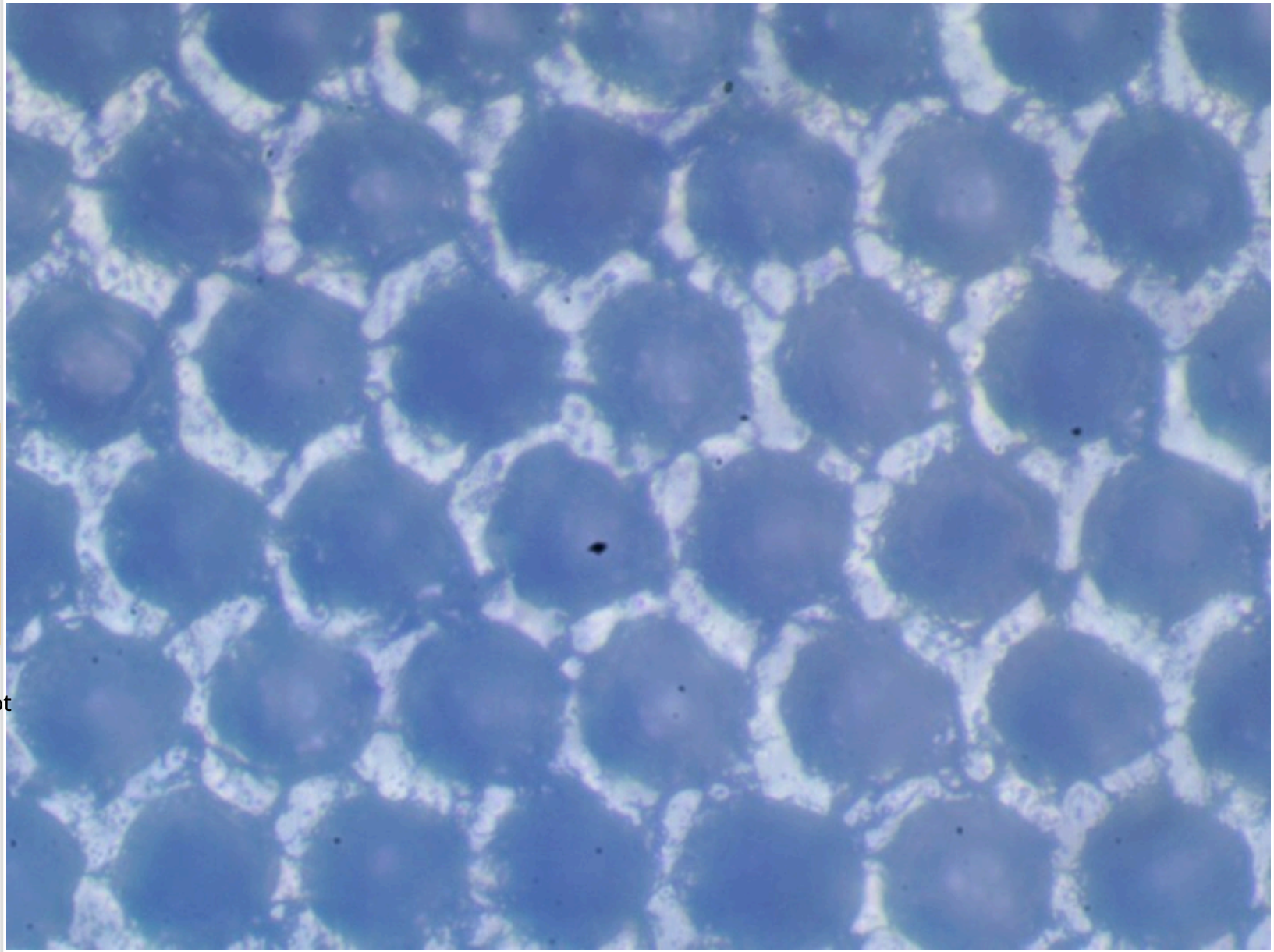
Ink transfer volume decrease from the nominal value: 48.18%

Bridge / Cell: 1 / 6
Depth before / after: 19.5 / 19.5 µm
Depth decreased by: 0%

Comment

dent 1120 streaks chip 1090 1125 spot 260.

Roll is worn.



Page №46. Roll "z18008069". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18008069".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	7.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	6.70	cm^3/m^2

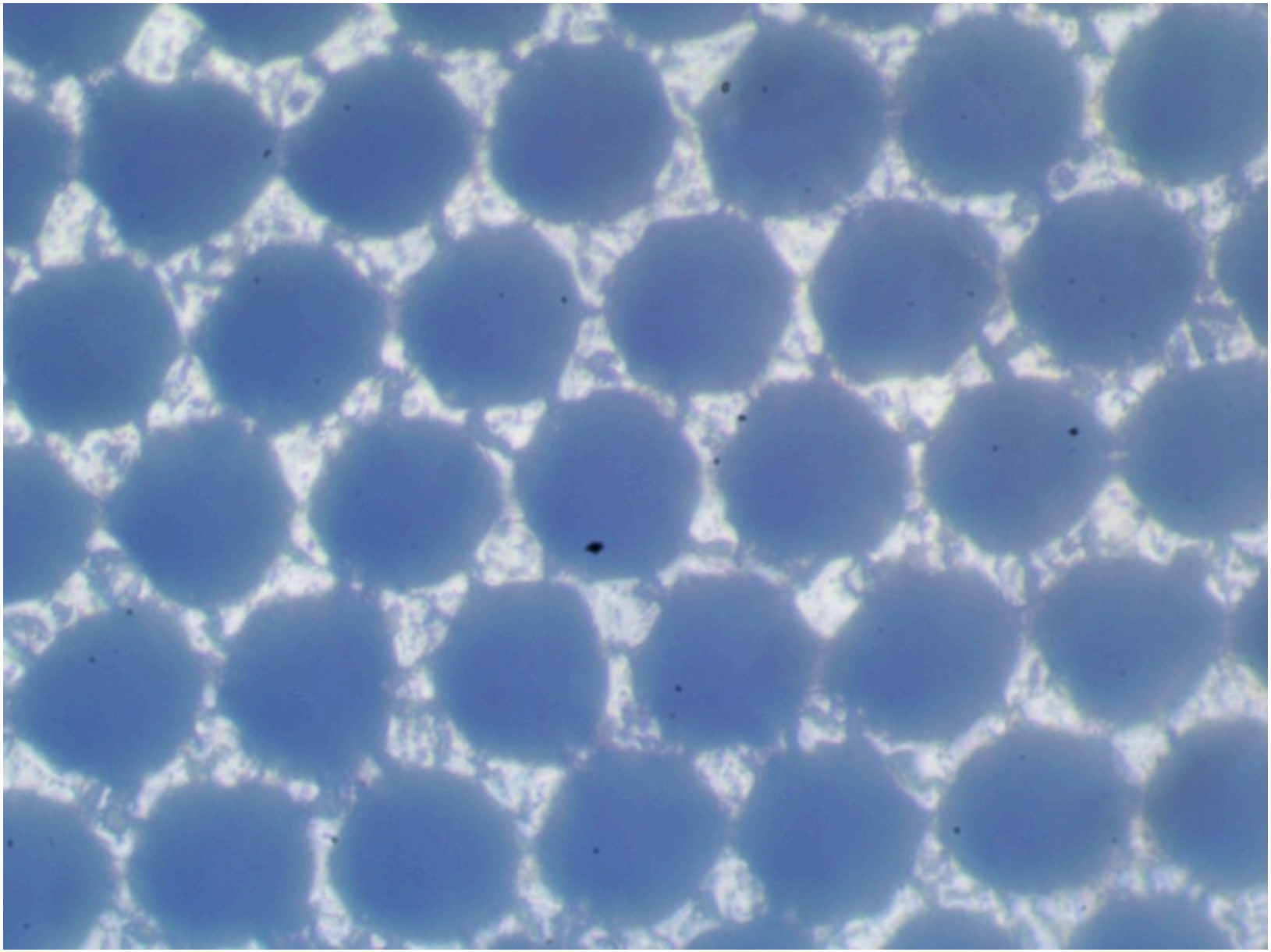
Ink transfer volume decrease from the nominal value: 4.29%

Bridge / Cell: 1 / 8
Depth before / after: 21.5 / 21.5 µm
Depth decreased by: 0%

Comment

scratch 1219 1290 1050 450 spot 505 streak 217.

Roll is slightly worn.



Page №47. Roll "z18008080". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18008080".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	120	lpcm
Vol	15.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	120	lpcm
Vol	11.20	cm^3/m^2

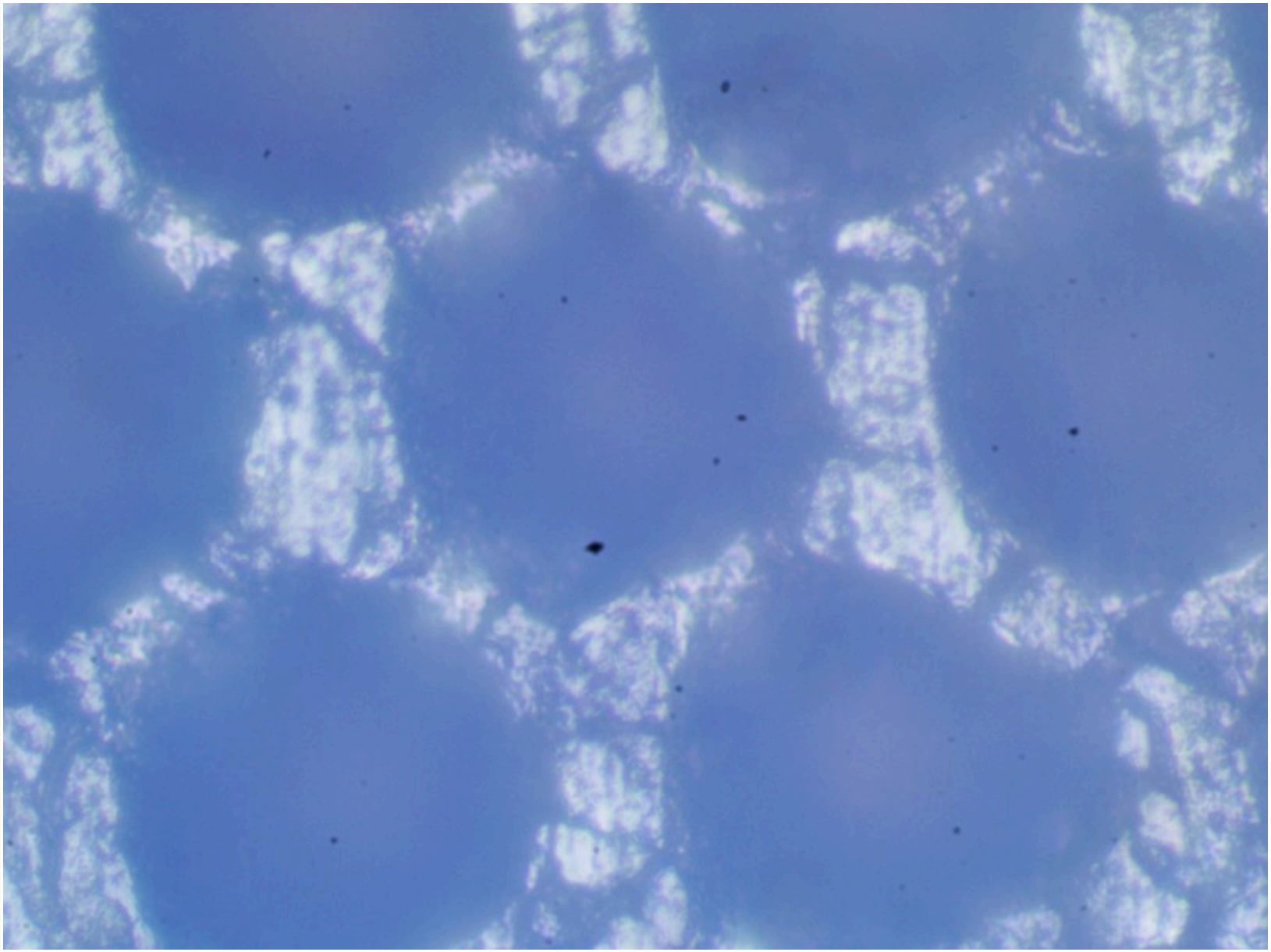
Ink transfer volume decrease from the nominal value: 25.33%

Bridge / Cell: 1 / 5
Depth before / after: 42 / 42 µm
Depth decreased by: 0%

Comment

streak 363 630 687 714 1057 dent 1130 1150 scratch 530

340.
Roll is worn.



Page №48. Roll "z18008072". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18008072".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	9.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	7.10	cm^3/m^2

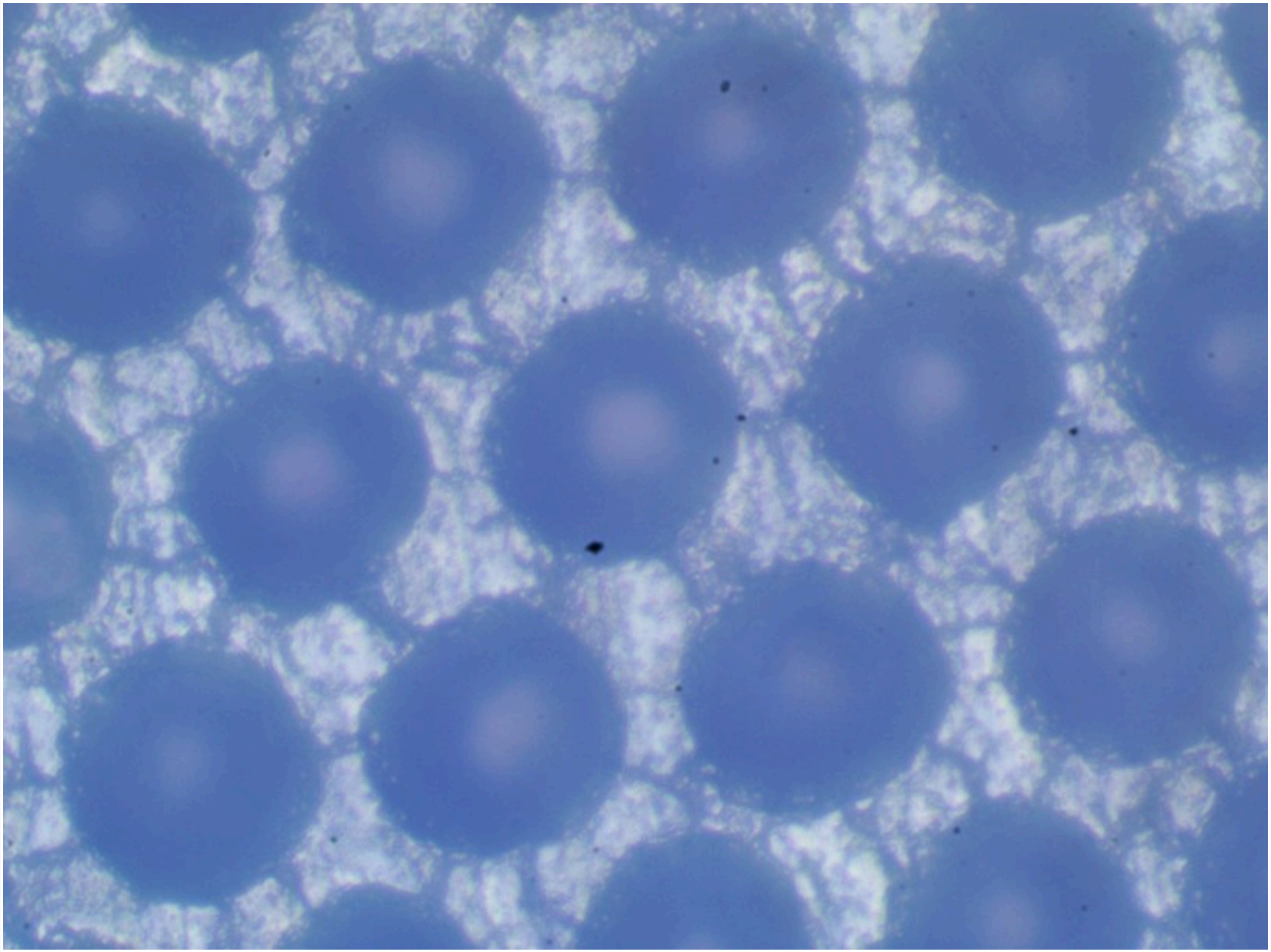
Ink transfer volume decrease from the nominal value: 21.11%

Bridge / Cell: 1 / 5
Depth before / after: 27 / 27 µm
Depth decreased by: 0%

Comment

worn streak 410 1021 scratch 345 1200.

Roll is worn.



Page №49. Roll "z18008068". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18008068".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.5	cm^3/m^2

LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	2.30	cm^3/m^2

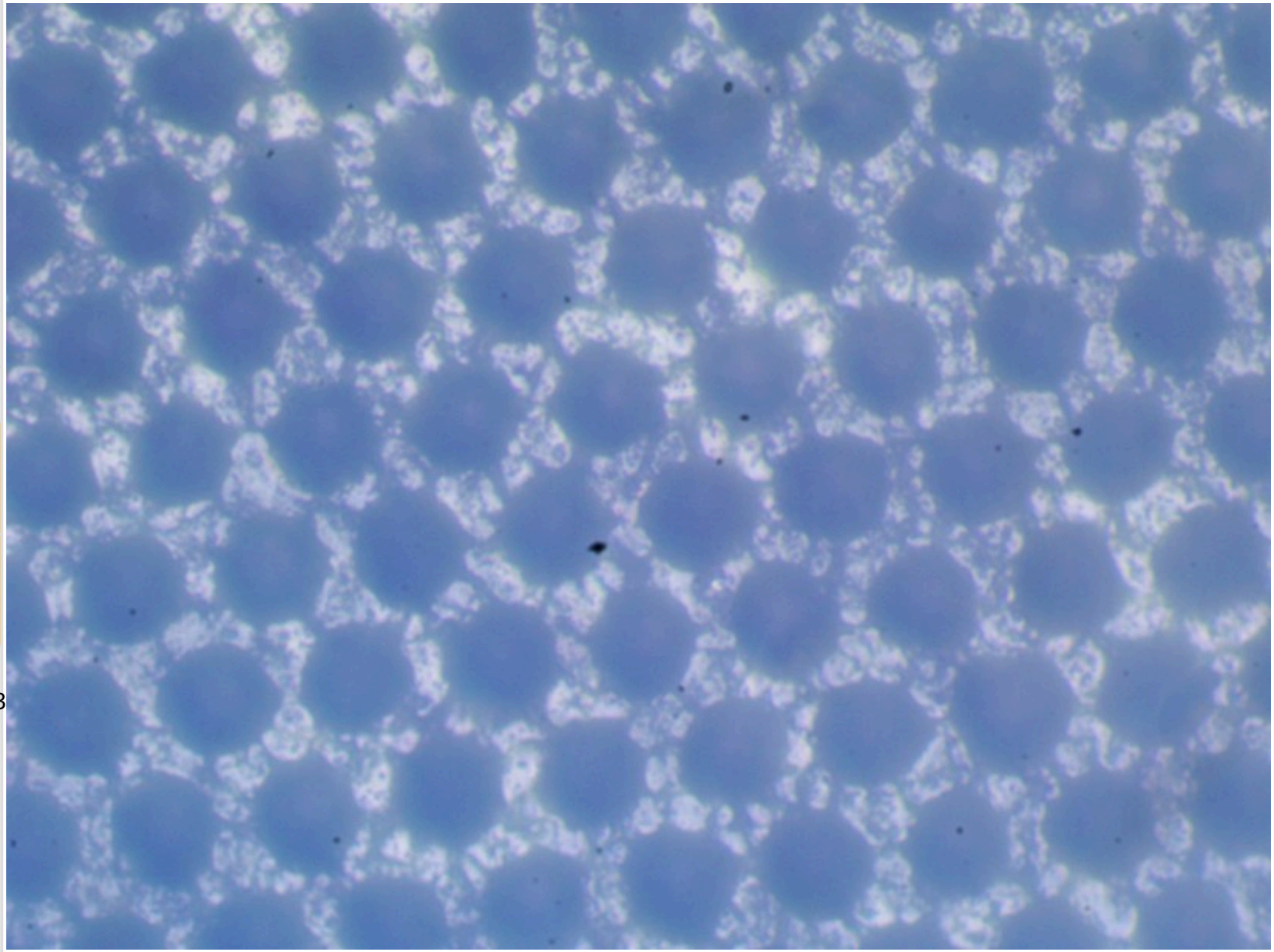
Ink transfer volume decrease from the nominal value: 34.29%

Bridge / Cell: 1 / 4
Depth before / after: 9.5 / 9.5 µm
Depth decreased by: 0%

Comment

streaks spot 270 wide streaks 110 293 661 805 1045

1160.
Roll is worn.



Page №50. Roll "3016196-02". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "3016196-02".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	120	lpcm
Vol	12.0	cm^3/m^2

LEC measurements by Troika:

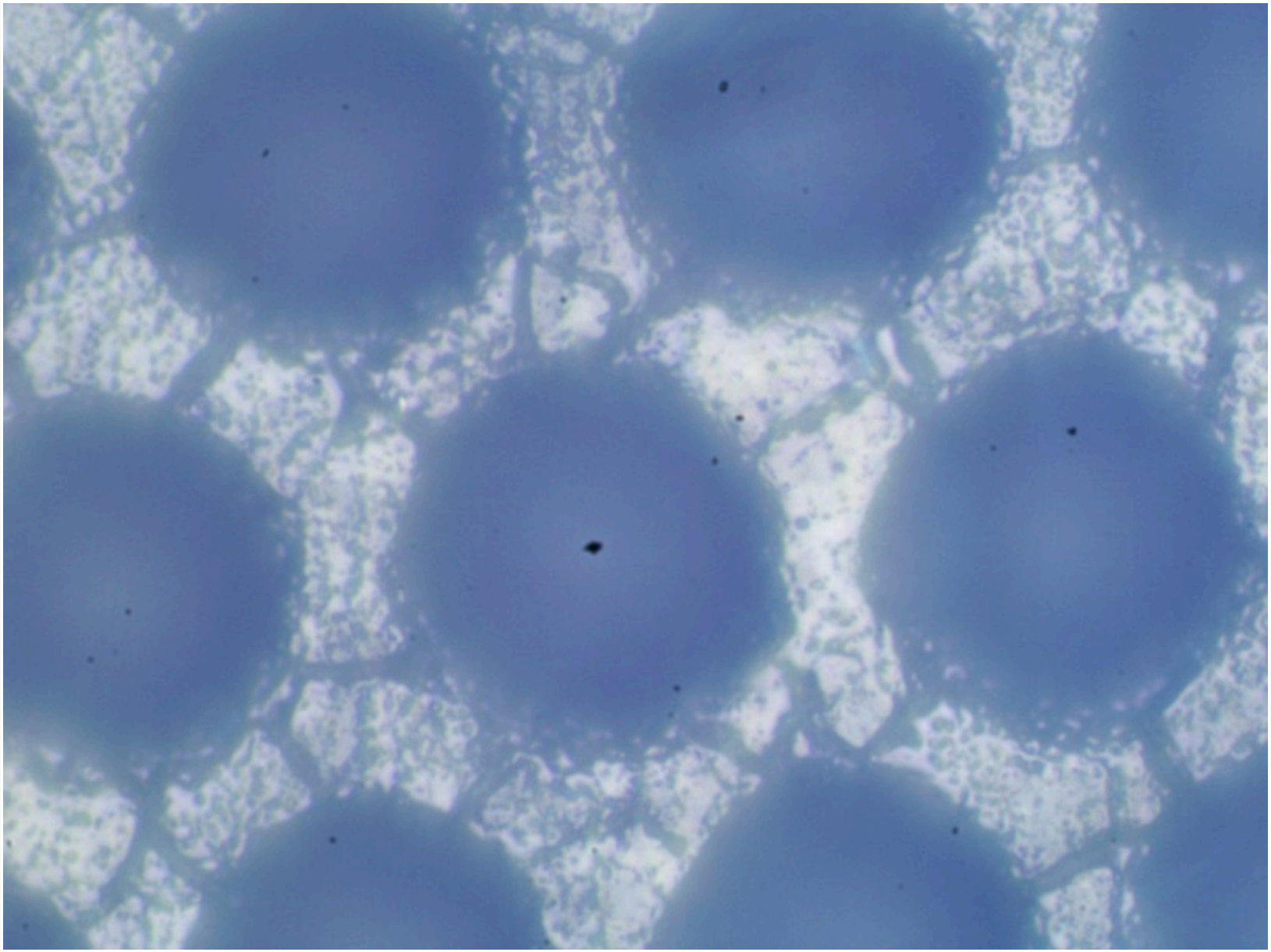
Measured line screen	120	lpcm
Vol	8.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 28.33%

Bridge / Cell: 1 / 7
Depth before / after: 28.5 / 28.5 µm
Depth decreased by: 0%

Comment

chips at edges scratch 260.
Roll is slightly worn.



Page №51. Roll "z19012420". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z19012420".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	13.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	9.10	cm^3/m^2

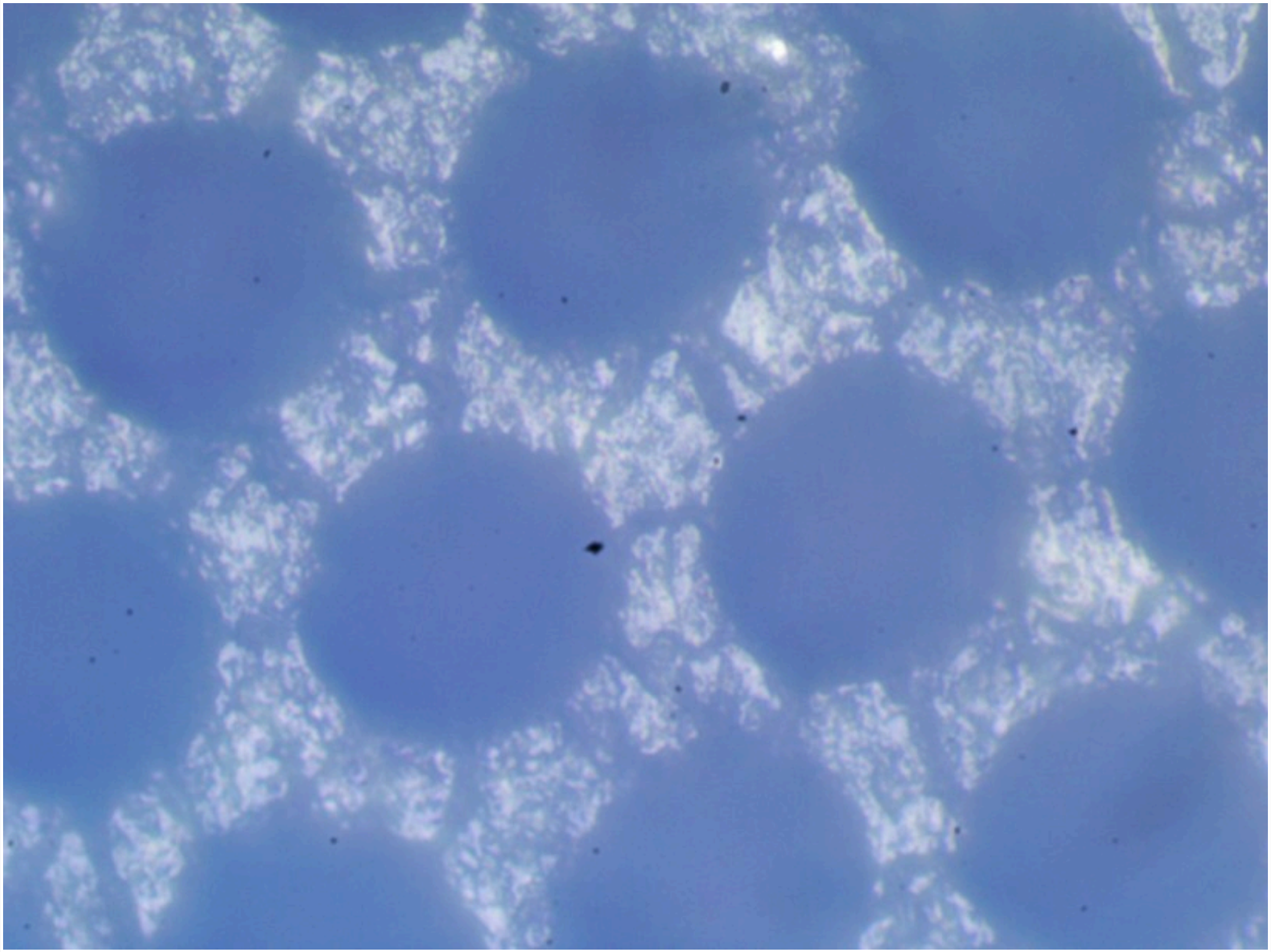
Ink transfer volume decrease from the nominal value: 30%

Bridge / Cell: 1 / 3
Depth before / after: 39 / 39 µm
Depth decreased by: 0%

Comment

streak 94 356 dent 270 282 302 scratch 594 722.

Roll is heavily worn.



Page №52. Roll "h100479-3". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100479-3".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

LEC measurements by Troika:

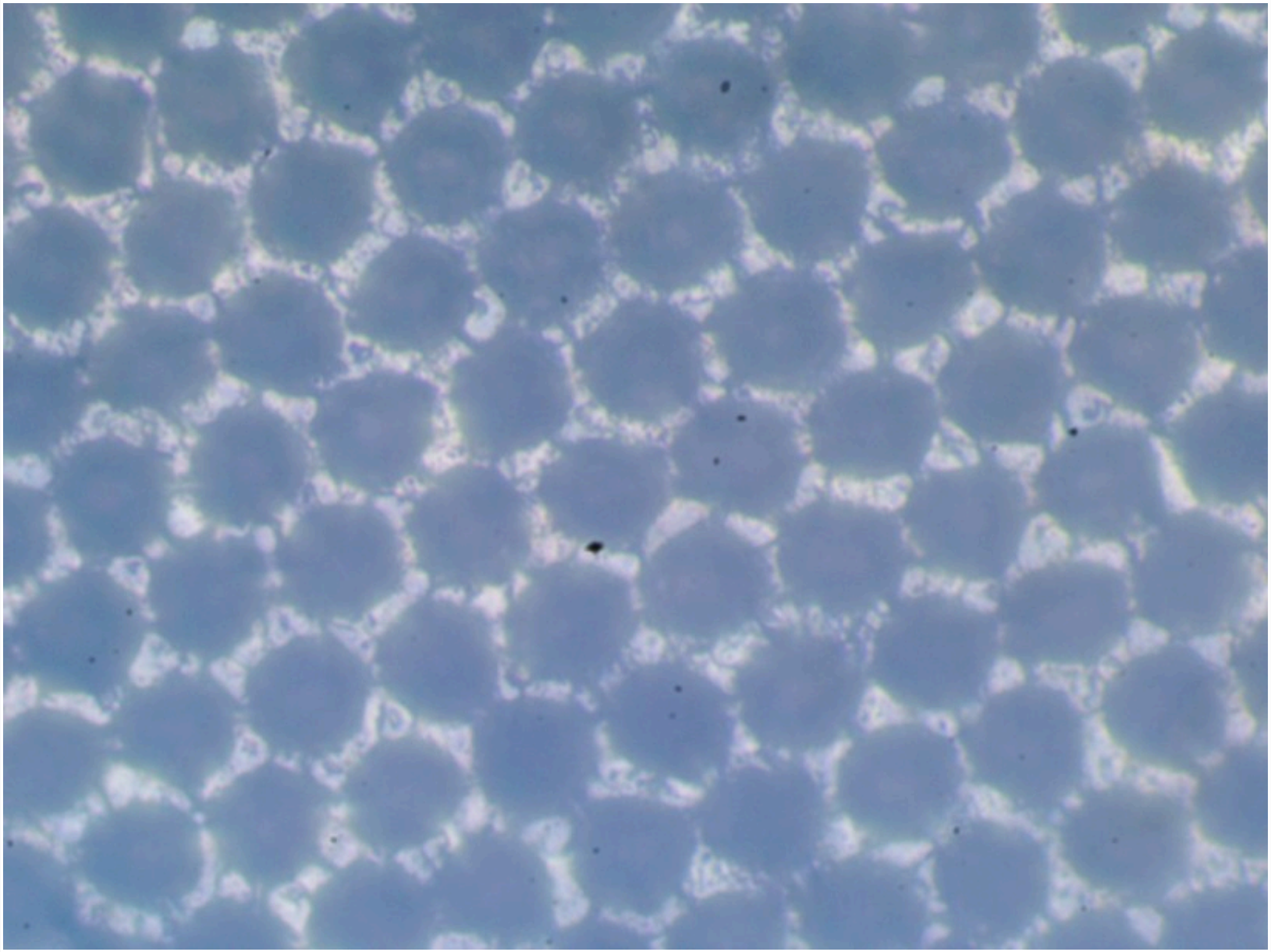
Measured line screen	420	lpcm
Vol	3.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10%

Bridge / Cell: 1 / 11
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment

streak 1233 603.



Page №53. Roll "sa008619". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008619".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	200	lpcm
Vol	9.0	cm^3/m^2

LEC measurements by Troika:

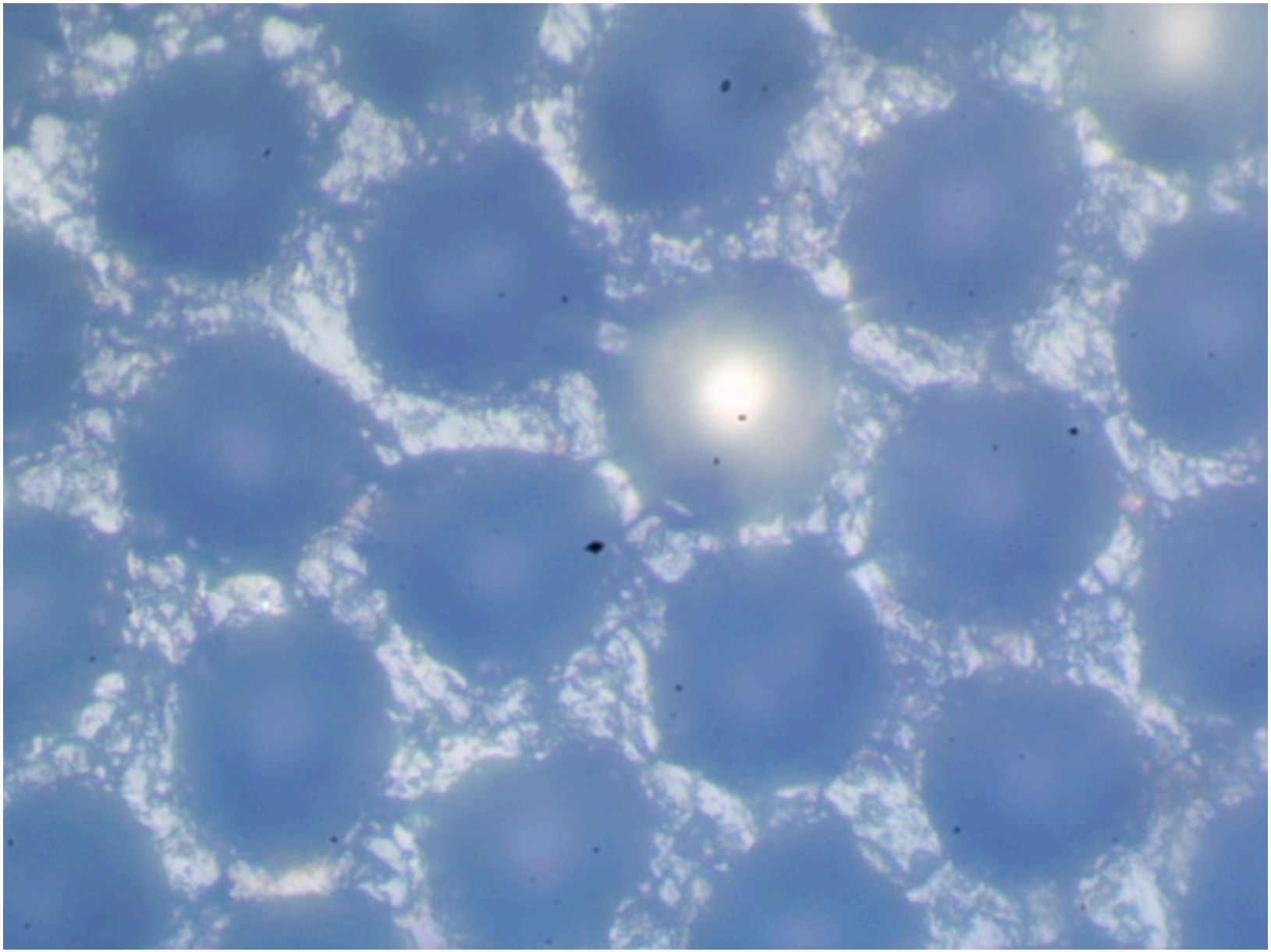
Measured line screen	200	lpcm
Vol	7.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 18.89%

Bridge / Cell: 1 / 6
Depth before / after: 25 / 25 µm
Depth decreased by: 0%

Comment

spot 60 70.
Roll is worn.



Page №54. Roll "z18008073". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18008073".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	9.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	3.40	cm^3/m^2

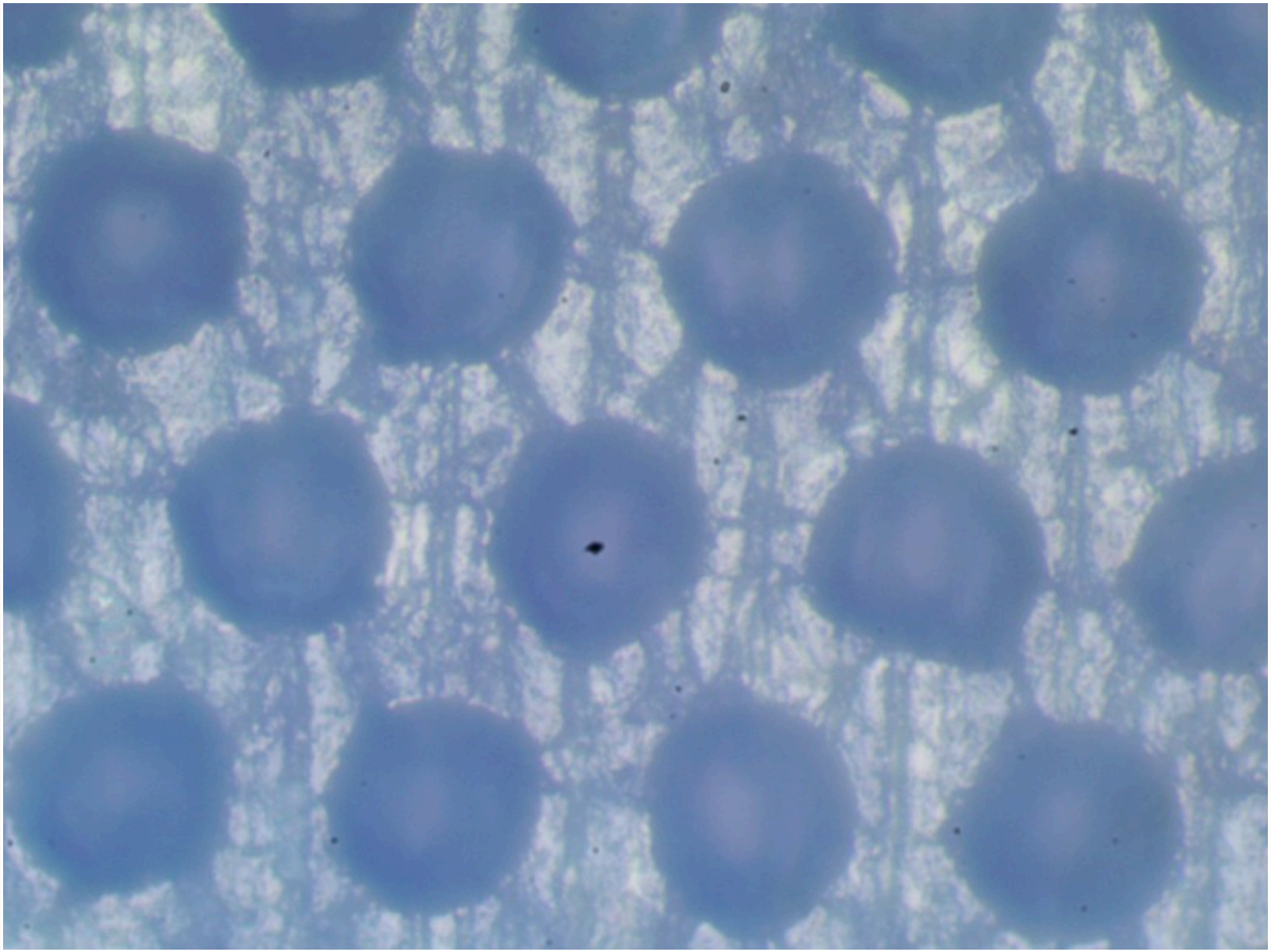
Ink transfer volume decrease from the nominal value: 62.22%

Bridge / Cell: 1 / 2
Depth before / after: 18 / 18 µm
Depth decreased by: 0%

Comment

mechanical wear chips 640 660 585 320 360 streak 320 885.

Roll is heavily worn.



Page №55. Roll "sa0088623". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa0088623".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	320	lpcm
Vol	6.0	cm^3/m^2

LEC measurements by Troika:

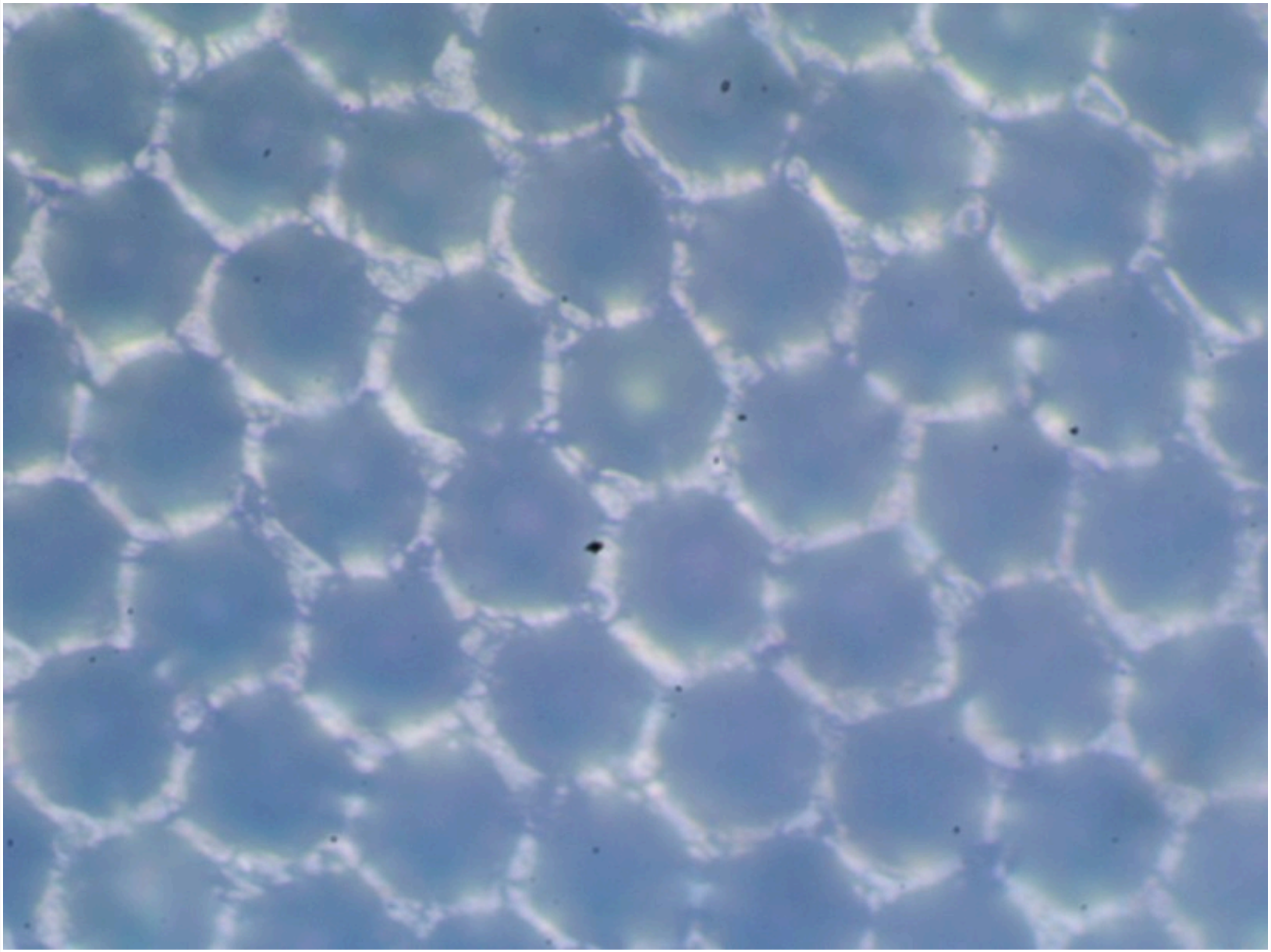
Measured line screen	300	lpcm
Vol	5.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 8.33%

Bridge / Cell: 1 / 10
Depth before / after: 17 / 17 µm
Depth decreased by: 0%

Comment

streak 370 575 673.



Page №56. Roll "h100749-4". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100749-4".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	300	lpcm
Vol	6.5	cm^3/m^2

LEC measurements by Troika:

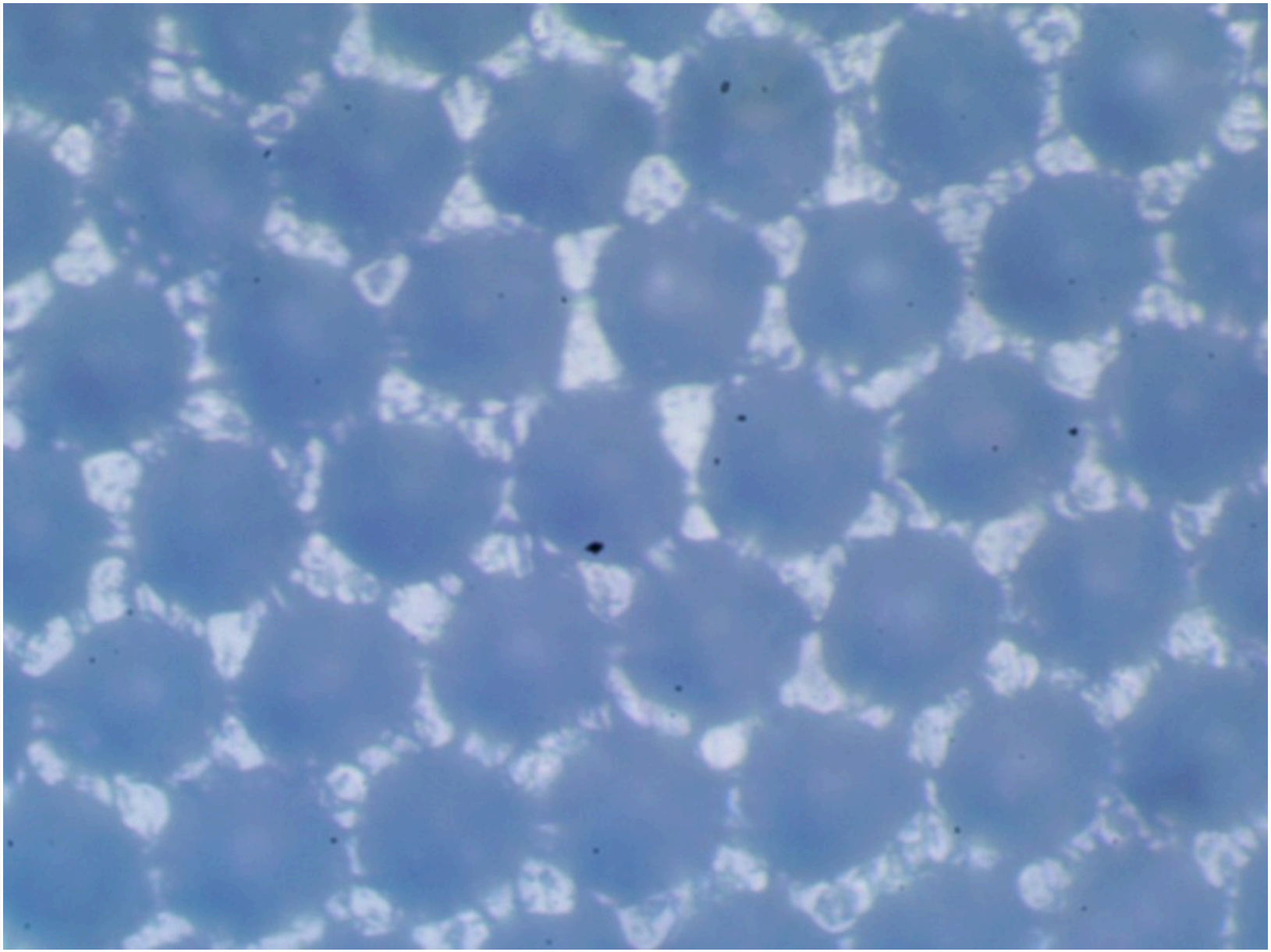
Measured line screen	300	lpcm
Vol	5.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 9.23%

Bridge / Cell: 1 / 16
Depth before / after: 17 / 17 µm
Depth decreased by: 0%

Comment

chip 890.



Page №57. Roll "sa008616". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008616".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	130	lpcm
Vol	14.0	cm^3/m^2

LEC measurements by Troika:

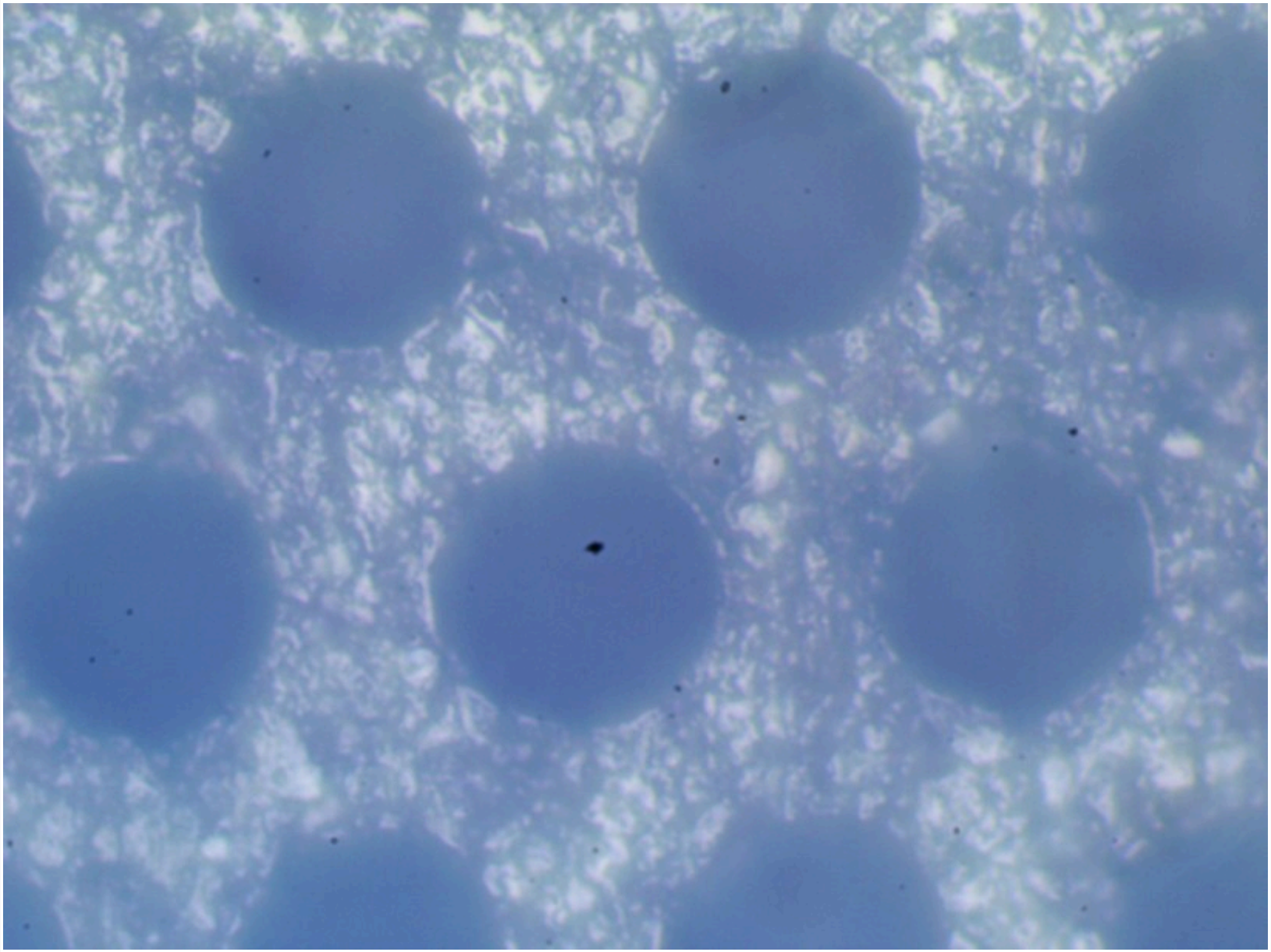
Measured line screen	130	lpcm
Vol	6.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 55.71%

Bridge / Cell: 1 / 2
Depth before / after: 36 / 36 µm
Depth decreased by: 0%

Comment

worn streaks scratch 220.
Roll is heavily worn.



Page №58. Roll "s2401739". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "s2401739".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	330	lpcm
Vol	4.0	cm^3/m^2

LEC measurements by Troika:

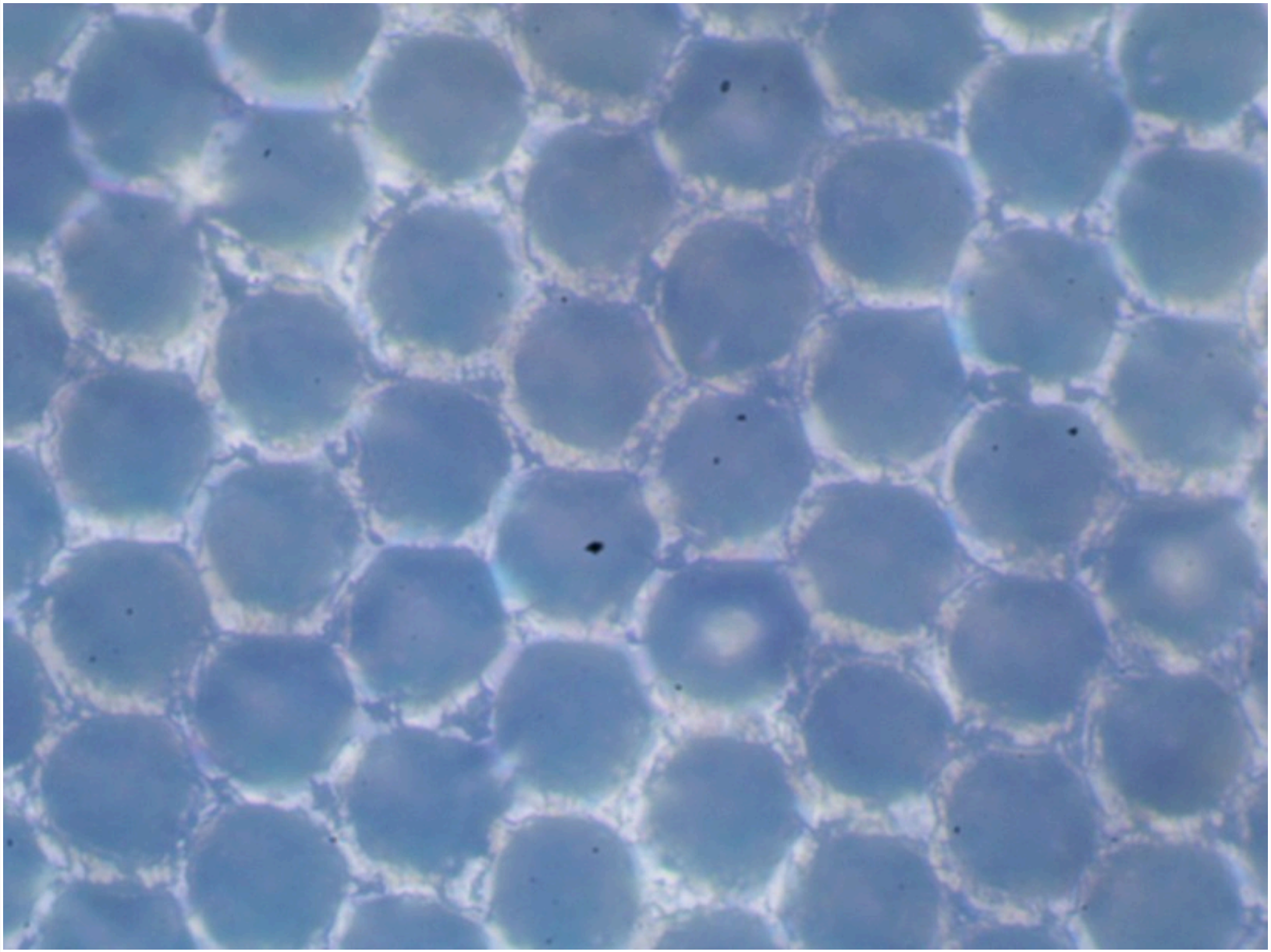
Measured line screen	330	lpcm
Vol	3.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 5%

Bridge / Cell: 1 / 14
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment

streak 30 1210 dent 1125.



Page №59. Roll "aa2413647". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413647".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	10.0	cm^3/m^2

LEC measurements by Troika:

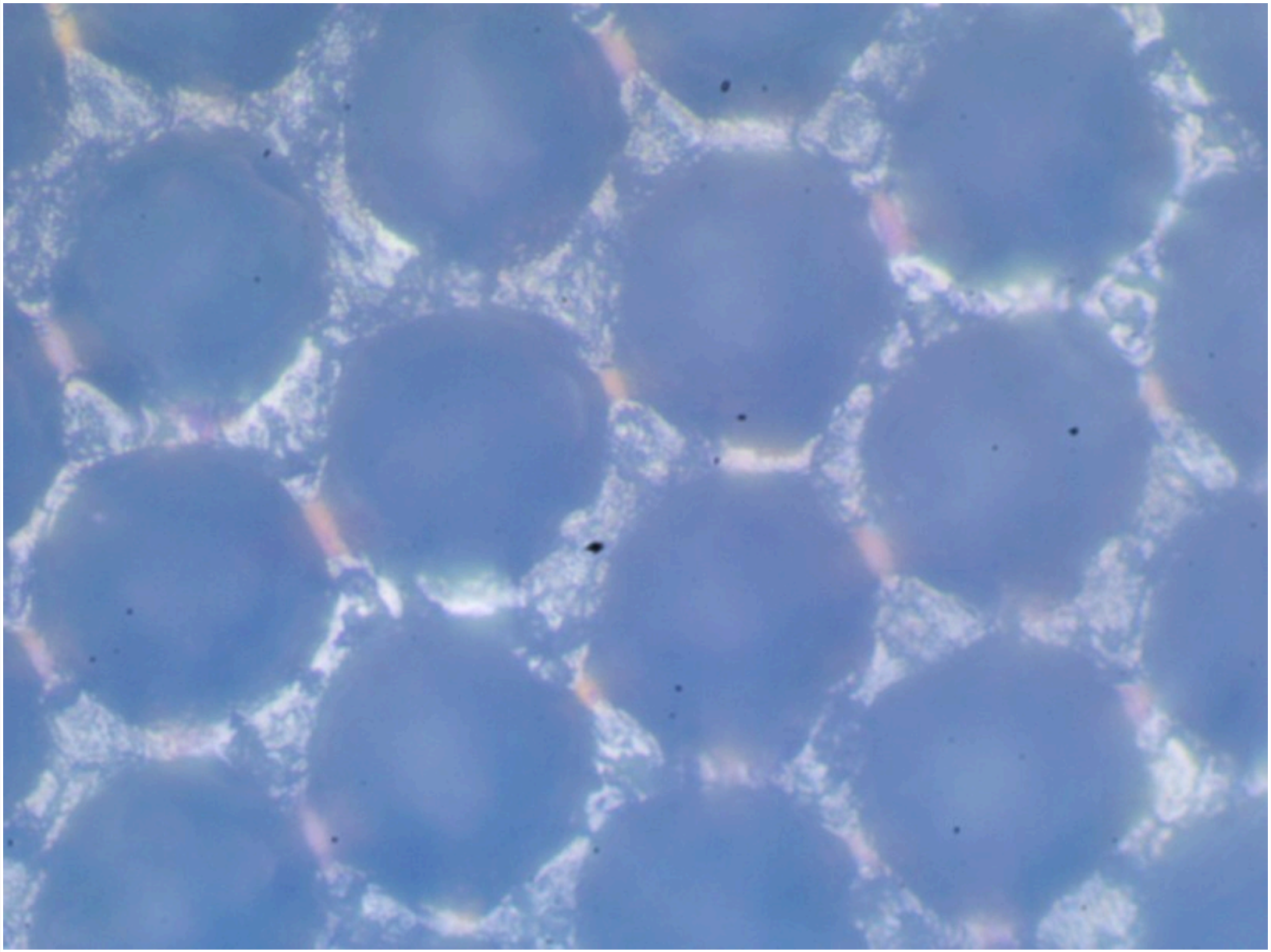
Measured line screen	180	lpcm
Vol	9.10	cm^3/m^2

Ink transfer volume decrease from the nominal value: 9%

Bridge / Cell: 1 / 18
Depth before / after: 26 / 26 µm
Depth decreased by: 0%

Comment

streaks streak 30.



Page №60. Roll "z18008078". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18008078".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	13.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	5.90	cm^3/m^2

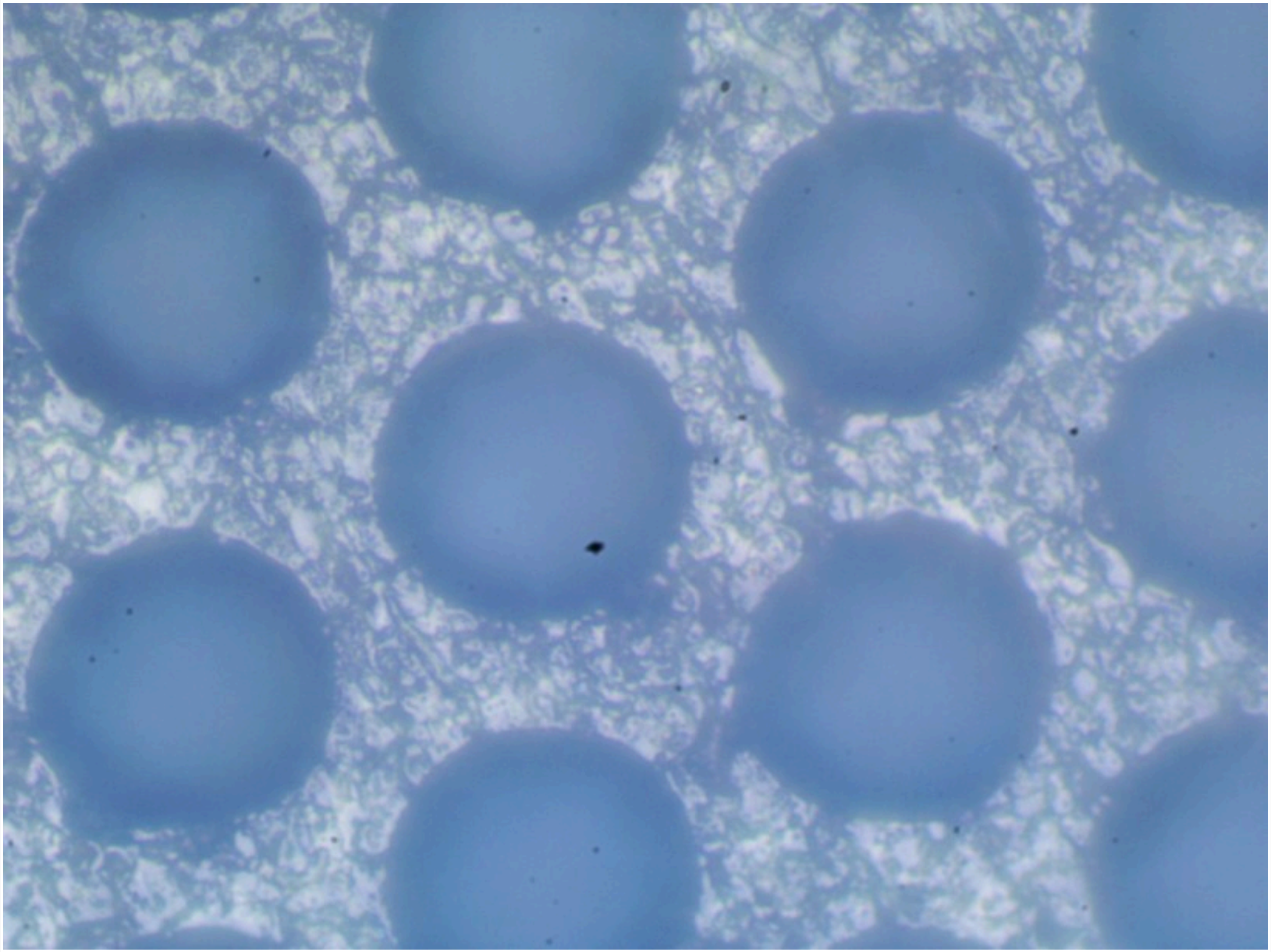
Ink transfer volume decrease from the nominal value: 54.62%

Bridge / Cell: 1 / 3
Depth before / after: 26 / 26 µm
Depth decreased by: 0%

Comment

mechanical damage 80 scratch 1310 dent 270 300 streak 340 spot 150.

Roll is heavily worn.



Page №61. Roll "h100749-2". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100749-2".	Photo of the anilox roll surface

Roll designations:

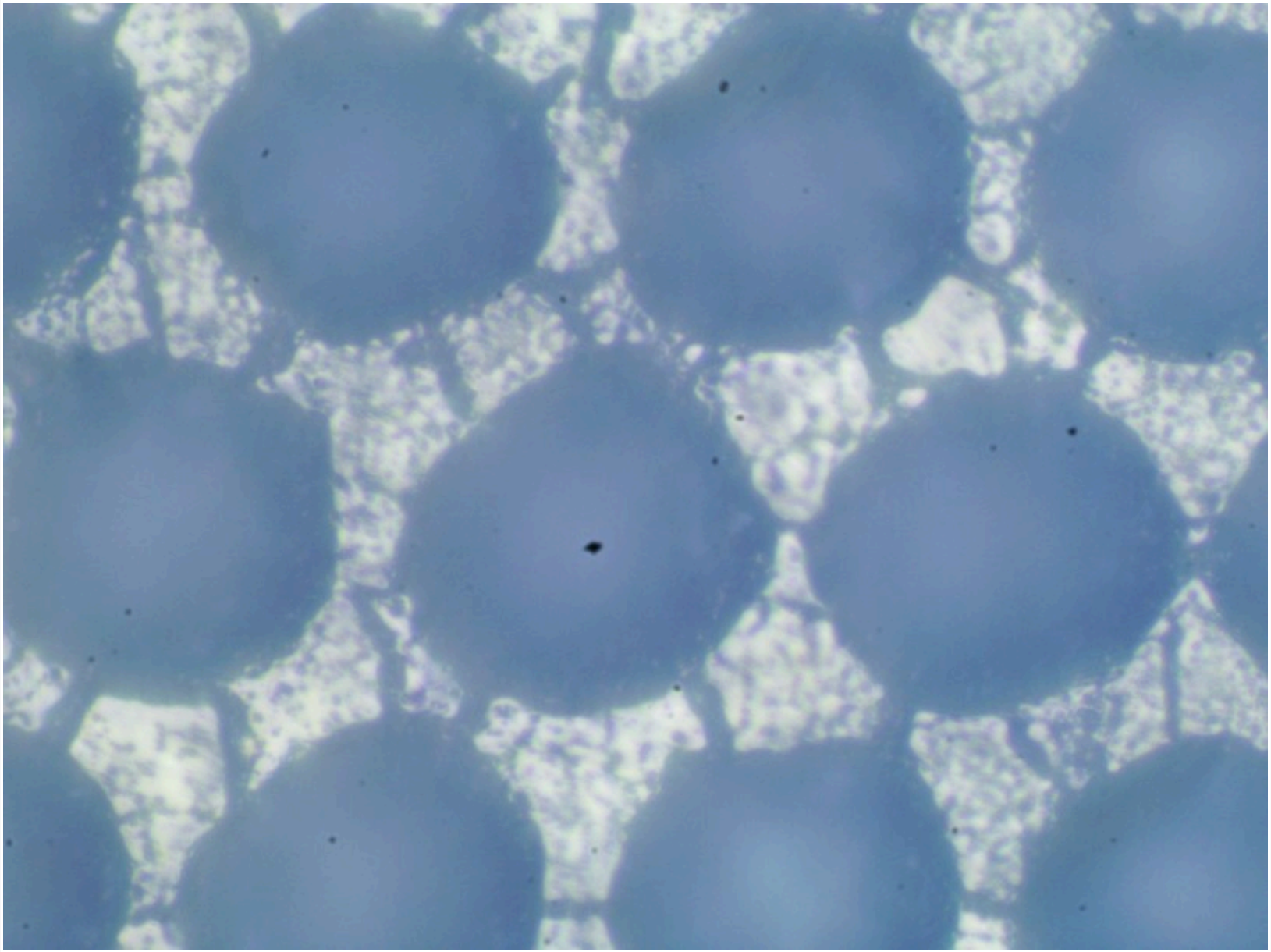
Nominal line screen	140	lpcm
Vol	12.5	cm^3/m^2

LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	9.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 25.6%

Bridge / Cell: 1 / 7
Depth before / after: 31 / 31 µm
Depth decreased by: 0%



Comment
chips at edges dents 215 170 150.
Roll is slightly worn.

Page №62. Roll "h100479-5". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100479-5".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

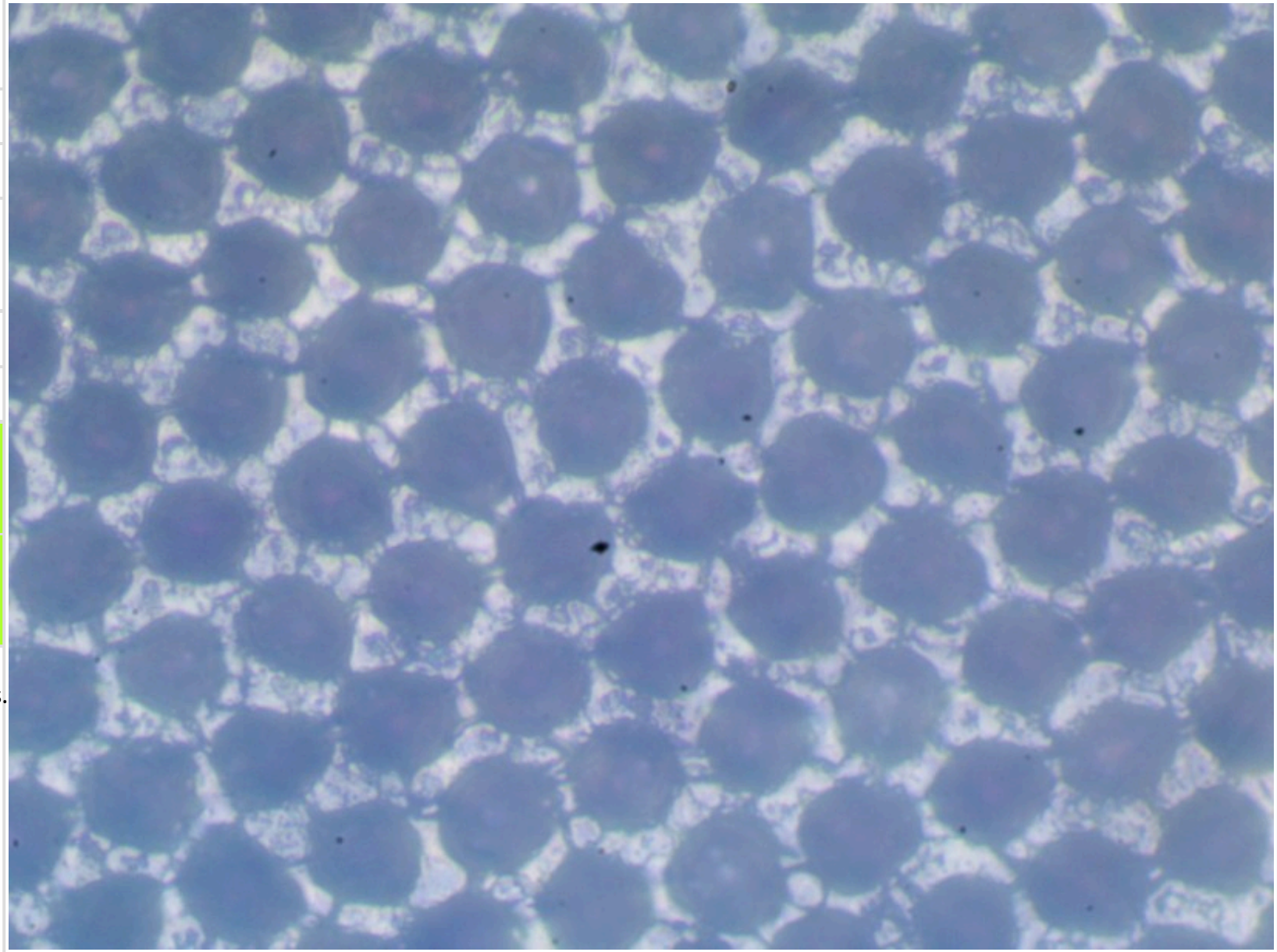
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	3.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10%

Bridge / Cell: 1 / 11
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
dent 740 1000 1160 1250 fine streaks.



Page №63. Roll "sd007092". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sd007092".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

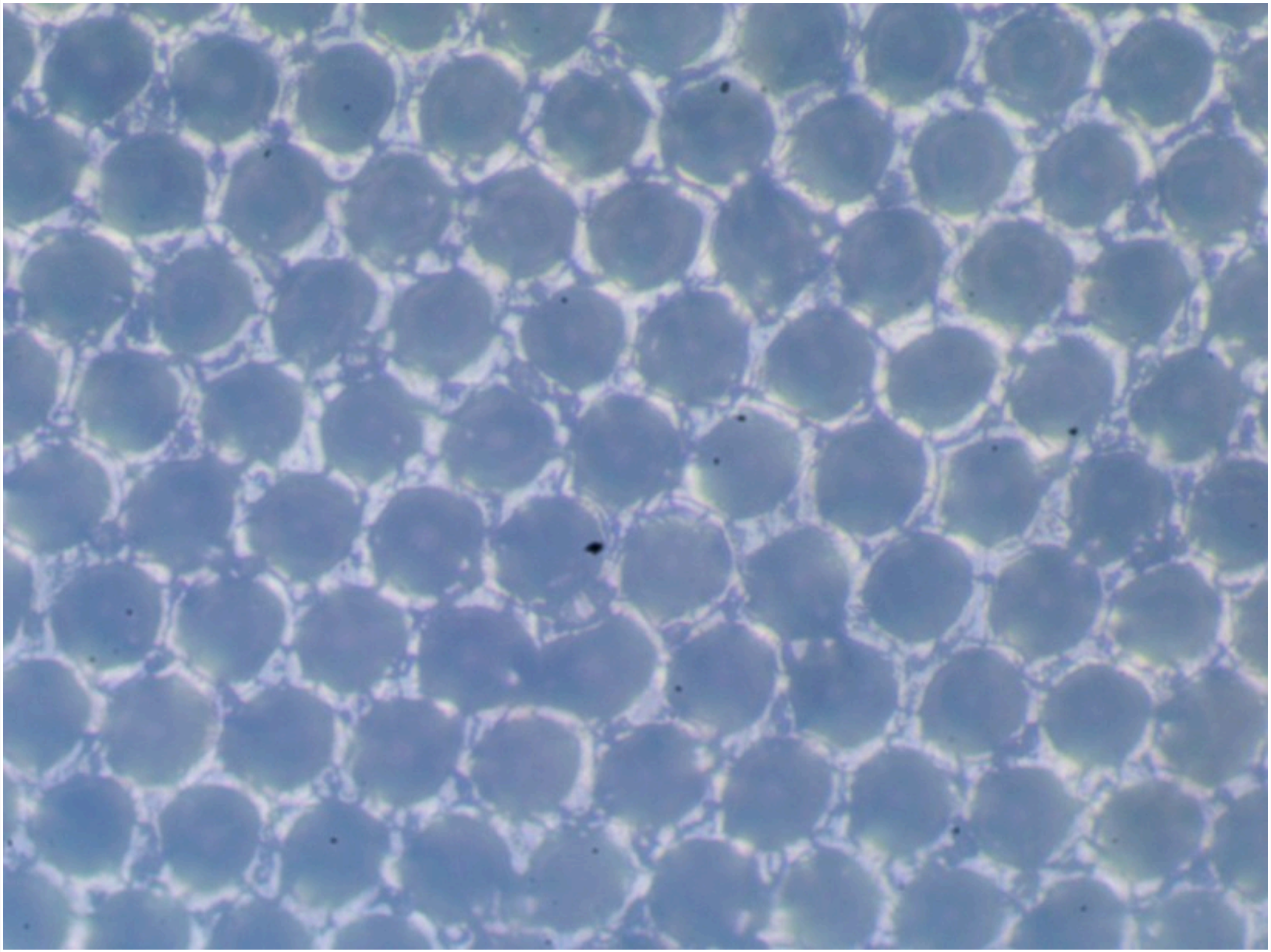
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 5.26%

Bridge / Cell: 1 / 10
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
streak 687 590 118 900.



Page №64. Roll "h100479-6". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100479-6".	Photo of the anilox roll surface

Roll designations:

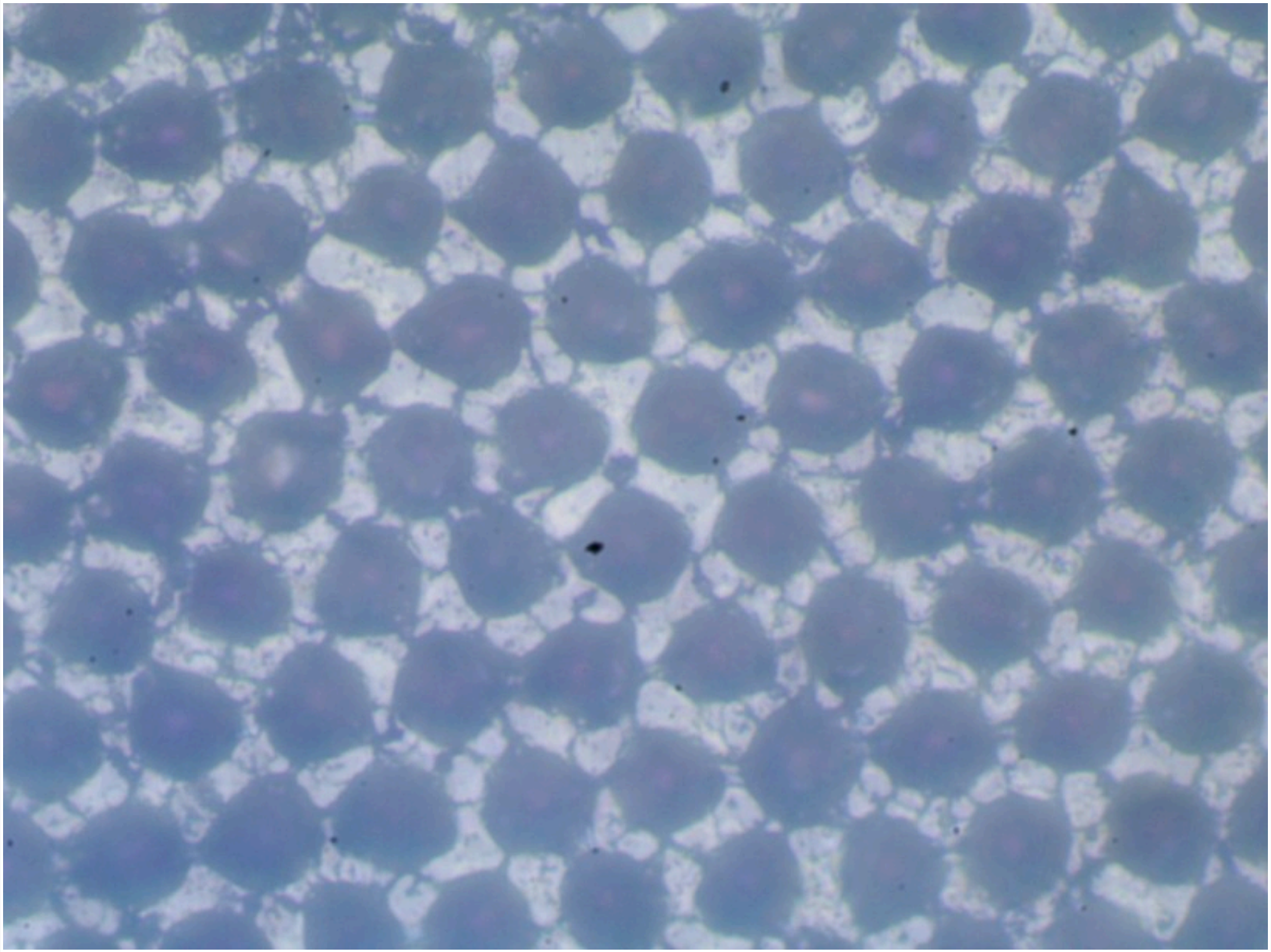
Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	2.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 27.5%

Bridge / Cell: 1 / 5
Depth before / after: 11 / 11 µm
Depth decreased by: 0%



Comment
streak 97 203 297 377 788 892 1140.
Roll is worn.

Page №65. Roll "s2401742". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "s2401742".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	240	lpcm
Vol	6.5	cm^3/m^2

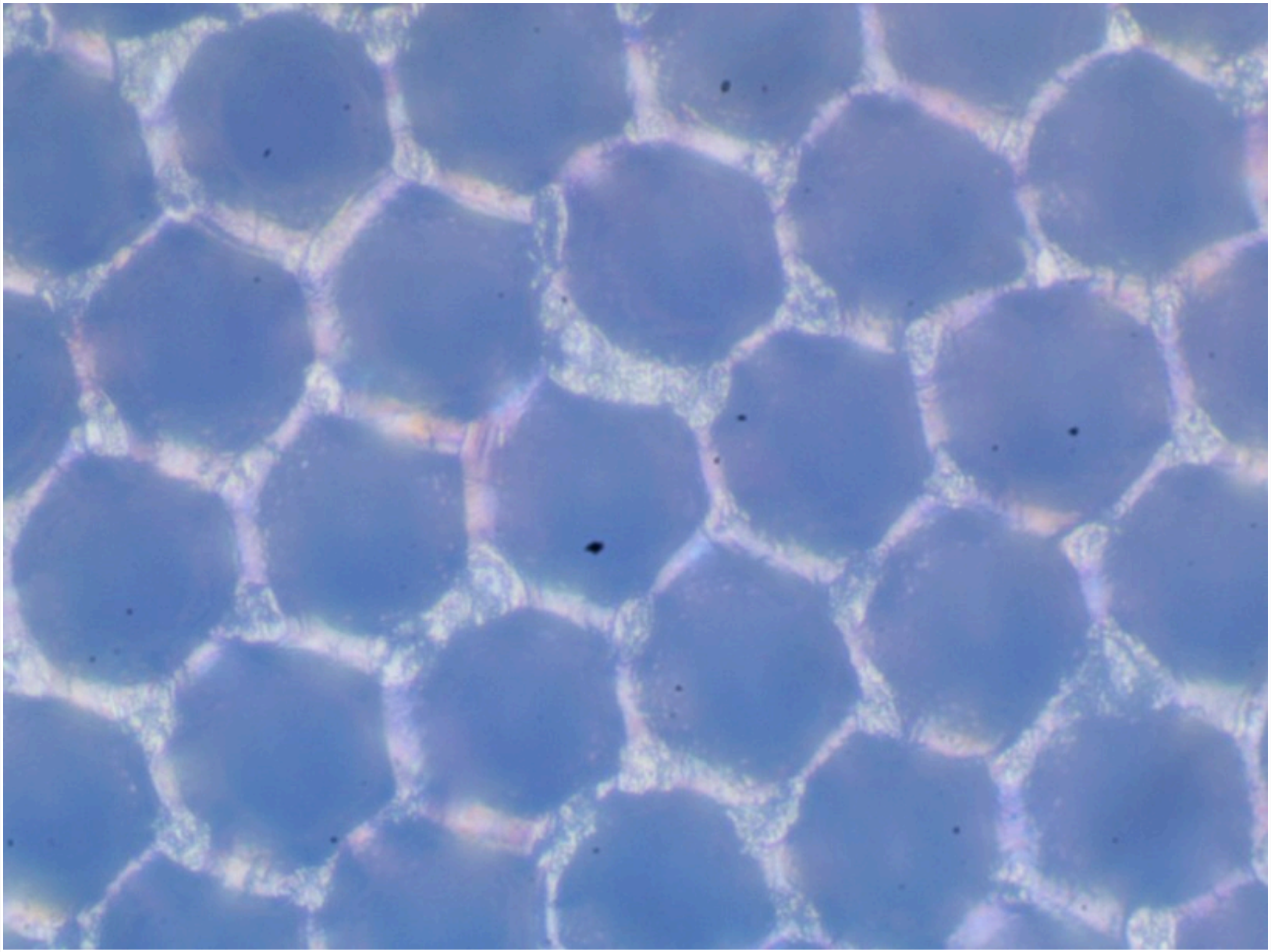
LEC measurements by Troika:

Measured line screen	240	lpcm
Vol	5.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10.77%

Bridge / Cell: 1 / 13
Depth before / after: 17 / 17 µm
Depth decreased by: 0%

Comment
streak 270.



Page №66. Roll "s2401659". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "s2401659".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

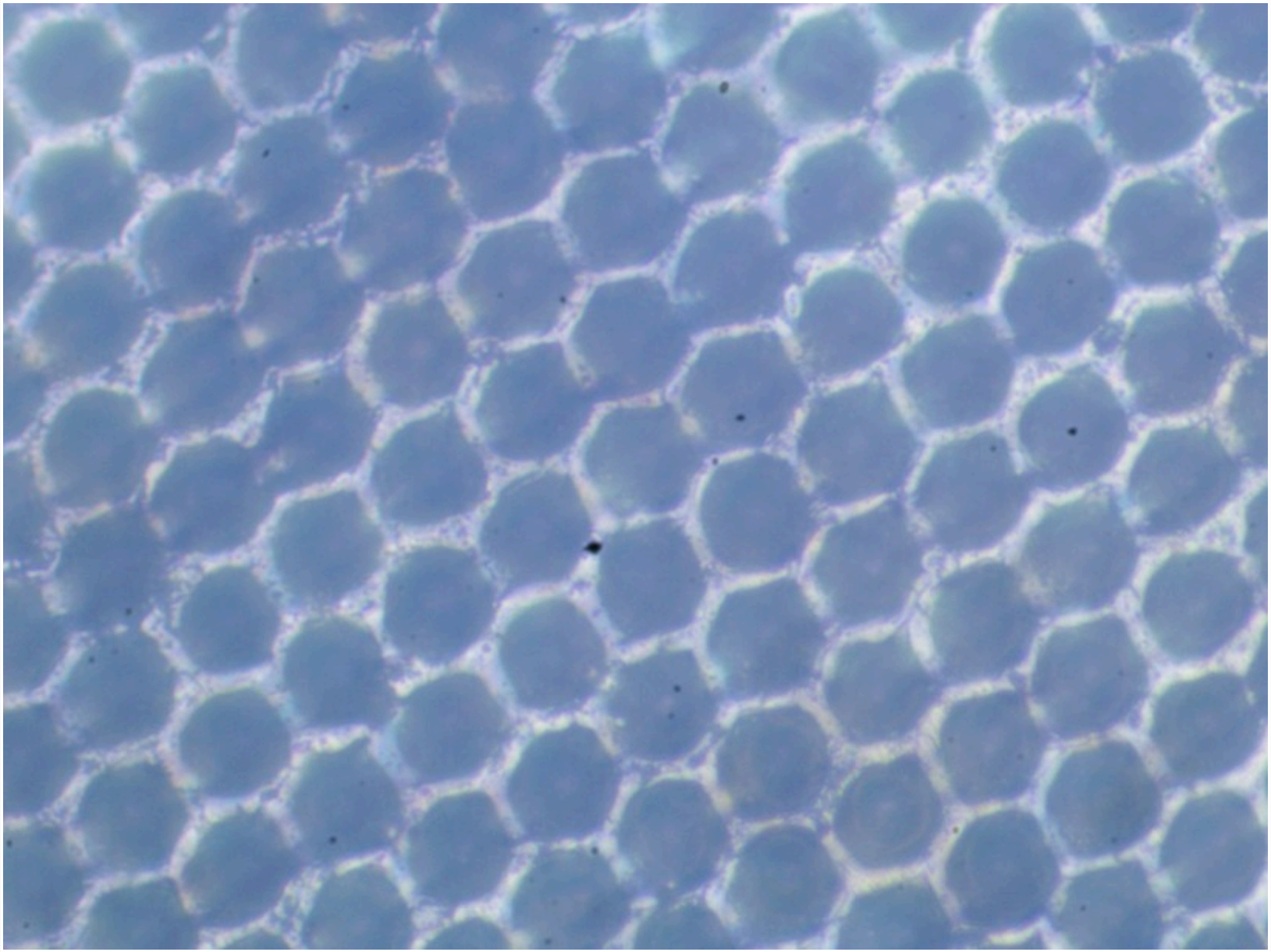
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 15.79%

Bridge / Cell: 1 / 10
Depth before / after: 10 / 10 µm
Depth decreased by: 0%

Comment



Page №67. Roll "aa2413648". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413648".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	7.5	cm^3/m^2

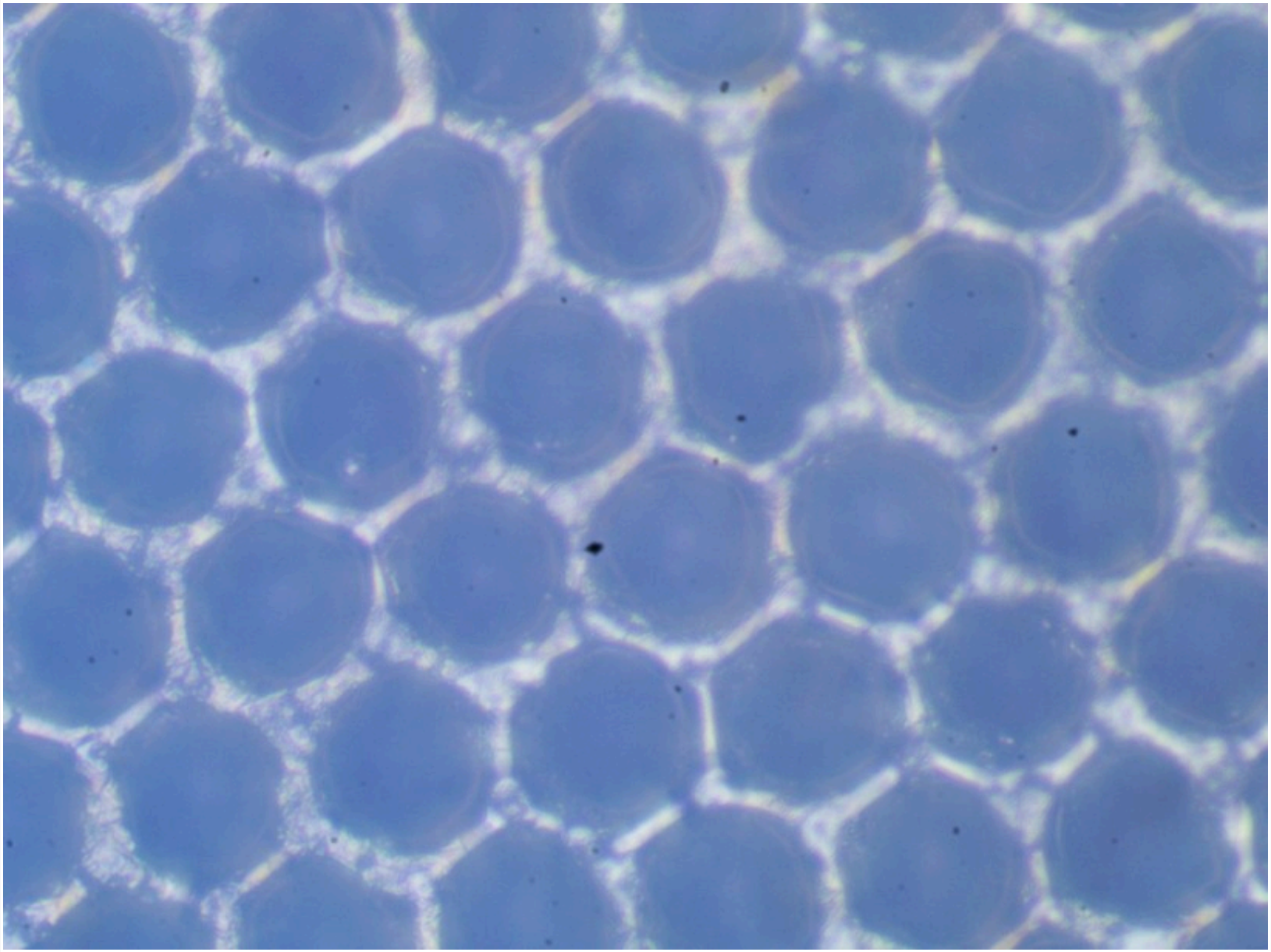
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	6.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10.67%

Bridge / Cell: 1 / 6
Depth before / after: 23 / 23 µm
Depth decreased by: 0%

Comment
Roll is worn.



Page №68. Roll "aa2413649". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413649".	Photo of the anilox roll surface

Roll designations:

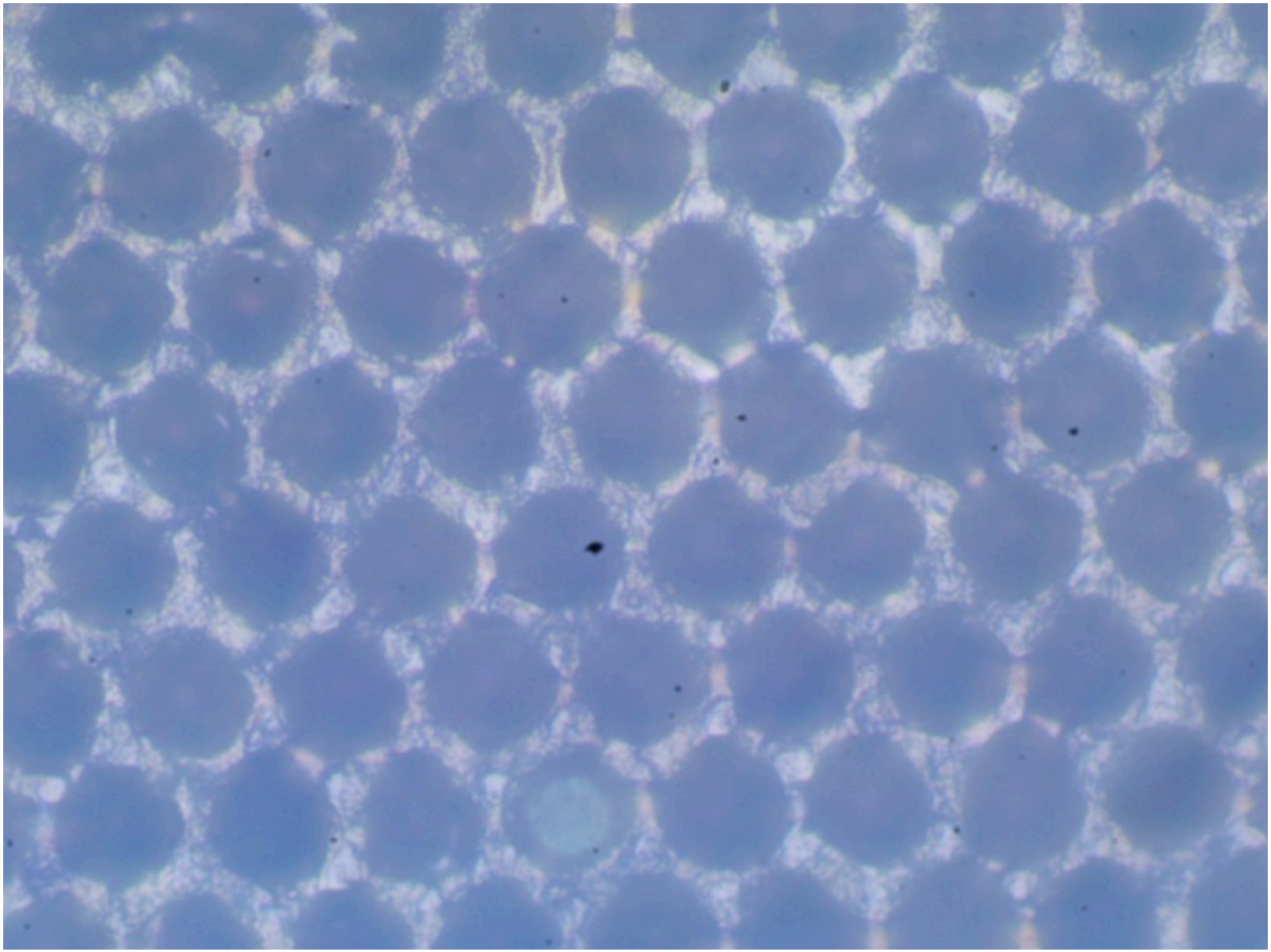
Nominal line screen	380	lpcm
Vol	5.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	380	lpcm
Vol	3.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 24%

Bridge / Cell: 1 / 4
Depth before / after: 15 / 15 µm
Depth decreased by: 0%



Comment
streak 175.
Roll is worn.

Page №69. Roll "s2401740". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "s2401740".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	330	lpcm
Vol	4.0	cm^3/m^2

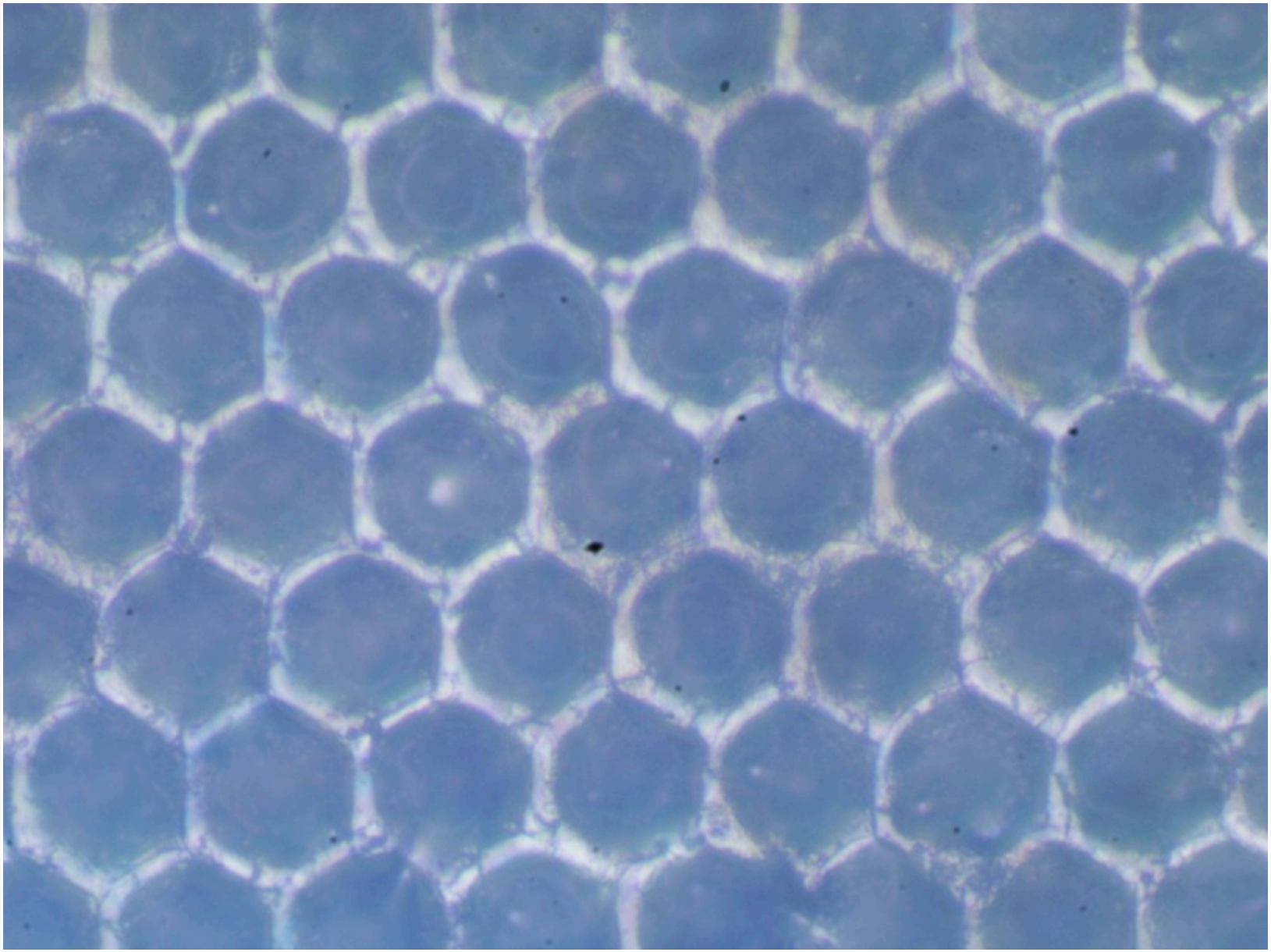
LEC measurements by Troika:

Measured line screen	320	lpcm
Vol	3.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 12.5%

Bridge / Cell: 1 / 9
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment



Page №70. Roll "s2401741". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "s2401741".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	200	lpcm
Vol	8.0	cm^3/m^2

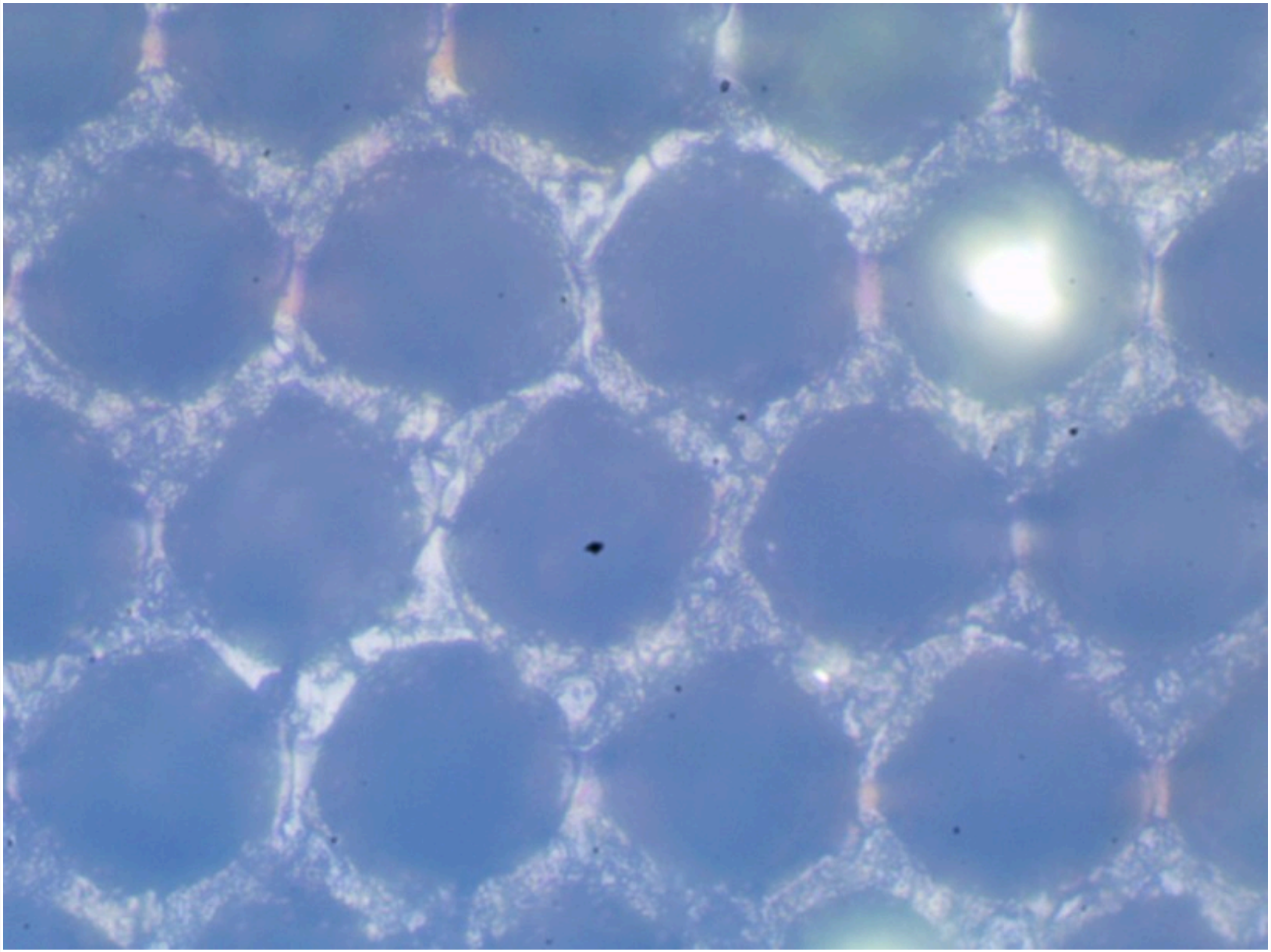
LEC measurements by Troika:

Measured line screen	200	lpcm
Vol	7.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 5%

Bridge / Cell: 1 / 6
Depth before / after: 26 / 26 µm
Depth decreased by: 0%

Comment
Roll is worn.



Page №71. Roll "aa2013651". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2013651".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

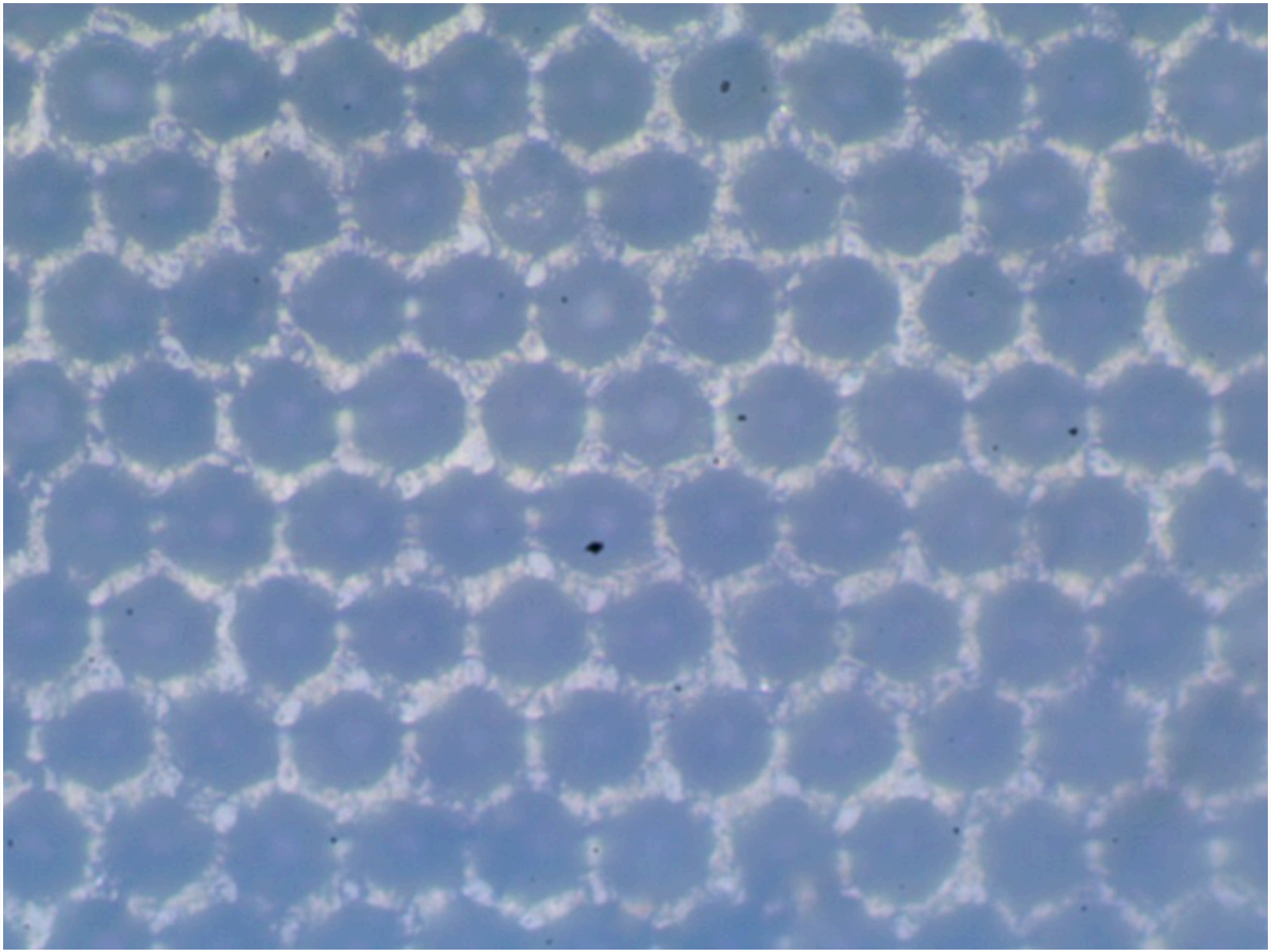
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 7.89%

Bridge / Cell: 1 / 6
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment
streak 150 272 478 530 912.
Roll is worn.



Page №72. Roll "sg4904612". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg4904612".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	7.6	cm^3/m^2

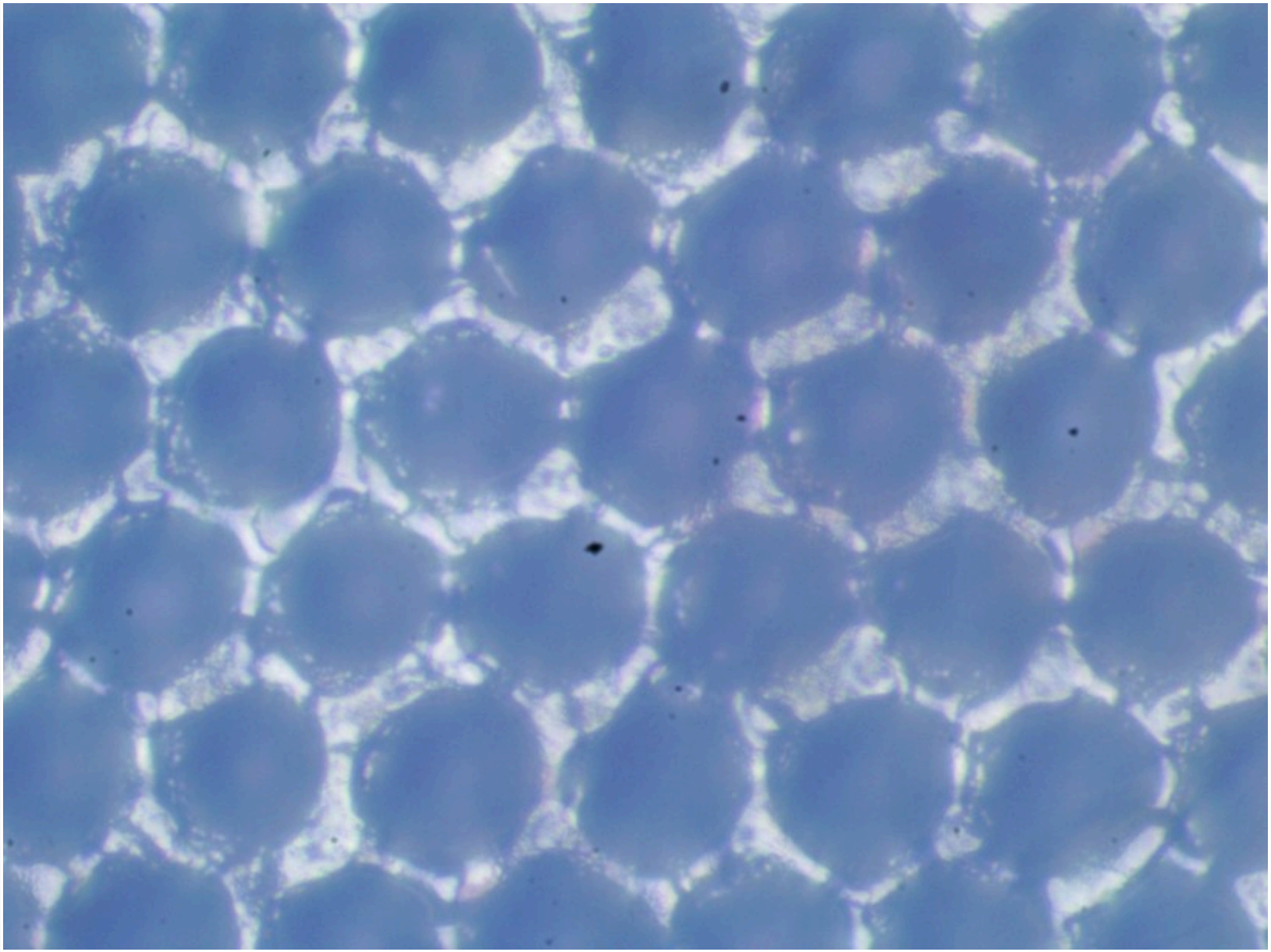
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	6.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 15.79%

Bridge / Cell: 1 / 8
Depth before / after: 21 / 21 µm
Depth decreased by: 0%

Comment
Roll is slightly worn.



Page №73. Roll "s2401718". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "s2401718".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

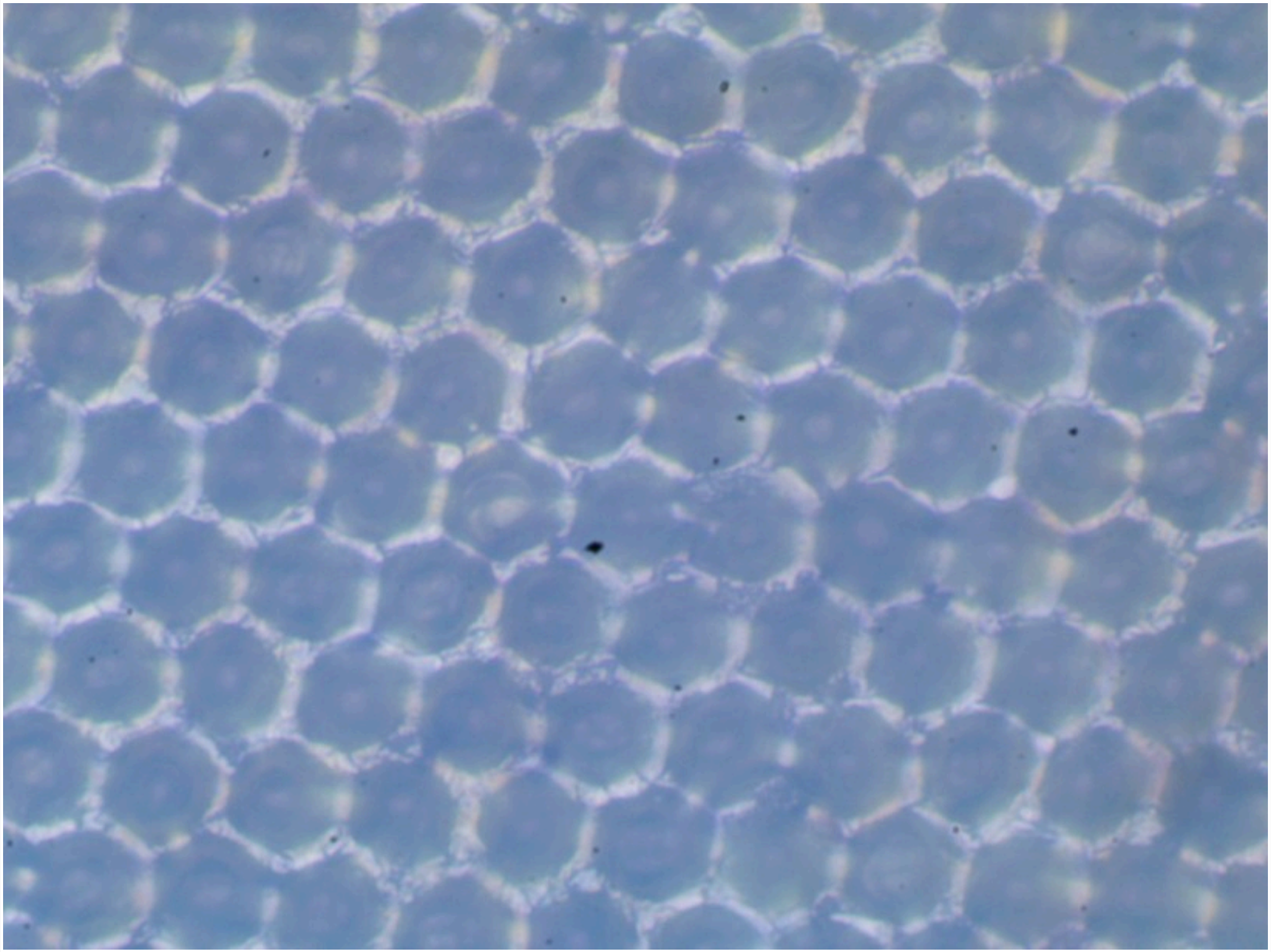
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10.53%

Bridge / Cell: 1 / 5
Depth before / after: 13 / 13 µm
Depth decreased by: 0%

Comment
Roll is worn.



Page №74. Roll "aa2413652". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413652".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

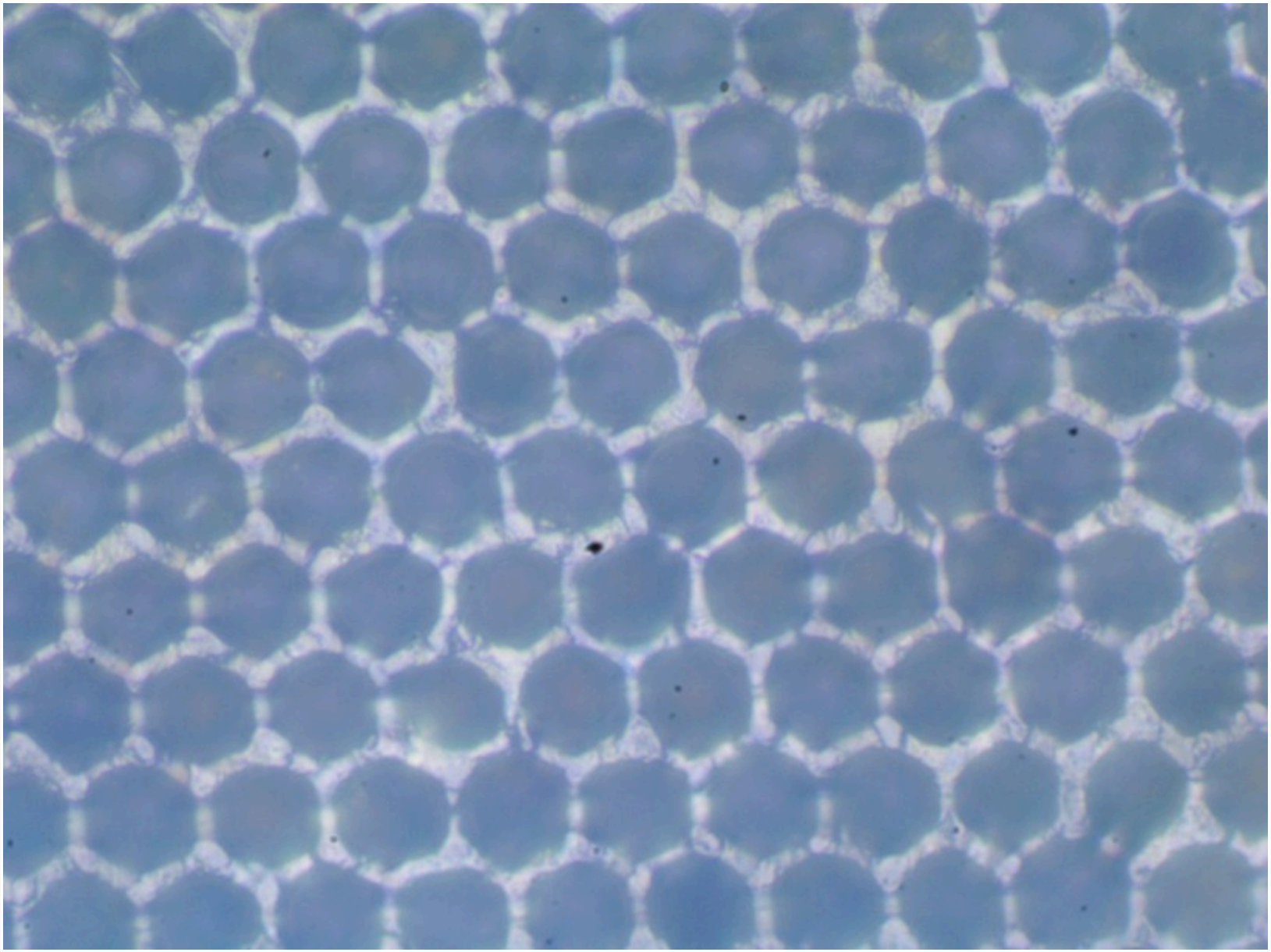
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 7.89%

Bridge / Cell: 1 / 6
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment
streak 575 600.
Roll is worn.



Page №75. Roll "s2401660". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "s2401660".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

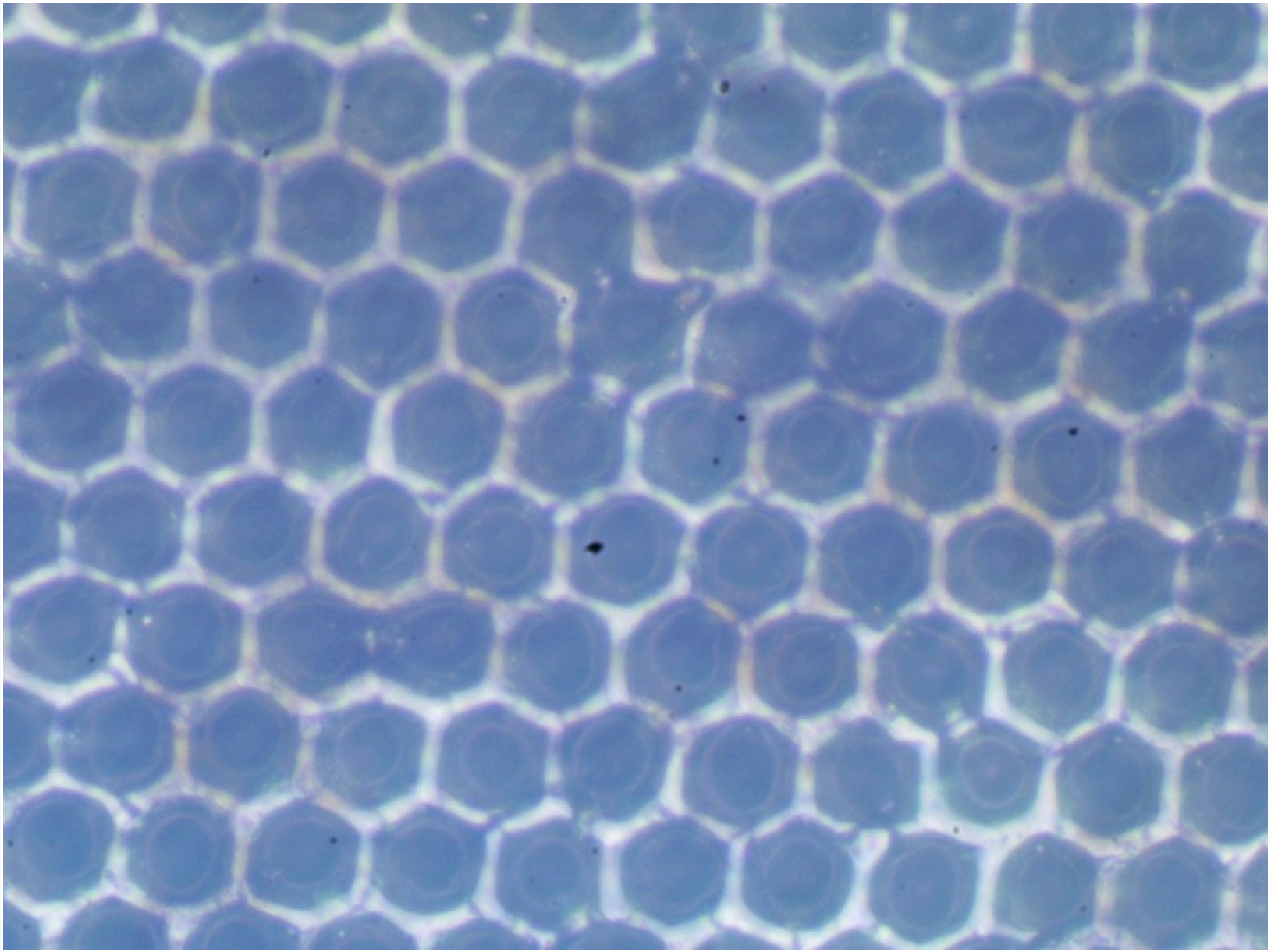
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 7.89%

Bridge / Cell: 1 / 10
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
streaks scratches 250.



Page №76. Roll "z17011027". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011027".	Photo of the anilox roll surface

Roll designations:

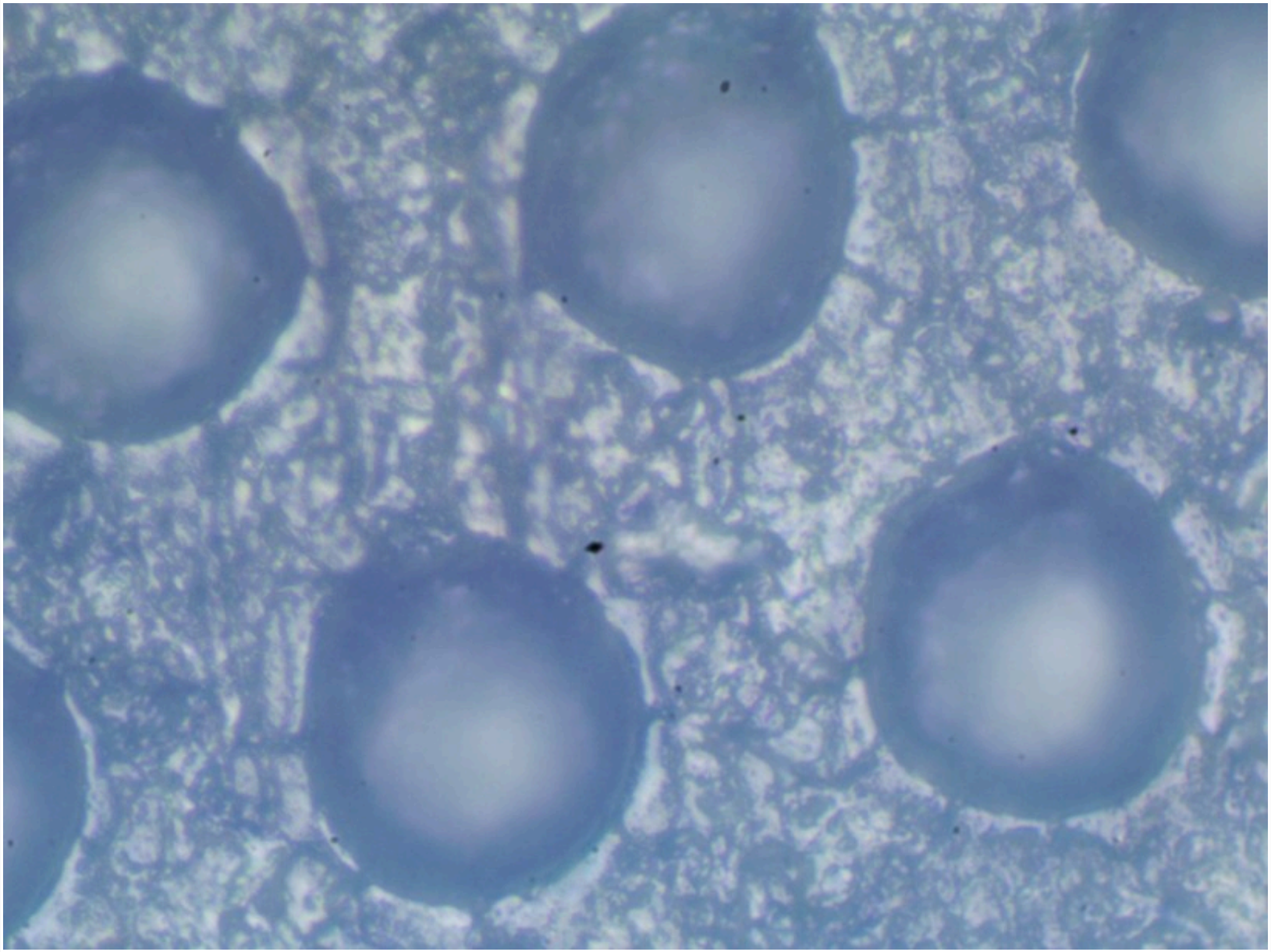
Nominal line screen	100	lpcm
Vol	11.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	100	lpcm
Vol	3.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 70.91%

Bridge / Cell: 1 / 2
Depth before / after: 20 / 20 µm
Depth decreased by: 0%



Comment
worn.
Roll is heavily worn.

Page №77. Roll "sa008587". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008587".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	110	lpcm
Vol	13.0	cm^3/m^2

LEC measurements by Troika:

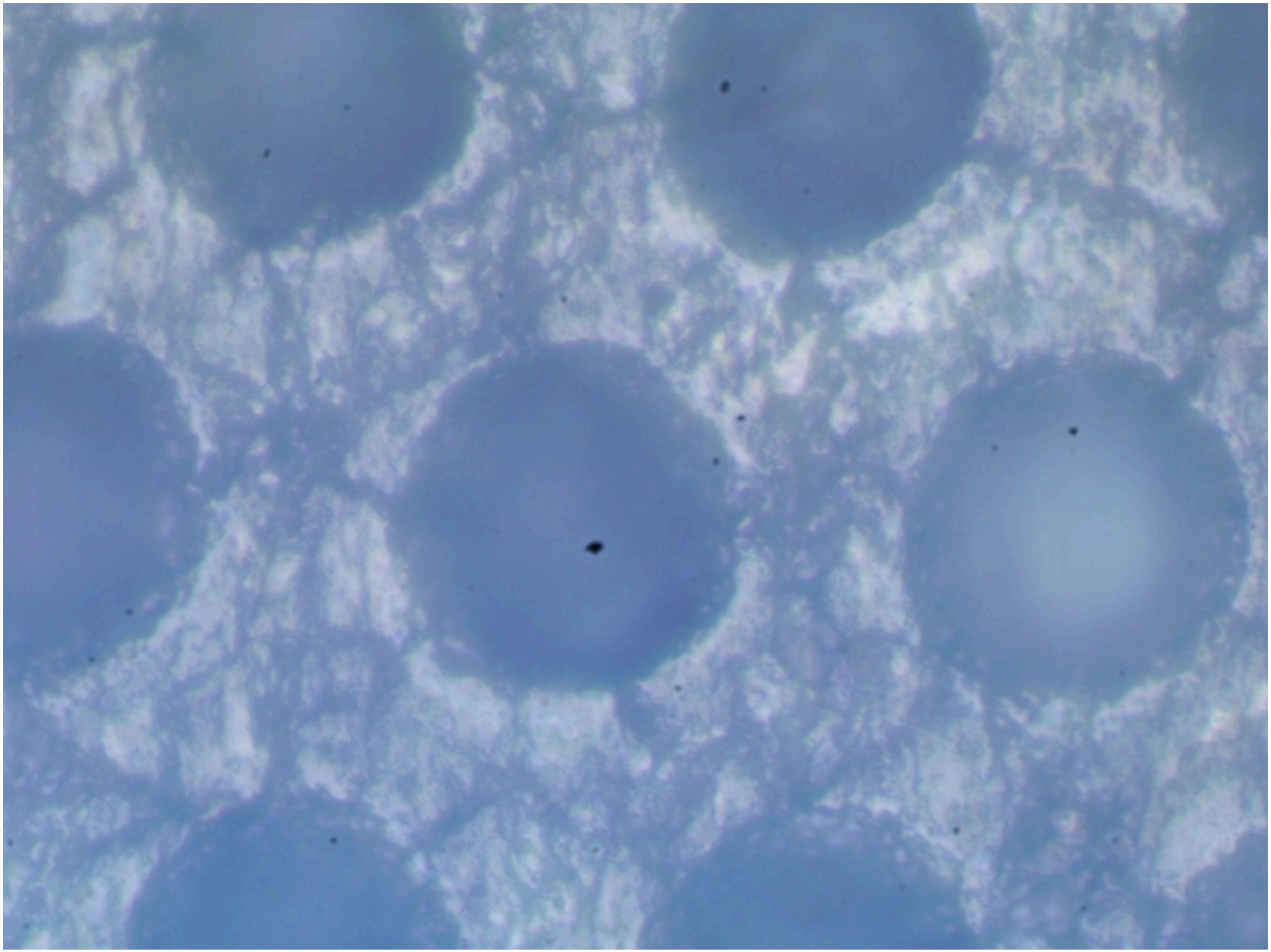
Measured line screen	110	lpcm
Vol	5.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 58.46%

Bridge / Cell: 1 / 2
Depth before / after: 33 / 33 µm
Depth decreased by: 0%

Comment
scratch 1030 1070 streak 938 280 worn.

Roll is heavily worn.



Page №78. Roll "z18009229". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18009229".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	9.5	cm^3/m^2

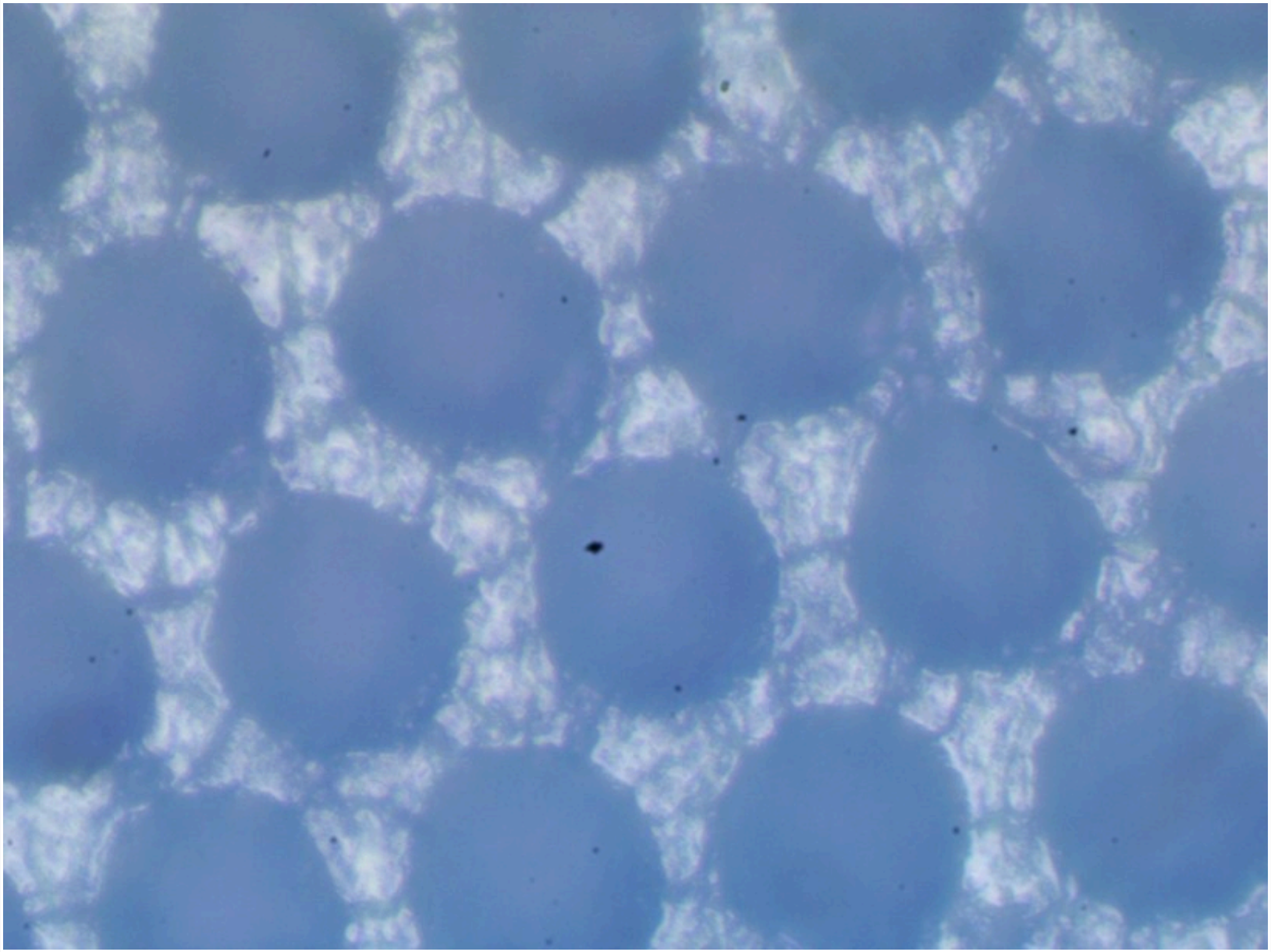
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	5.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 37.89%

Bridge / Cell: 1 / 4
Depth before / after: 23.5 / 23.5 µm
Depth decreased by: 0%

Comment
streak 970 dent 1050 1080.
Roll is worn.



Page №79. Roll "z17011037". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011037".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.7	cm^3/m^2

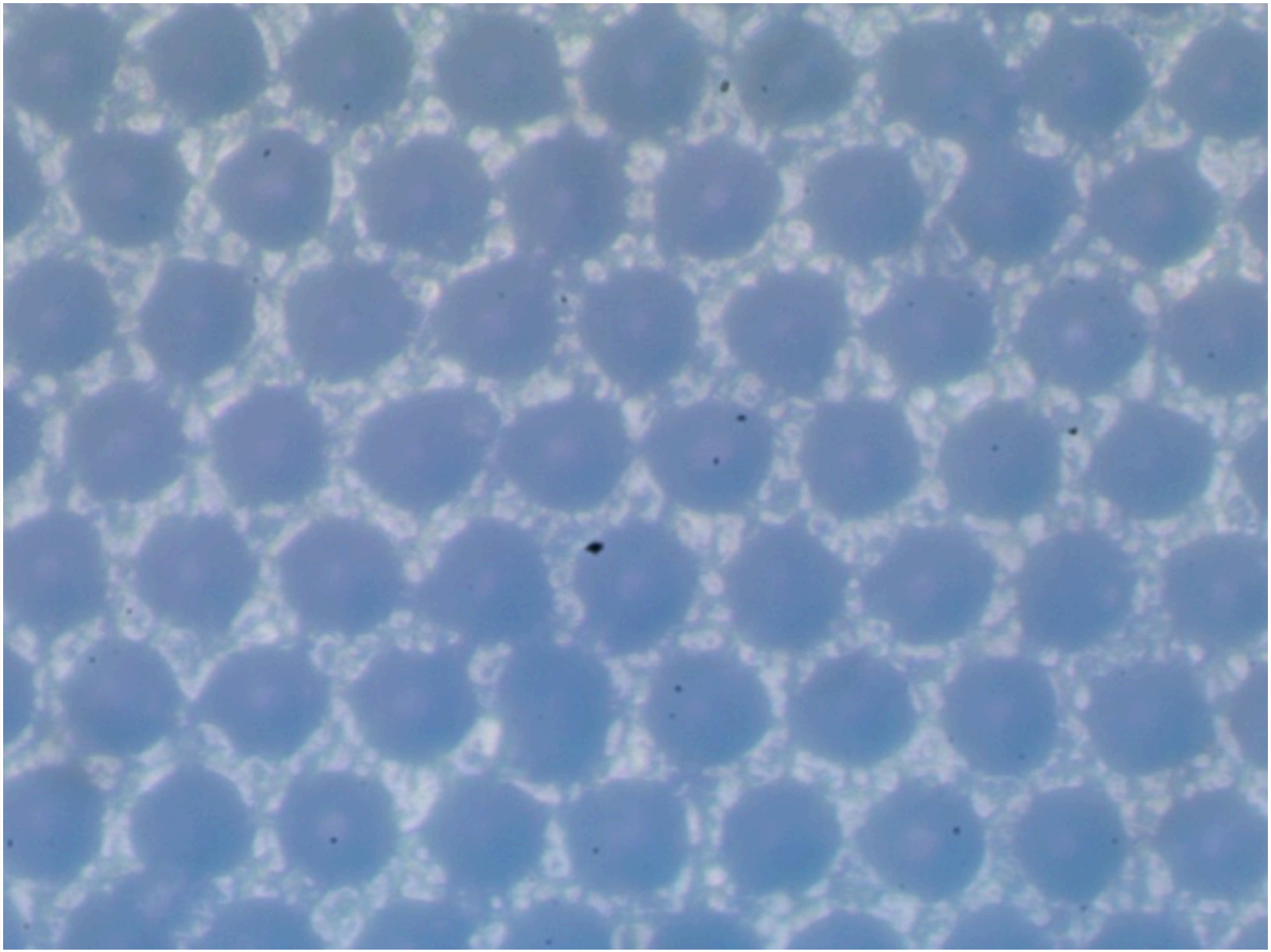
LEC measurements by Troika:

Measured line screen	400	lpcm
Vol	2.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 37.84%

Bridge / Cell: 1 / 4
Depth before / after: 9 / 9 µm
Depth decreased by: 0%

Comment
streaks streak 734 dent 1125 1175 1220.
Roll is worn.



Page №80. Roll "z48070". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z48070".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	4.1	cm^3/m^2

LEC measurements by Troika:

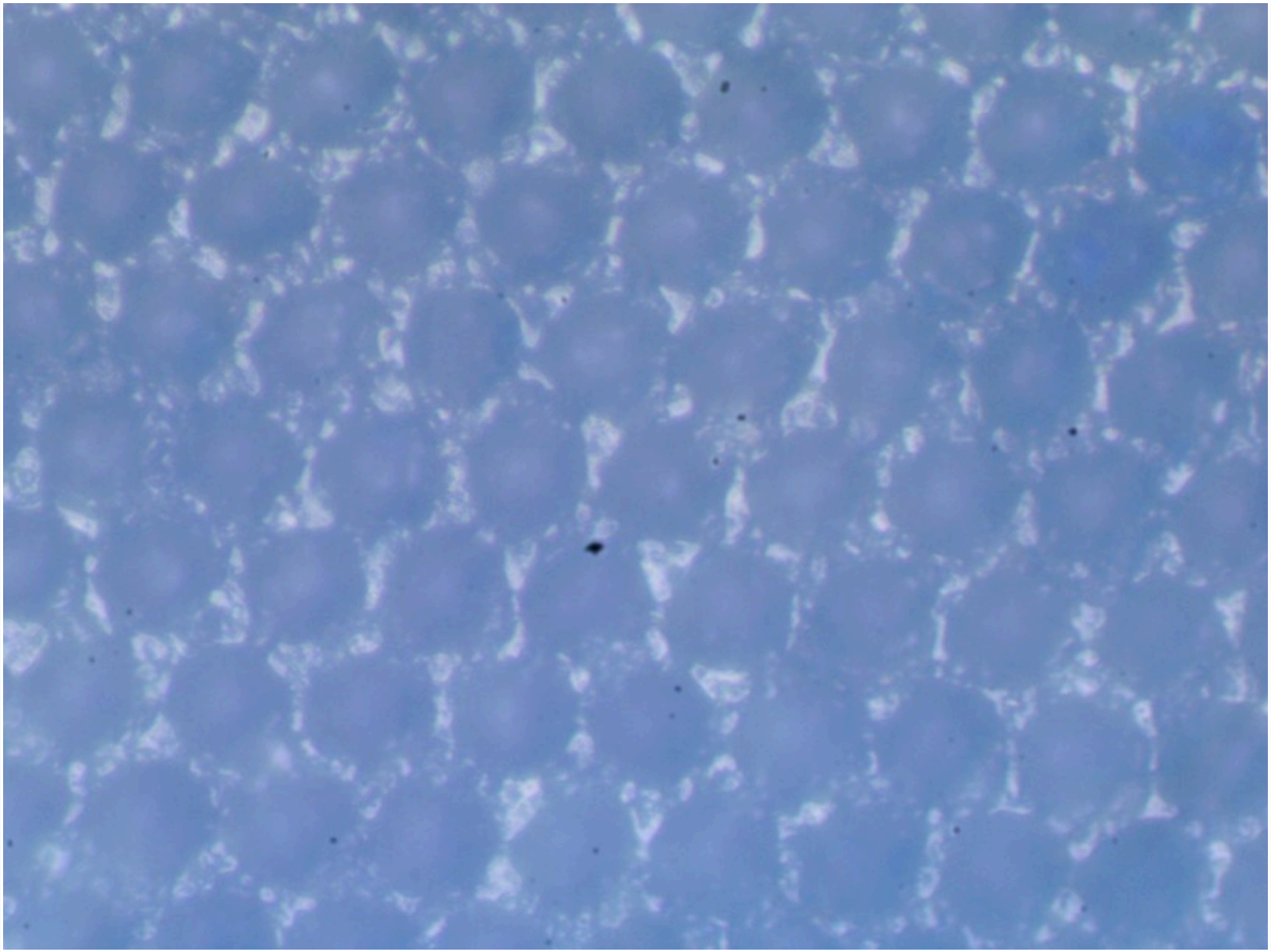
Measured line screen	400	lpcm
Vol	3.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 19.51%

Bridge / Cell: 1 / 4
Depth before / after: 13 / 13 µm
Depth decreased by: 0%

Comment
streaks streak 55 128 1032 dent 222 231 257 1160 1000.

Roll is worn.



Page №81. Roll "046633". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "046633".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	4.0	cm^3/m^2

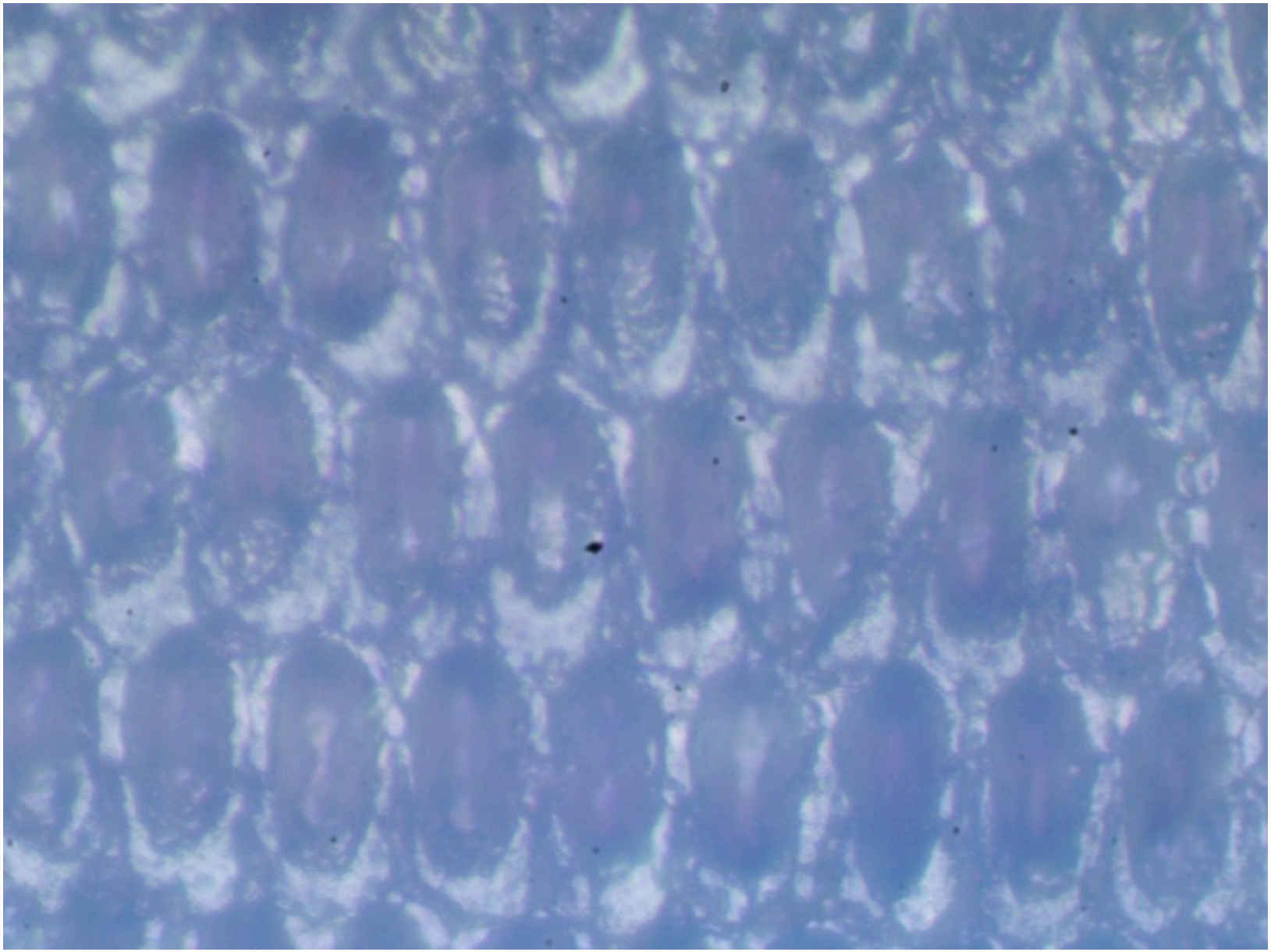
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	2.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 32.5%

Bridge / Cell: 1 / 3
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment
streak 34 747.
Roll is heavily worn.



Page №82. Roll "046634". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "046634".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	4.0	cm^3/m^2

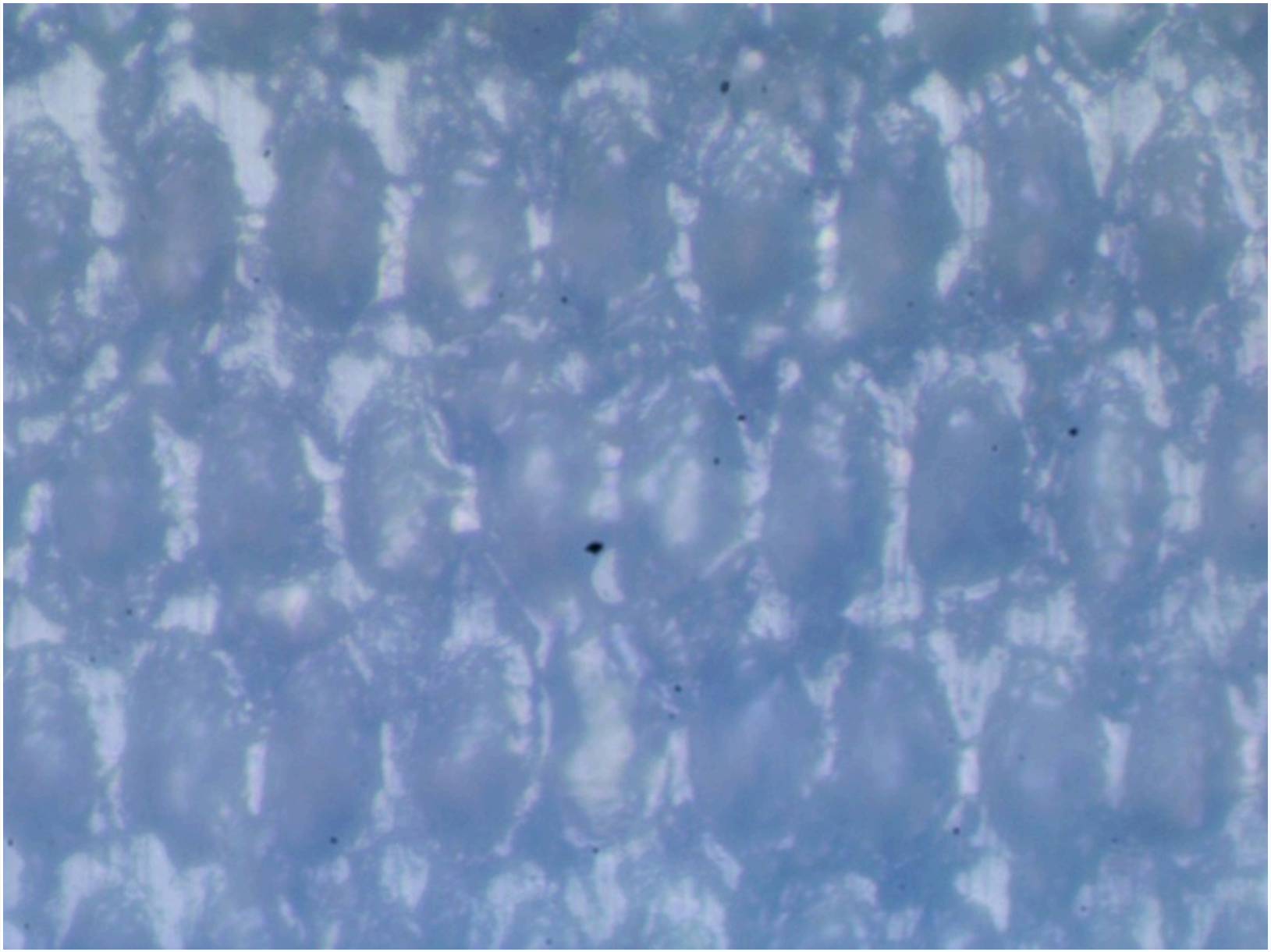
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	2.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 32.5%

Bridge / Cell: 1 / 4
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
streak 650 798 1172.
Roll is worn.



Page №83. Roll "sg49046-30". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-30".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

LEC measurements by Troika:

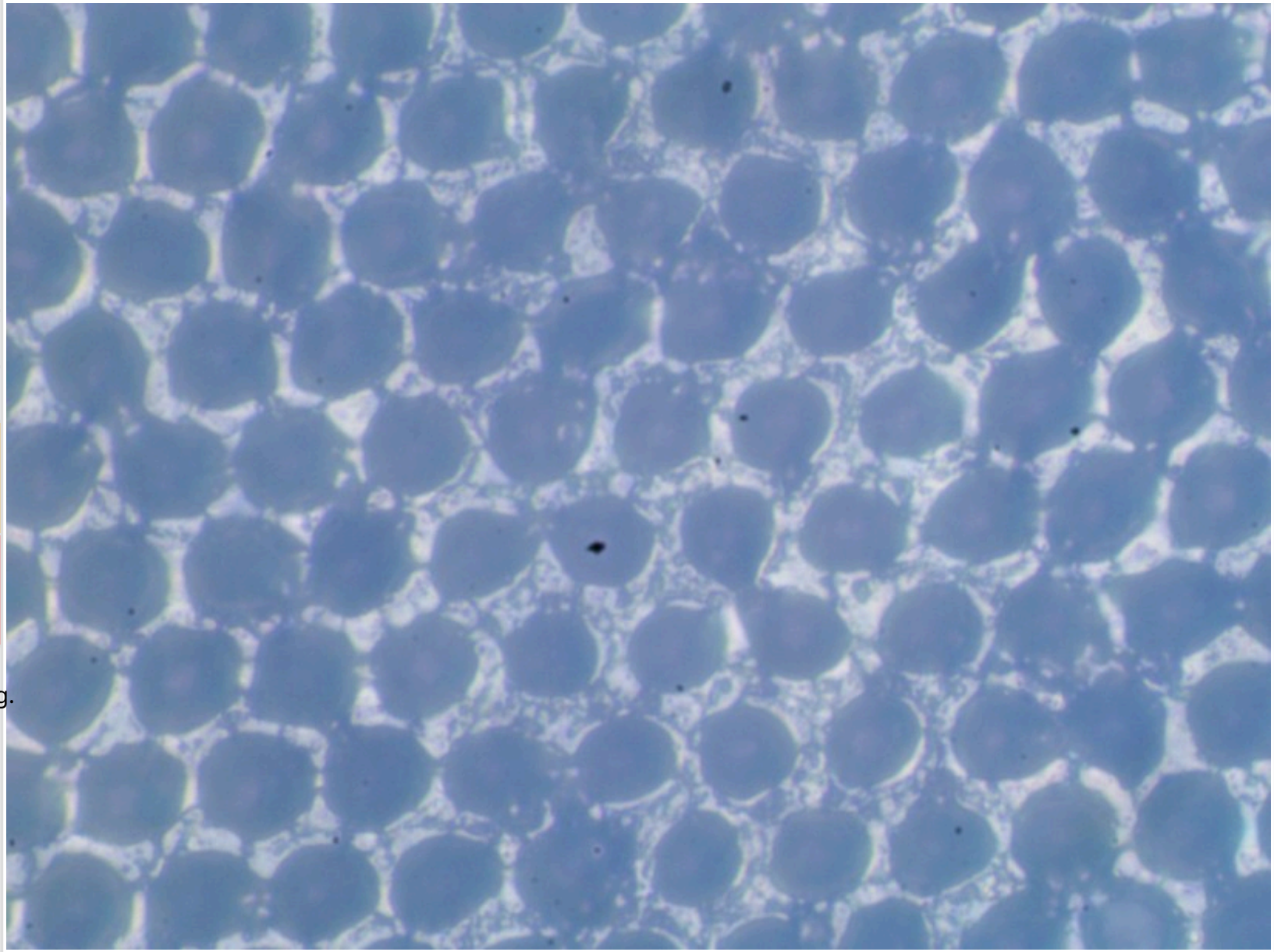
Measured line screen	460	lpcm
Vol	2.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 31.58%

Bridge / Cell: 1 / 3
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
streaks in places cell walls are missing.

Roll is heavily worn.



Page №84. Roll "h100750-1". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100750-1".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	130	lpcm
Vol	13.5	cm^3/m^2

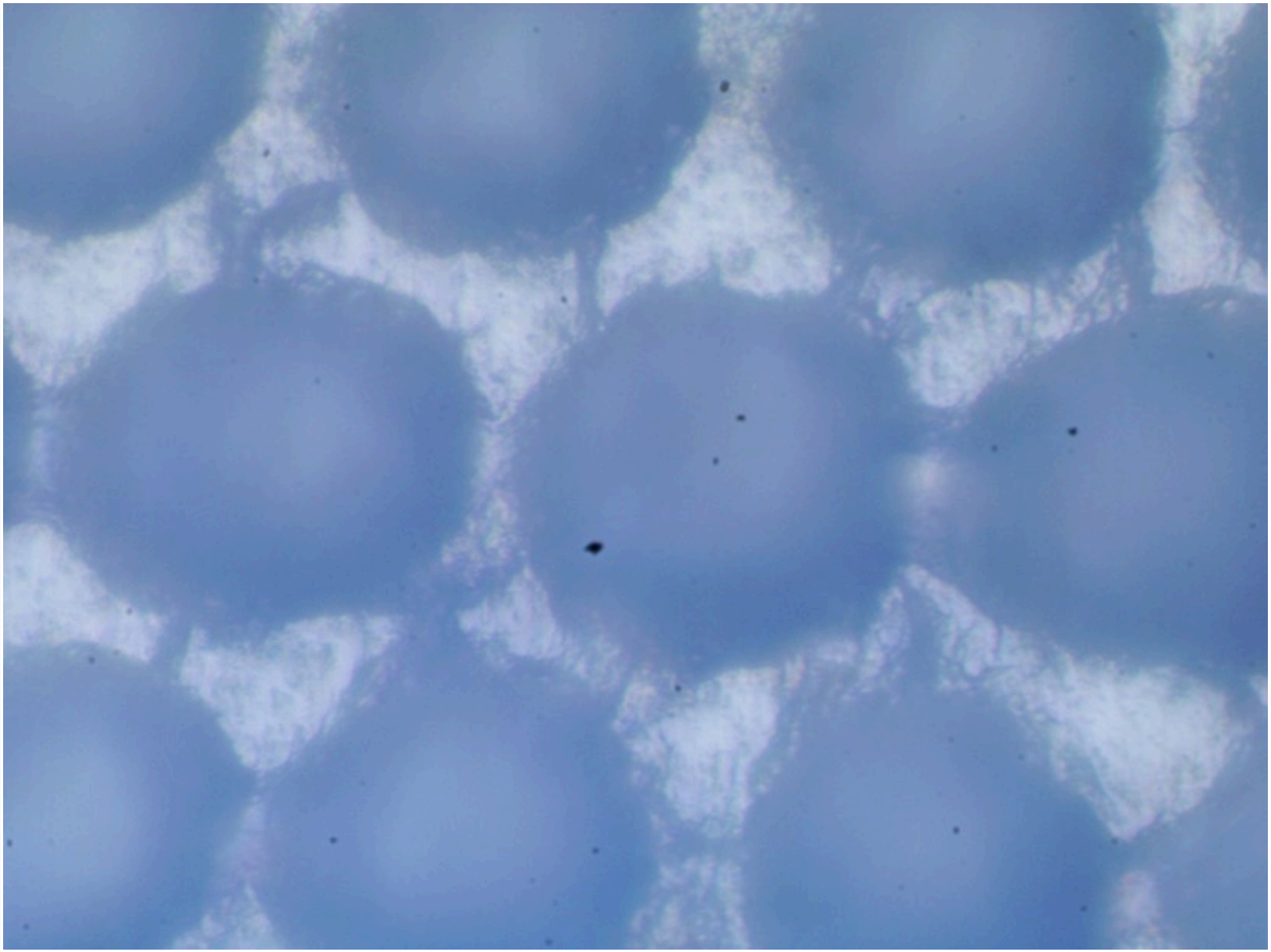
LEC measurements by Troika:

Measured line screen	130	lpcm
Vol	9.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 29.63%

Bridge / Cell: 1 / 5
Depth before / after: 35 / 35 µm
Depth decreased by: 0%

Comment
dent 255 268 273 273 303.
Roll is worn.



Page №85. Roll "z17011030". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011030".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	8.5	cm^3/m^2

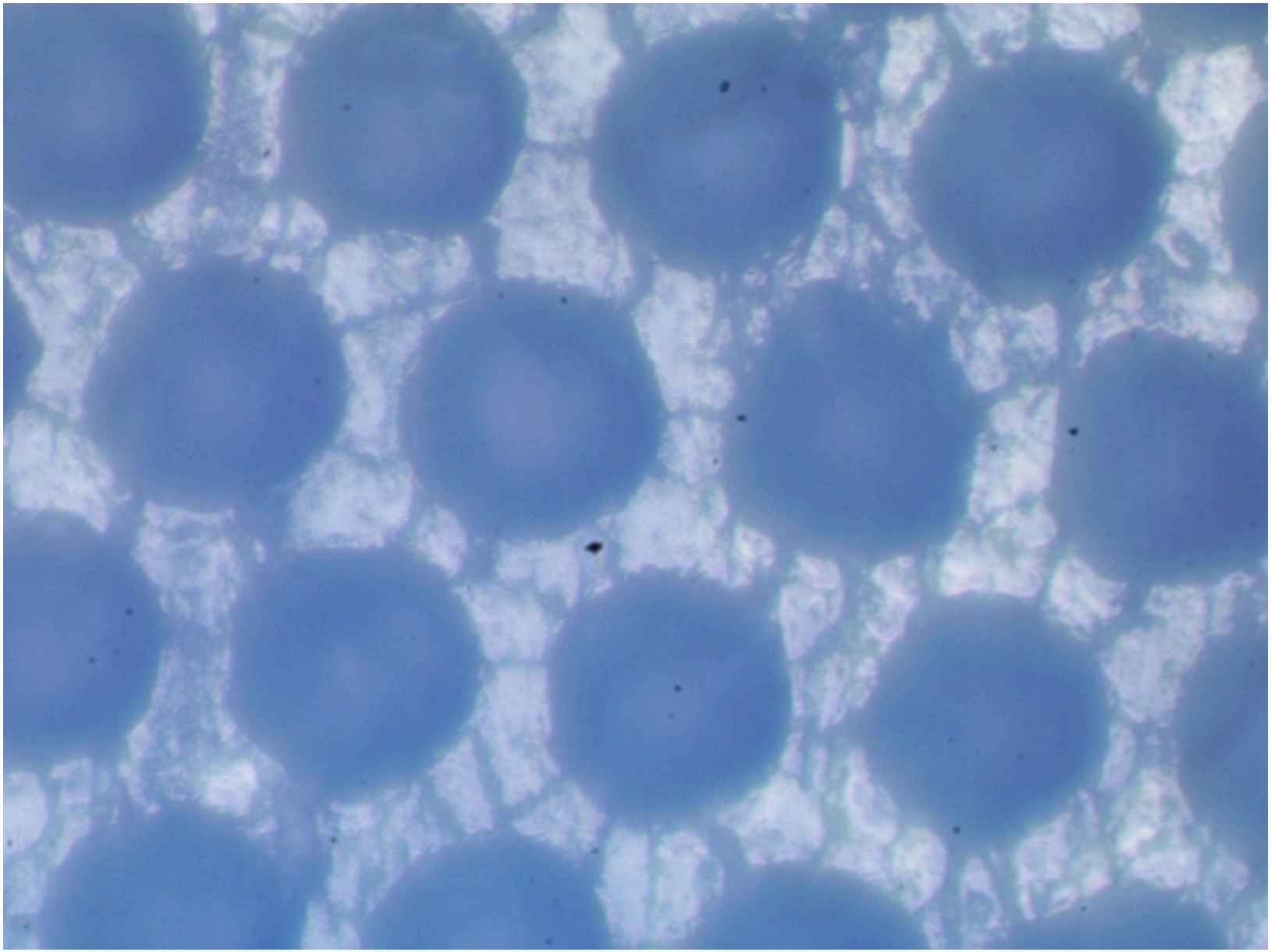
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	5.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 35.29%

Bridge / Cell: 1 / 4
Depth before / after: 22 / 22 µm
Depth decreased by: 0%

Comment
streak 285 835 dent 460.
Roll is worn.



Page №86. Roll "z17011014". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011014".	Photo of the anilox roll surface

Roll designations:

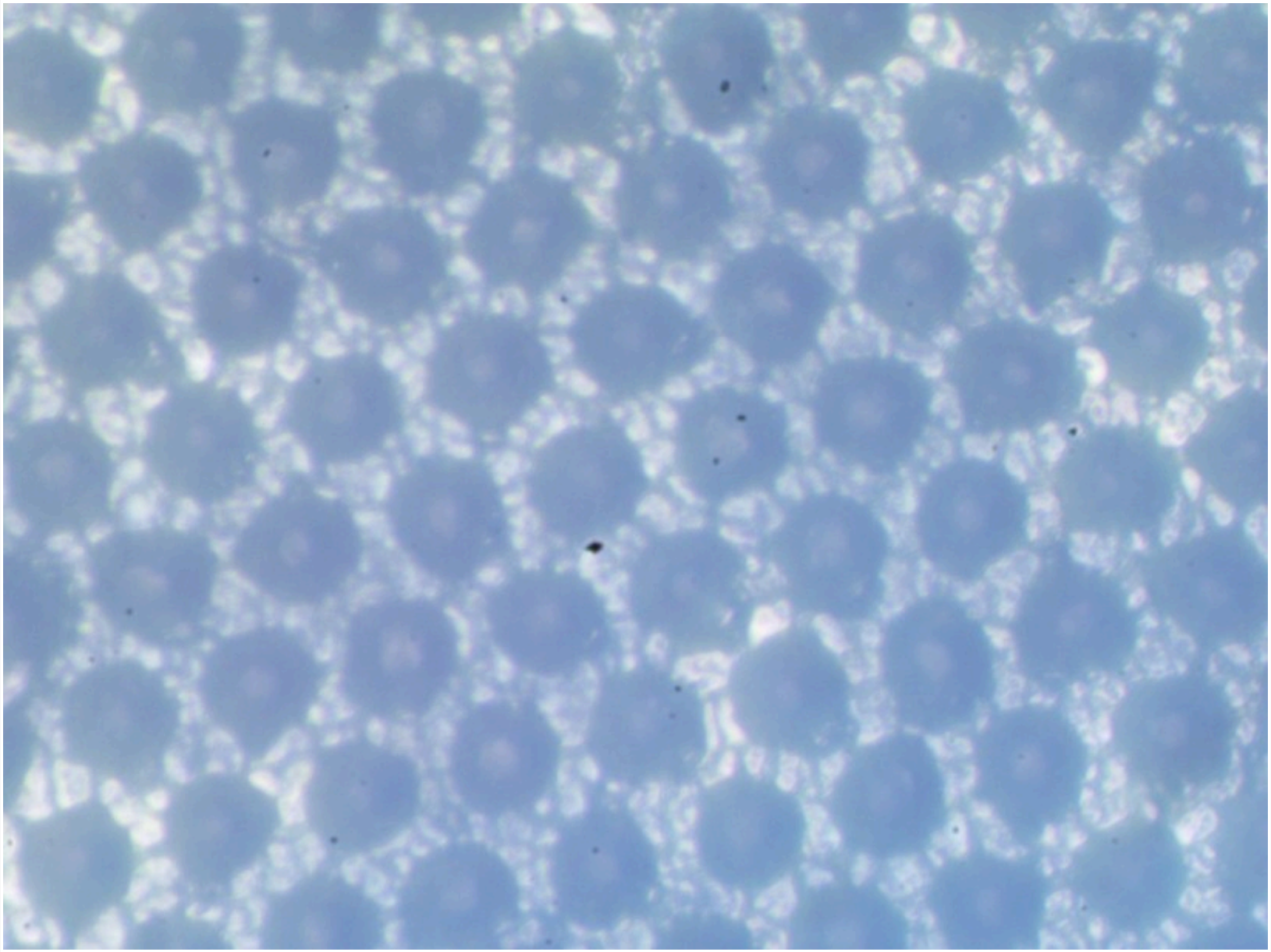
Nominal line screen	400	lpcm
Vol	3.6	cm^3/m^2

LEC measurements by Troika:

Measured line screen	380	lpcm
Vol	1.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 47.22%

Bridge / Cell: 1 / 3
Depth before / after: 8 / 8 µm
Depth decreased by: 0%



Comment
cell walls are missing streak dent 330 340 362 342 300 36 52 163 233 1228 842 970

1165 1280.
Roll is heavily worn.

Page №87. Roll "z17011021". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011021".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	7.1	cm^3/m^2

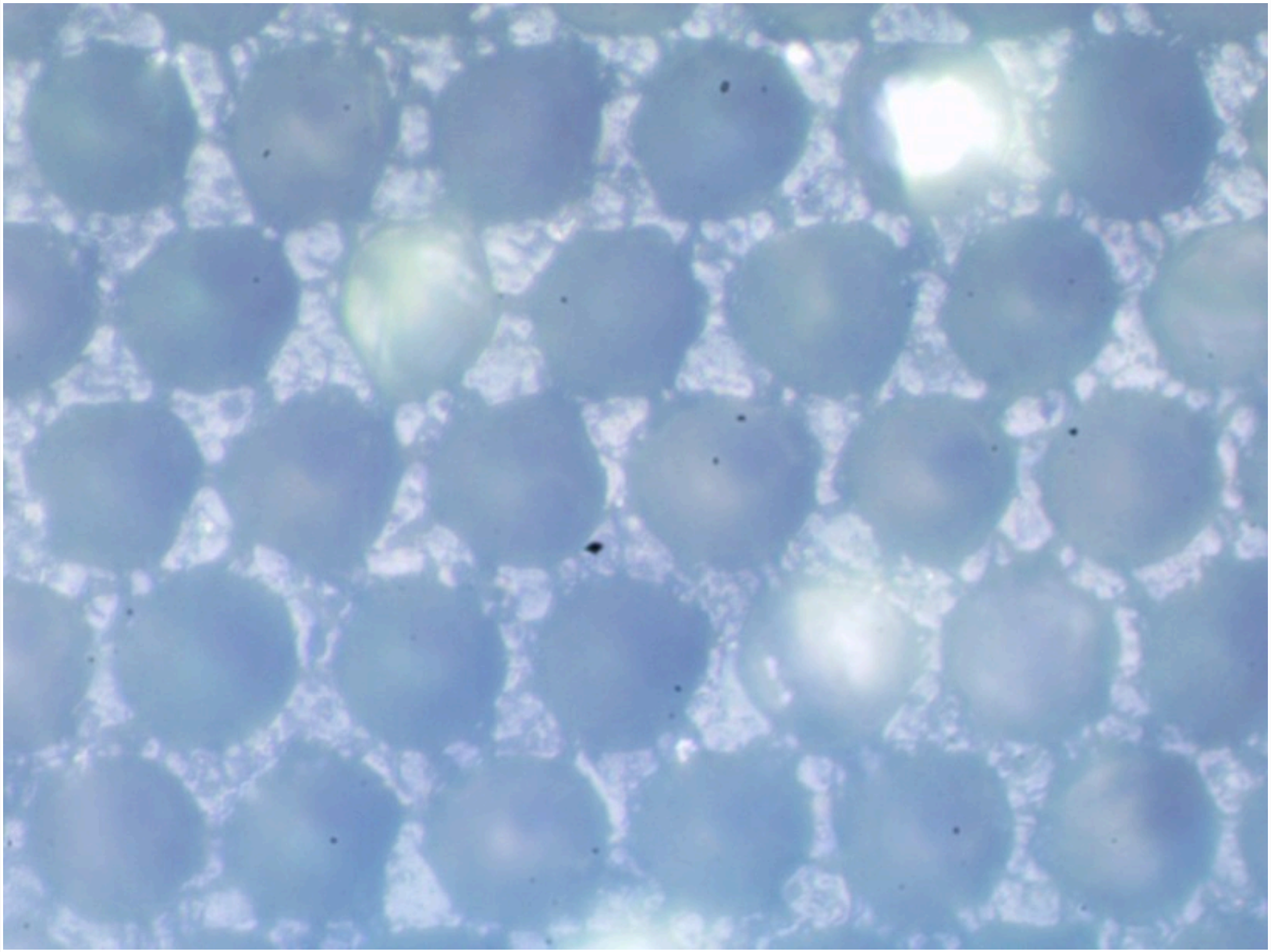
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	6.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 12.68%

Bridge / Cell: 1 / 8
Depth before / after: 20 / 20 µm
Depth decreased by: 0%

Comment
streak 1035 dent 85 1050.
Roll is slightly worn.



Page №88. Roll "046635". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "046635".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	4.0	cm^3/m^2

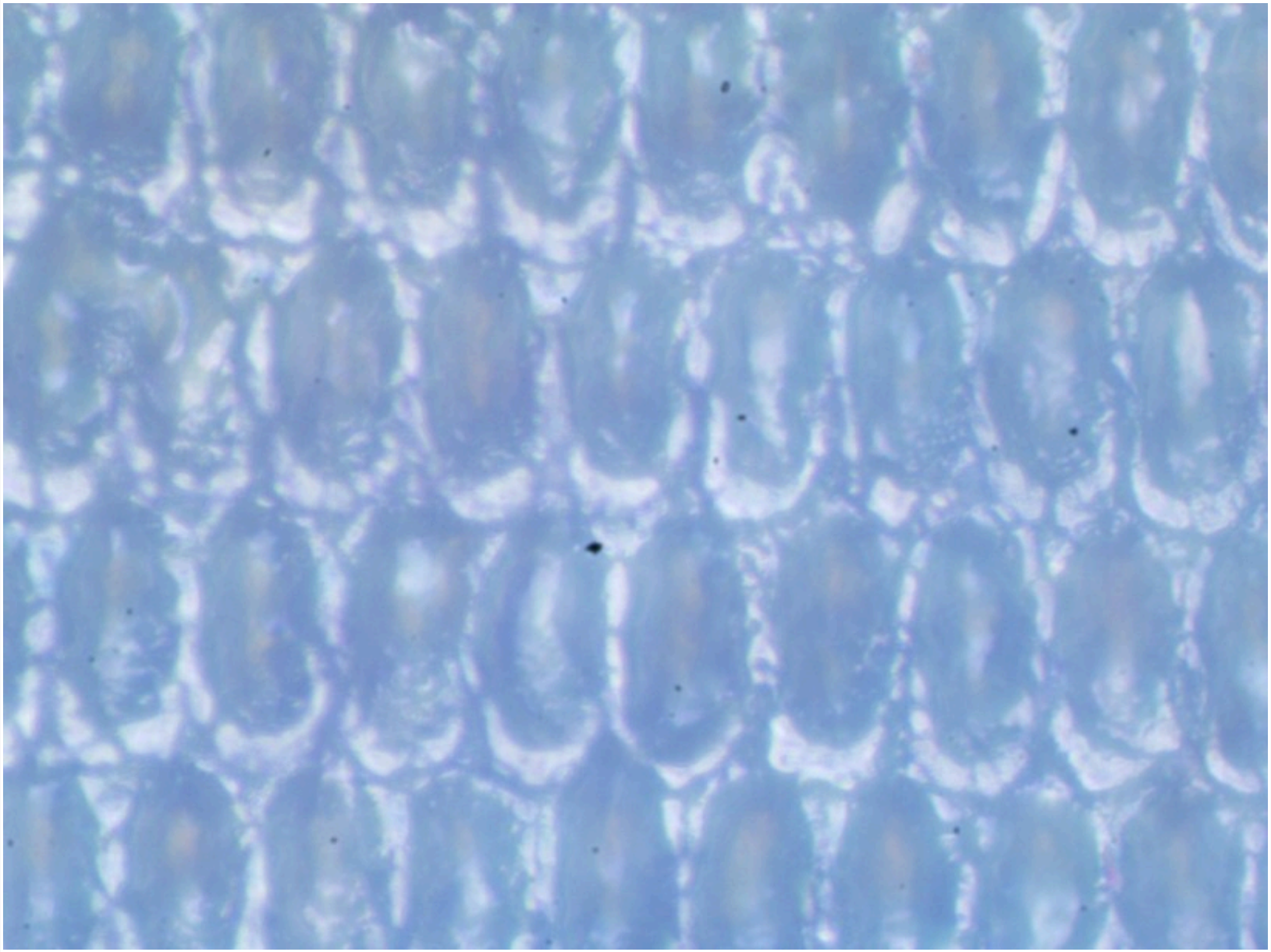
LEC measurements by Troika:

Measured line screen	400	lpcm
Vol	3.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 20%

Bridge / Cell: 1 / 7
Depth before / after: 10.5 / 10.5 µm
Depth decreased by: 0%

Comment
scratch 1253.
Roll is slightly worn.



Page №89. Roll "z16007654". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z16007654".	Photo of the anilox roll surface

Roll designations:

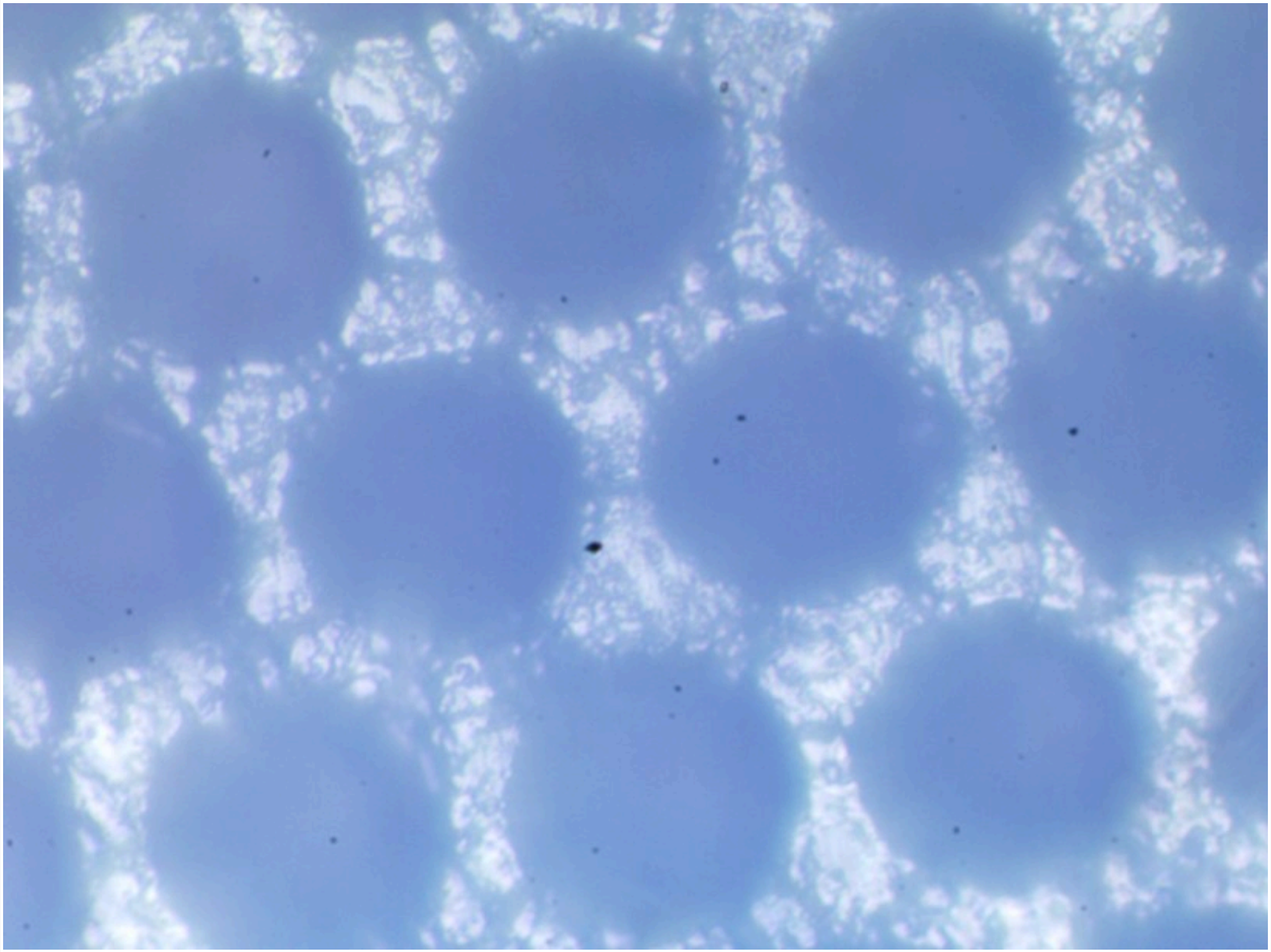
Nominal line screen	160	lpcm
Vol	9.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	160	lpcm
Vol	7.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 20%

Bridge / Cell: 1 / 5
Depth before / after: 26 / 26 µm
Depth decreased by: 0%



Comment
streak 120 409 689.
Roll is worn.

Page №90. Roll "3016198-2". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "3016198-2".	Photo of the anilox roll surface

Roll designations:

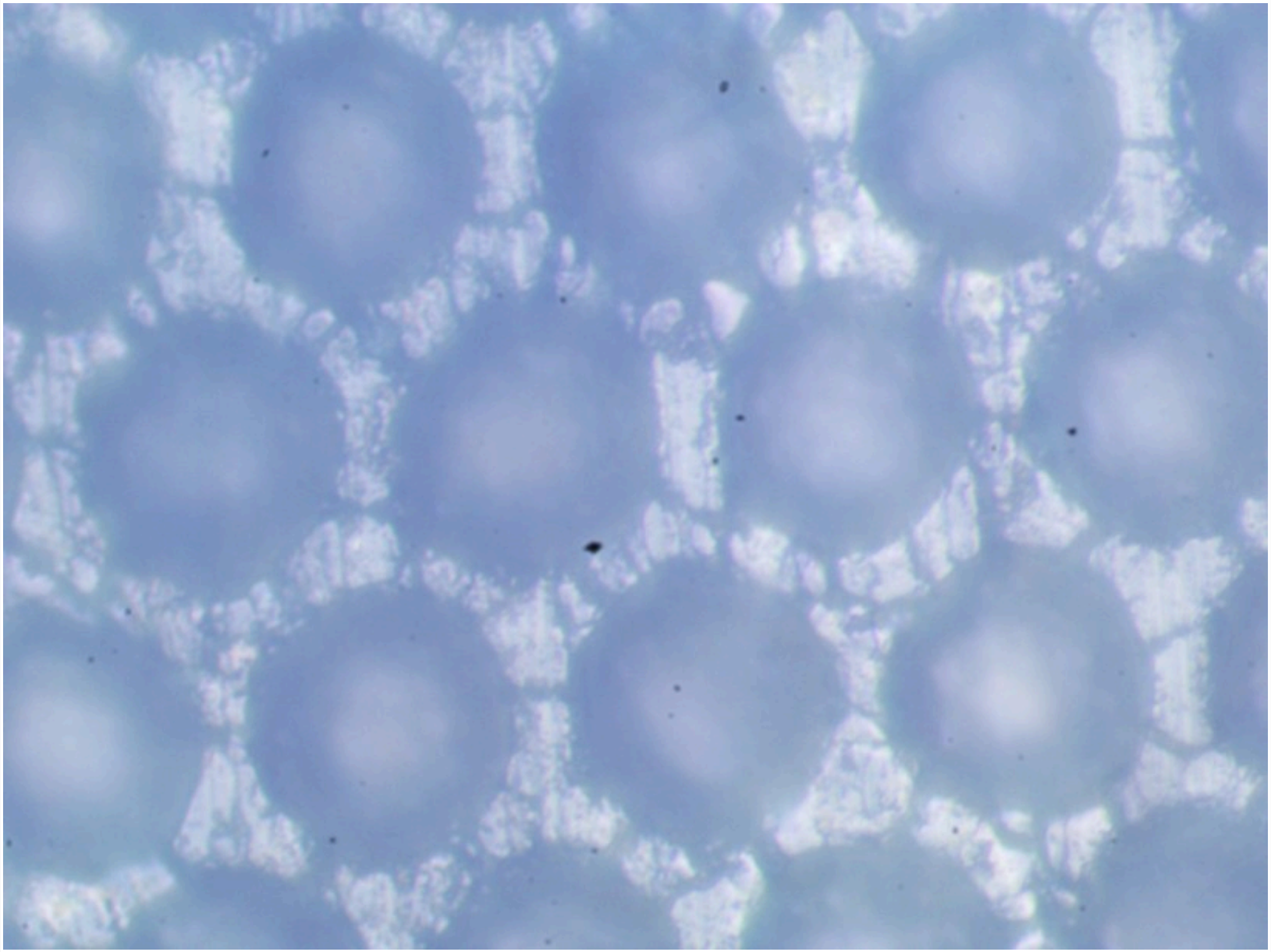
Nominal line screen	180	lpcm
Vol	9.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	6.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 23.33%

Bridge / Cell: 1 / 7
Depth before / after: 23 / 23 µm
Depth decreased by: 0%



Comment
streaks.
Roll is slightly worn.

Page №91. Roll "z16007659". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z16007659".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	4.0	cm^3/m^2

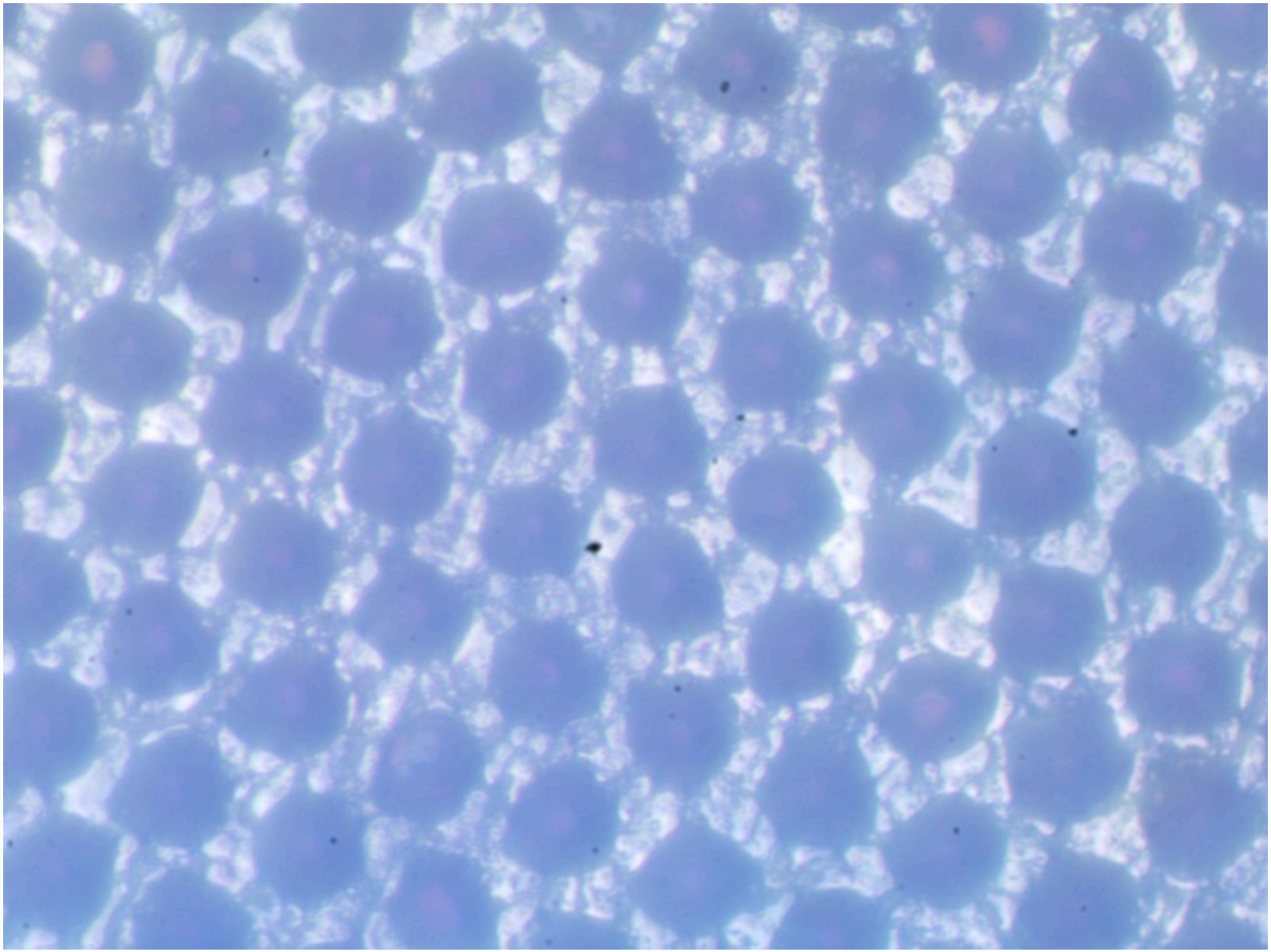
LEC measurements by Troika:

Measured line screen	400	lpcm
Vol	2.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 27.5%

Bridge / Cell: 1 / 4
Depth before / after: 11.5 / 11.5 µm
Depth decreased by: 0%

Comment
streak 860 streaks.
Roll is worn.



Page №92. Roll "z16007663". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z16007663".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	13.0	cm^3/m^2

LEC measurements by Troika:

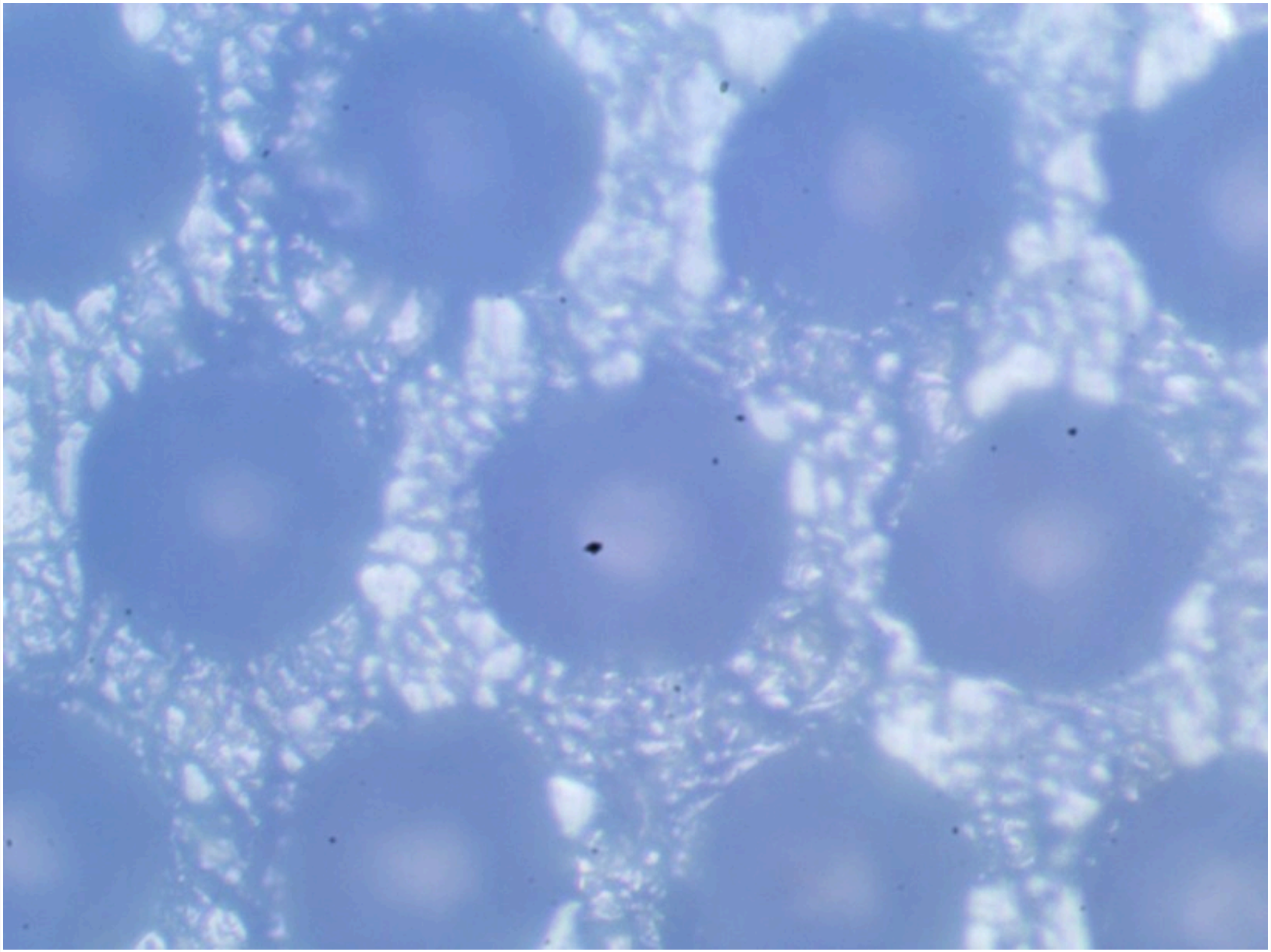
Measured line screen	140	lpcm
Vol	5.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 57.69%

Bridge / Cell: 1 / 3
Depth before / after: 25 / 25 µm
Depth decreased by: 0%

Comment
worn streak 739 748 streaks scratch 860.

Roll is heavily worn.



Page №93. Roll "z16007646". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z16007646".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	7.0	cm^3/m^2

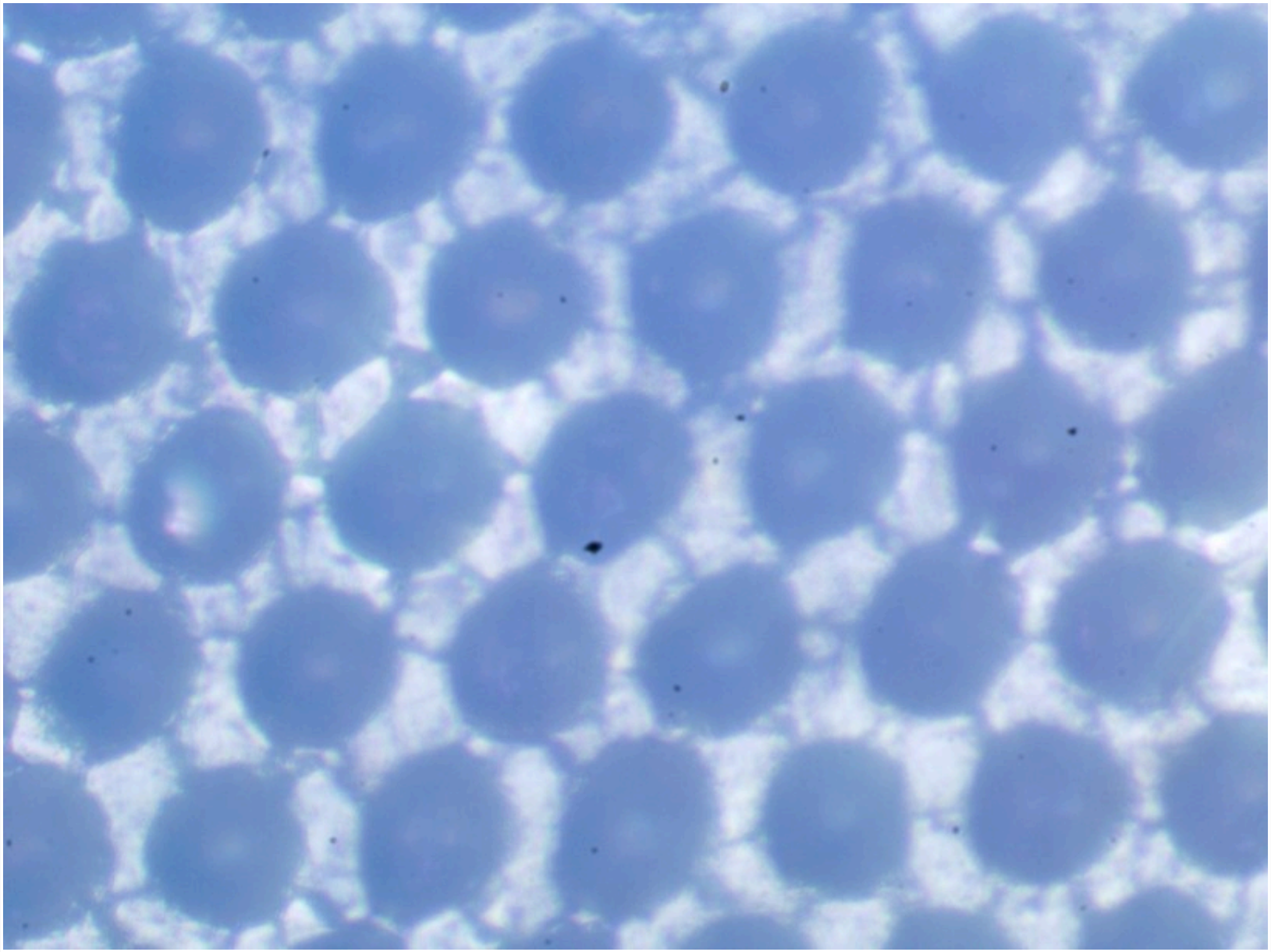
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	4.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 34.29%

Bridge / Cell: 1 / 4
Depth before / after: 18 / 18 µm
Depth decreased by: 0%

Comment
streak 112 254.
Roll is worn.



Page №94. Roll "sa008613". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008613".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

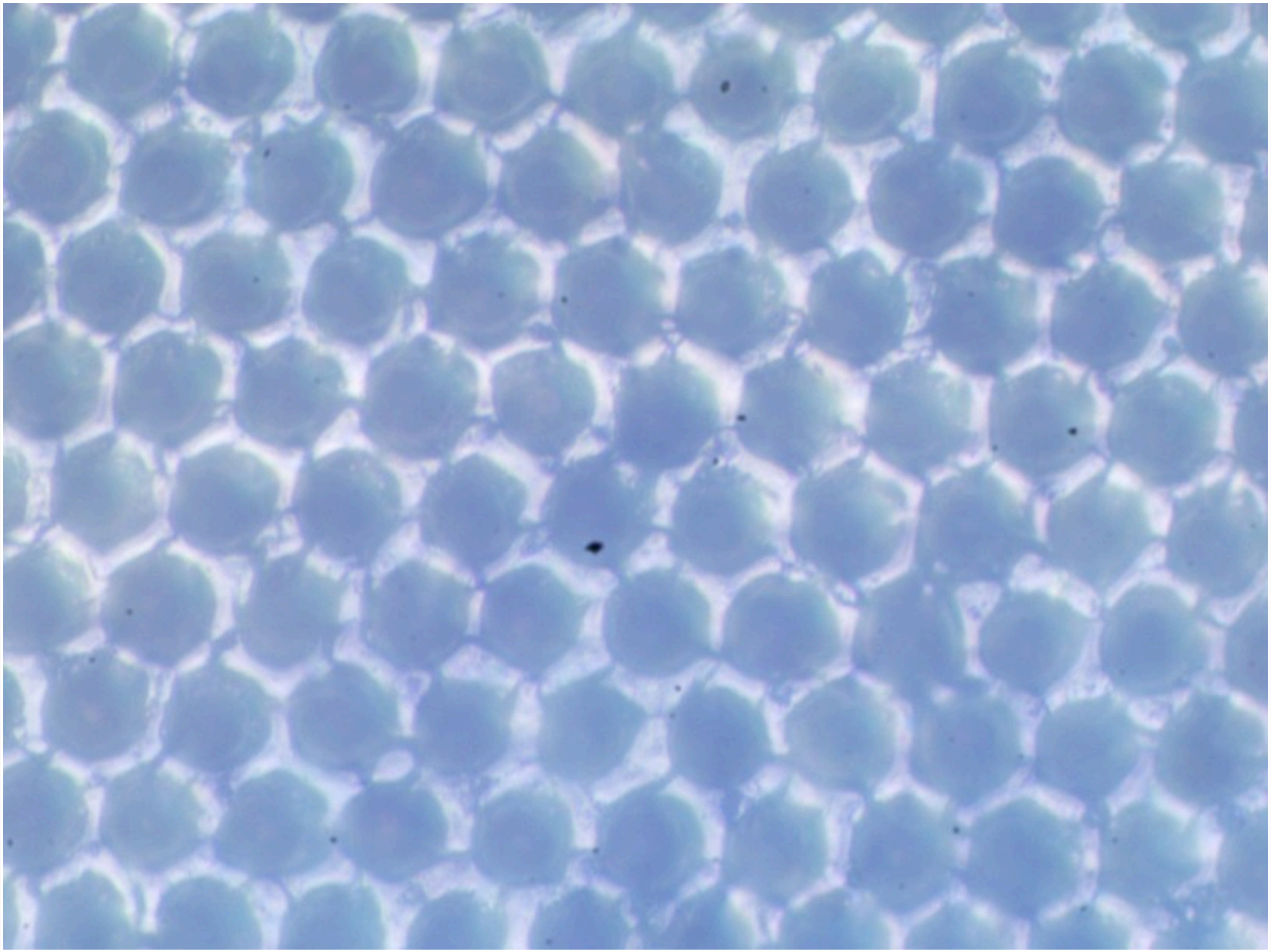
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.80	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 6
Depth before / after: 12.5 / 12.5 µm
Depth decreased by: 0%

Comment
spots streak 129 151 158.
Roll is worn.



Page №95. Roll "alt17447". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "alt17447".	Photo of the anilox roll surface

Roll designations:

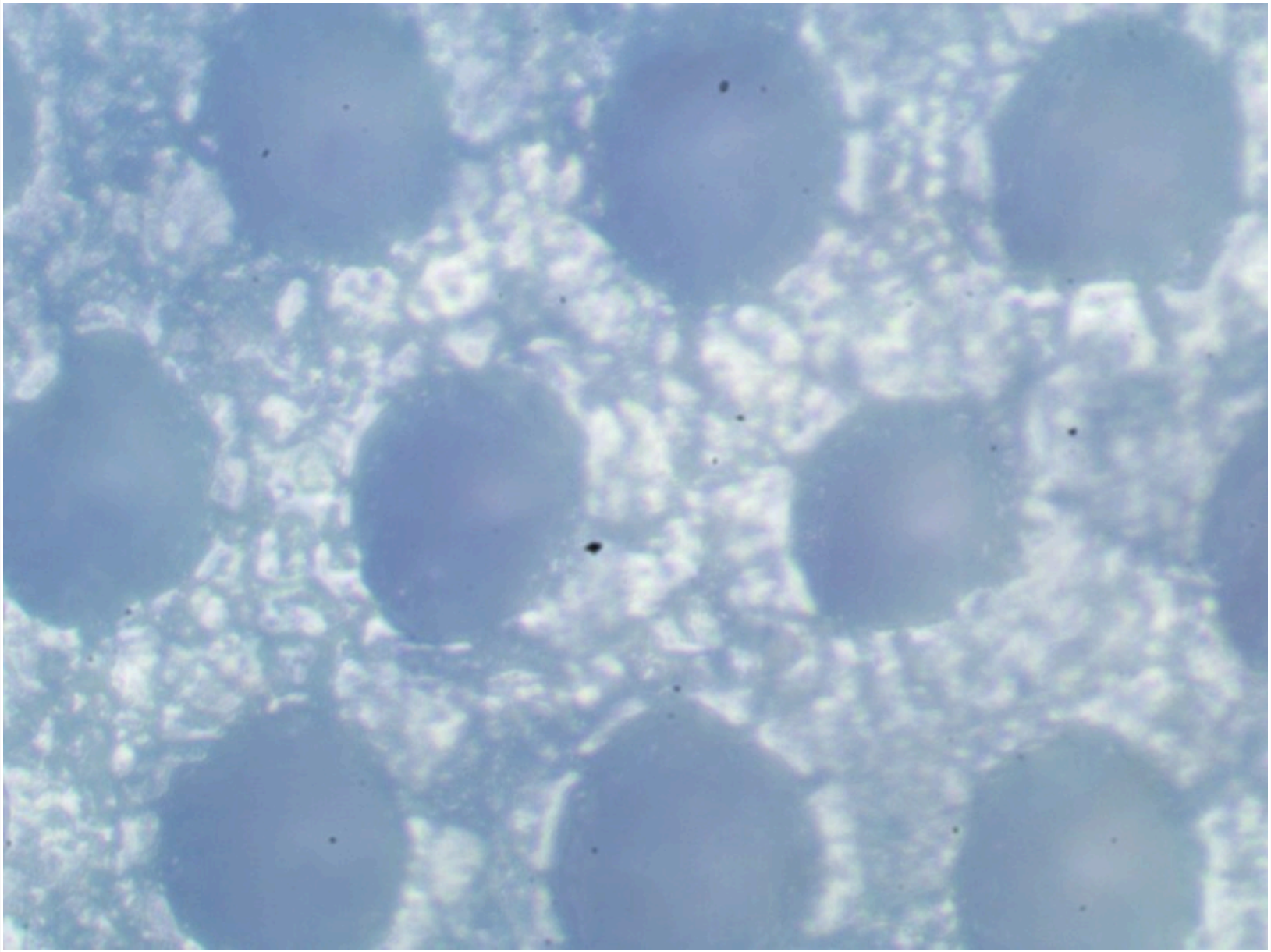
Nominal line screen	140	lpcm
Vol	13.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	4.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 66.15%

Bridge / Cell: 1 / 2
Depth before / after: 25 / 25 µm
Depth decreased by: 0%



Comment
worn spots.
Roll is heavily worn.

Page №96. Roll "aa2413650". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413650".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

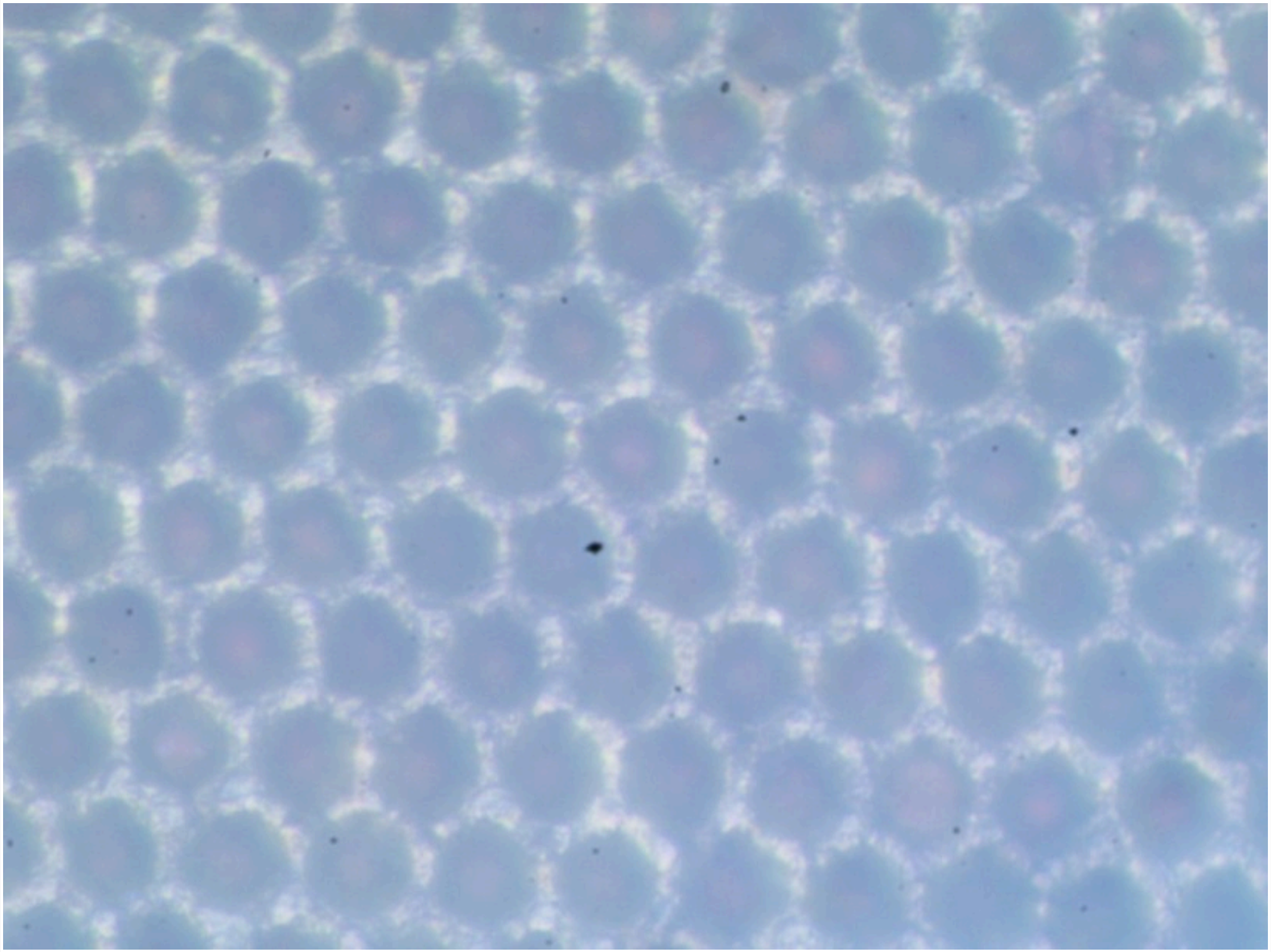
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 15.79%

Bridge / Cell: 1 / 6
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
streaks.
Roll is worn.



Page №97. Roll "aa2413653". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413653".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

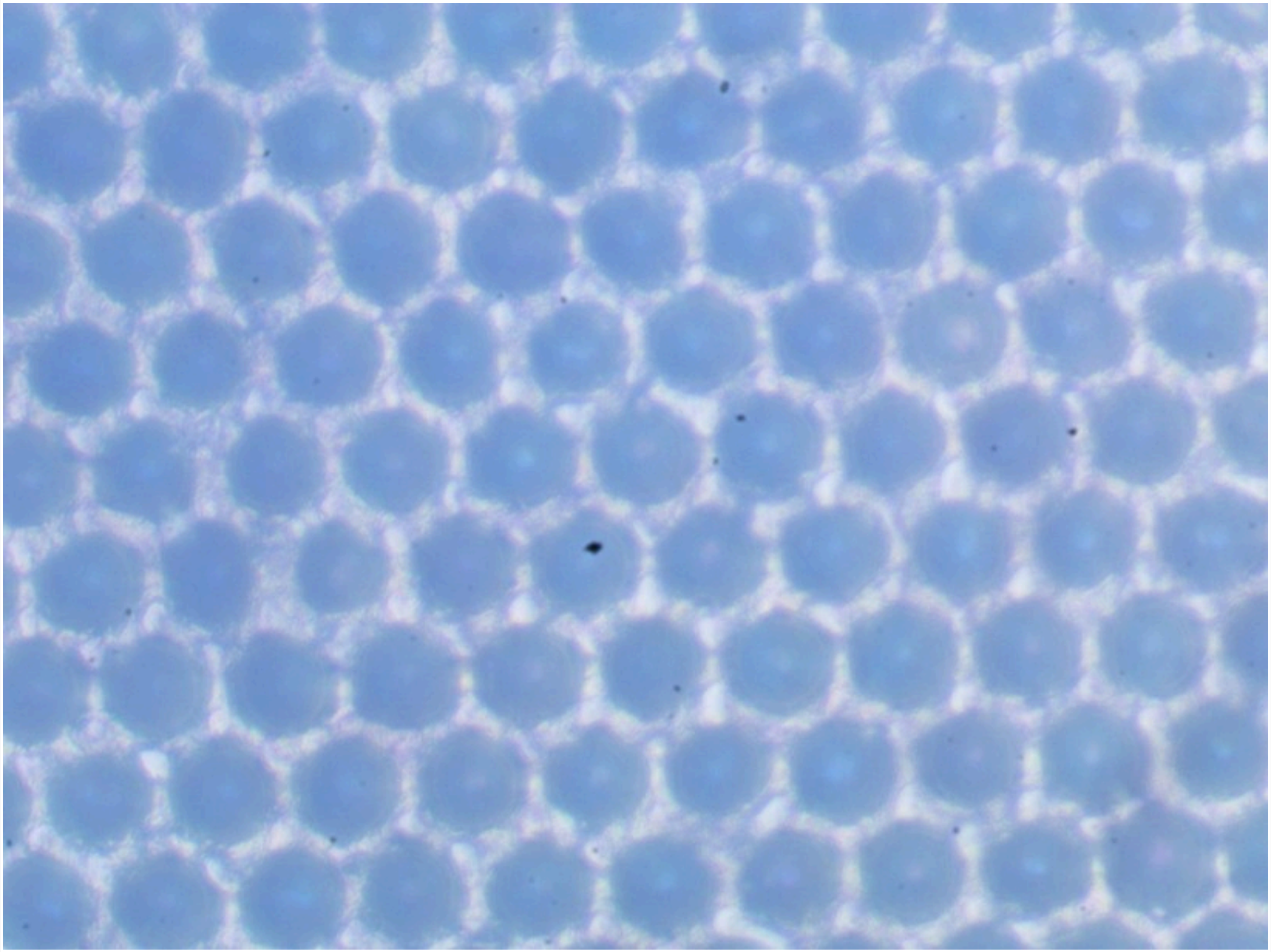
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10.53%

Bridge / Cell: 1 / 5
Depth before / after: 13 / 13 µm
Depth decreased by: 0%

Comment
streaks.
Roll is worn.



Page №98. Roll "z18008079". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18008079".	Photo of the anilox roll surface

Roll designations:

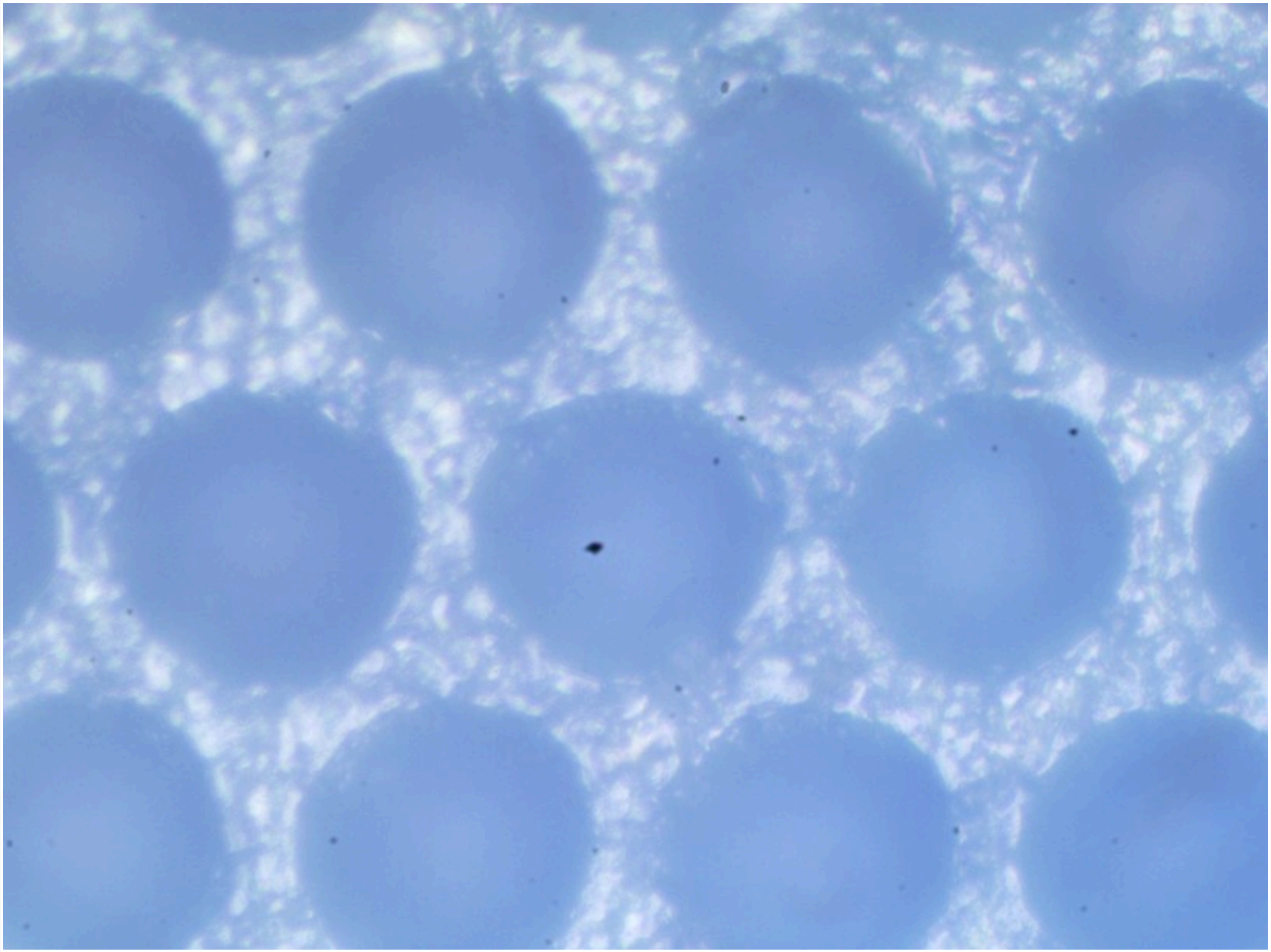
Nominal line screen	160	lpcm
Vol	7.7	cm^3/m^2

LEC measurements by Troika:

Measured line screen	160	lpcm
Vol	5.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 27.27%

Bridge / Cell: 1 / 5
Depth before / after: 20 / 20 µm
Depth decreased by: 0%



Comment
streak 134.
Roll is worn.

Page №99. Roll "aa2409897". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2409897".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	130	lpcm
Vol	12.0	cm^3/m^2

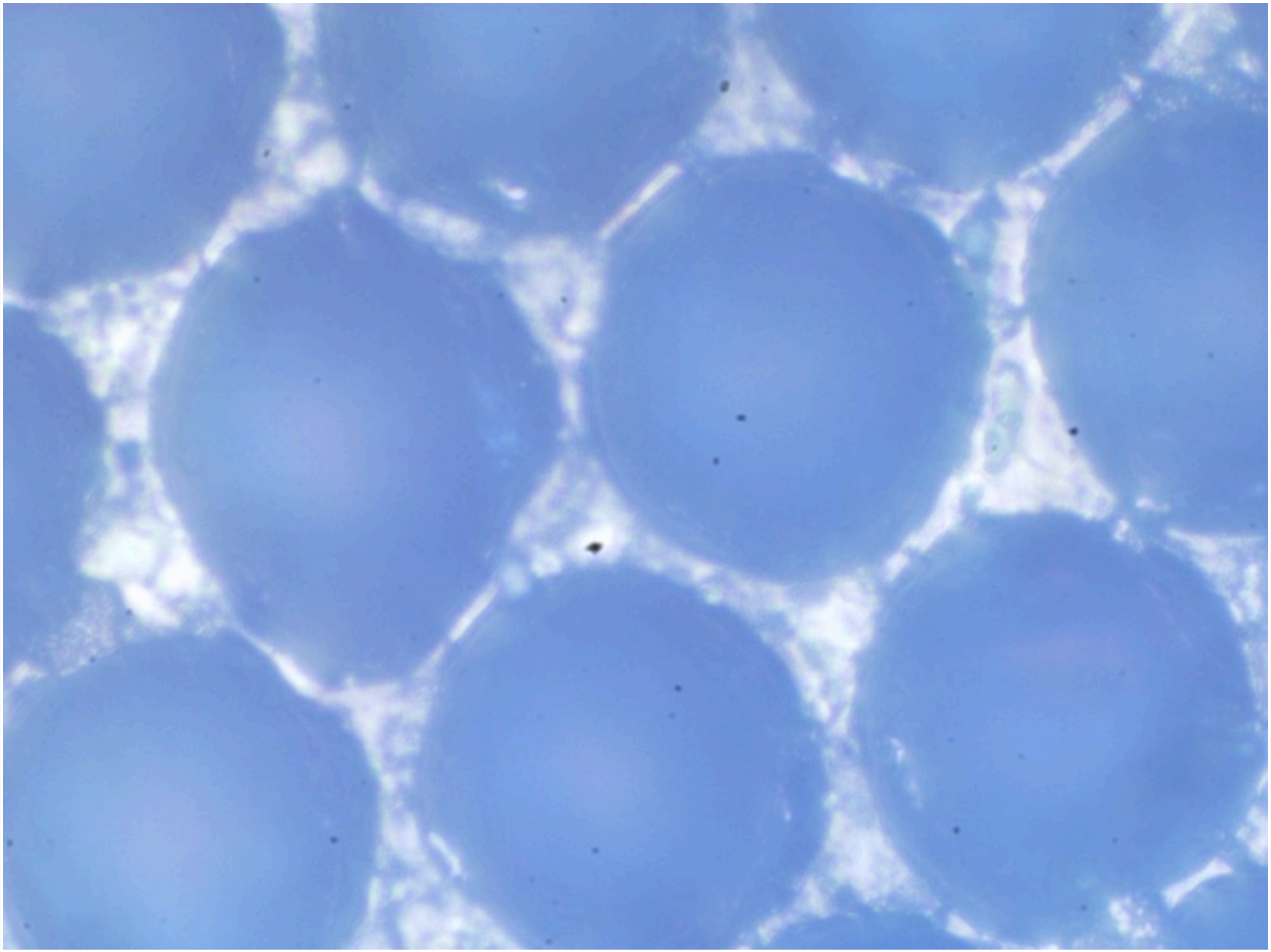
LEC measurements by Troika:

Measured line screen	130	lpcm
Vol	10.00	cm^3/m^2

Ink transfer volume decrease from the nominal value: 16.67%

Bridge / Cell: 1 / 14
Depth before / after: 29 / 29 µm
Depth decreased by: 0%

Comment
streak 900.



Page №100. Roll "ad007096". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "ad007096".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

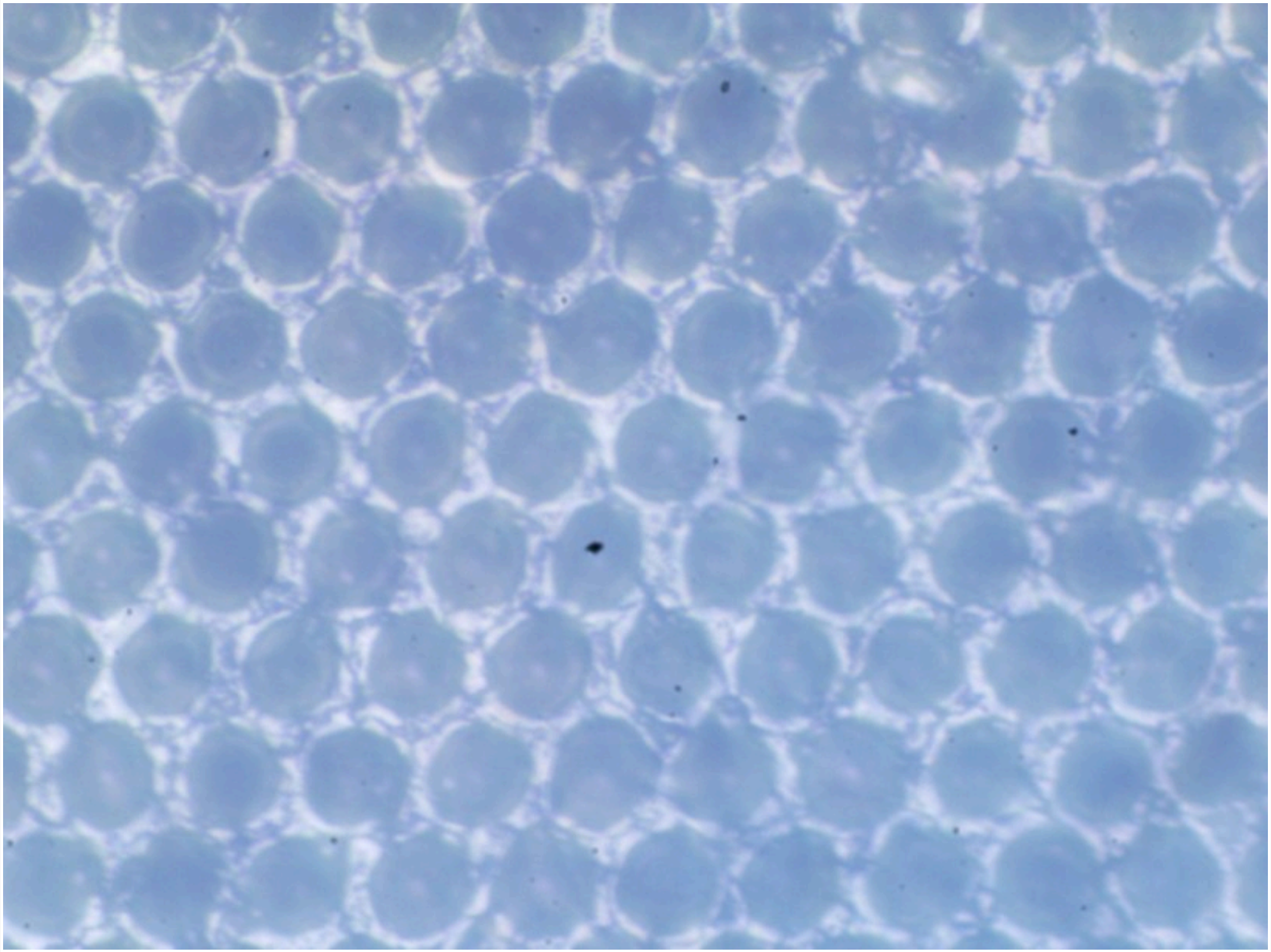
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.10	cm^3/m^2

Ink transfer volume decrease from the nominal value: 18.42%

Bridge / Cell: 1 / 6
Depth before / after: 10.5 / 10.5 µm
Depth decreased by: 0%

Comment
streak 759.
Roll is worn.



Page №101. Roll "z45229". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z45229".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	9.0	cm^3/m^2

LEC measurements by Troika:

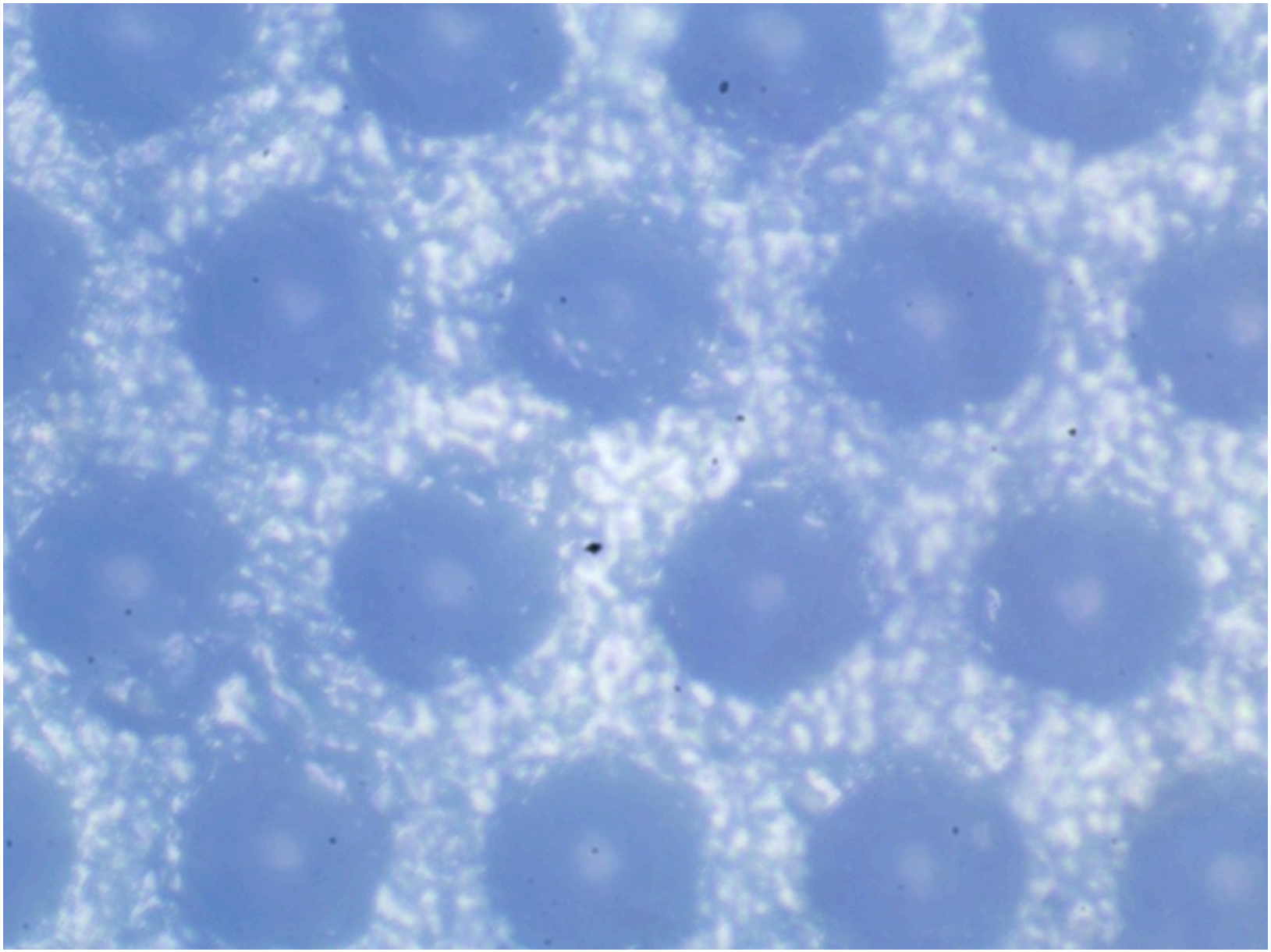
Measured line screen	180	lpcm
Vol	3.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 64.44%

Bridge / Cell: 1 / 3
Depth before / after: 16 / 16 µm
Depth decreased by: 0%

Comment
worn streak 78 875 100 65 50 1255
dent 213 234 1243 1265.

Roll is heavily worn.



Page №102. Roll "sa008592". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008592".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	170	lpcm
Vol	8.0	cm^3/m^2

LEC measurements by Troika:

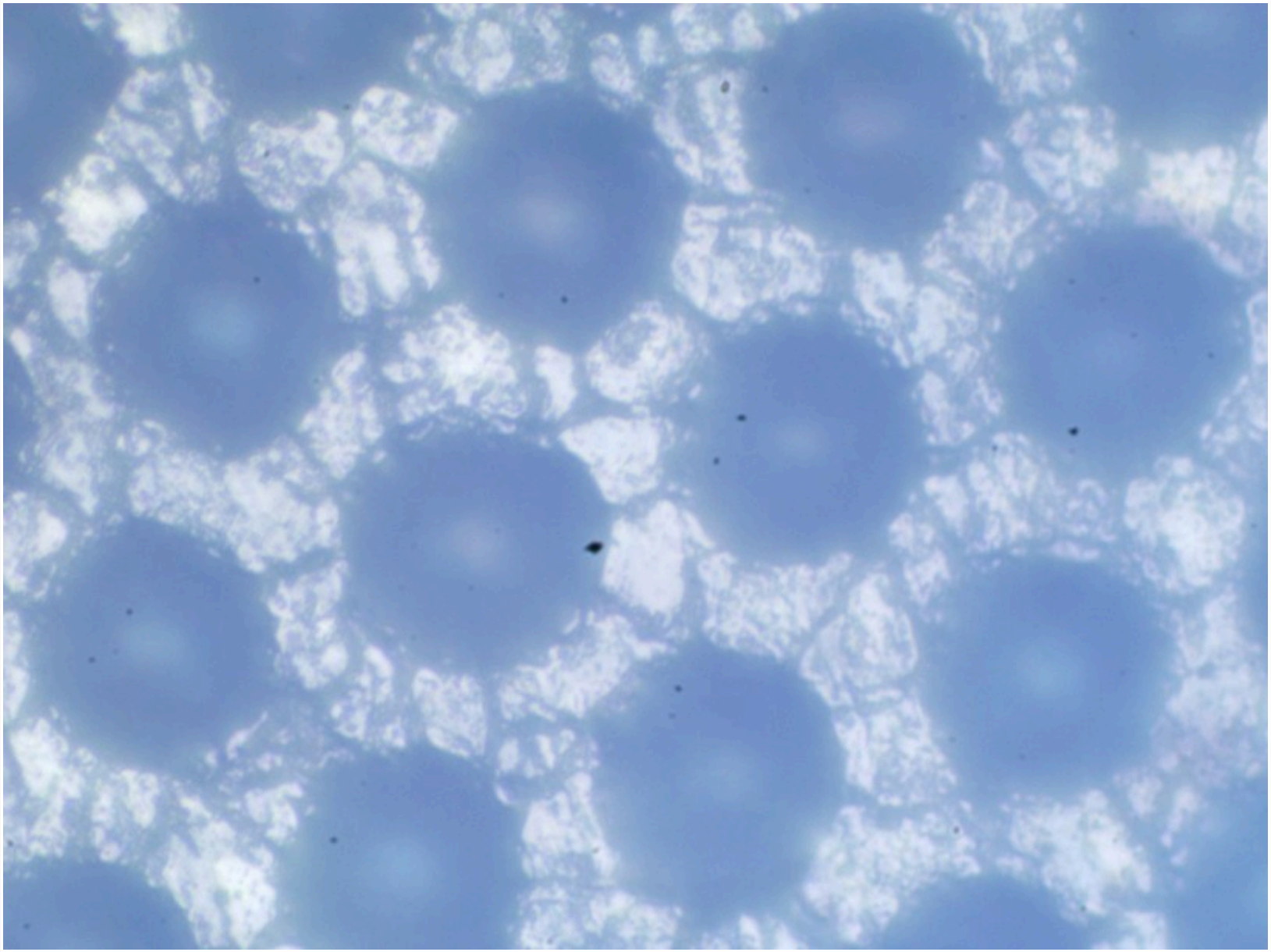
Measured line screen	170	lpcm
Vol	6.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 21.25%

Bridge / Cell: 1 / 4
Depth before / after: 24 / 24 µm
Depth decreased by: 0%

Comment
worn streak 110 scratch dent 1185.
390 400 414 510 523 535 555

Roll is worn.



Page №103. Roll "alt17454". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "alt17454".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	80	lpcm
Vol	18.0	cm^3/m^2

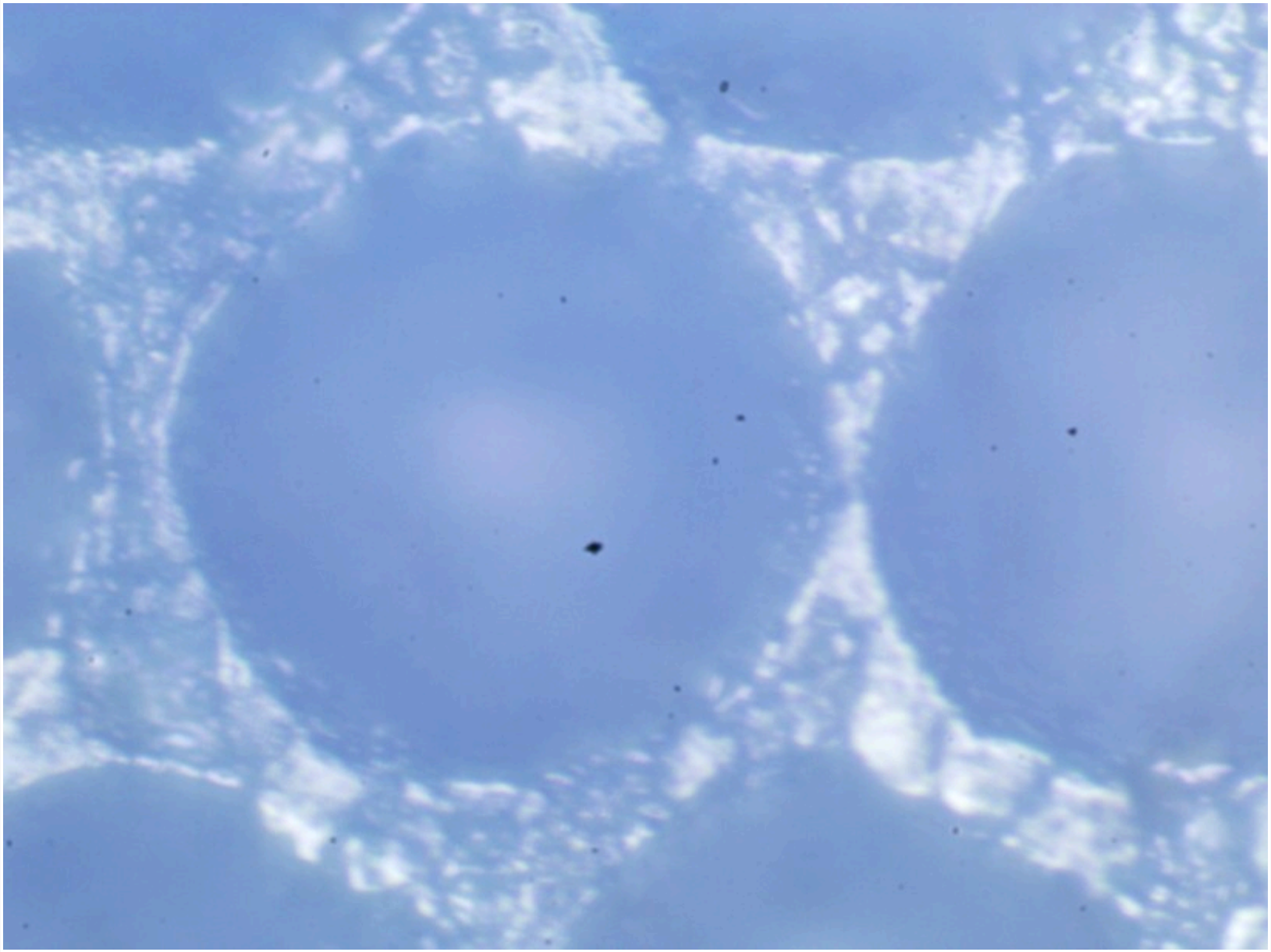
LEC measurements by Troika:

Measured line screen	80	lpcm
Vol	17.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 4.44%

Bridge / Cell: 1 / 11
Depth before / after: 52 / 52 µm
Depth decreased by: 0%

Comment
dent 450 467 493 530 580 streak 780.



Page №104. Roll "sg49046-9". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-9".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	10.0	cm^3/m^2

LEC measurements by Troika:

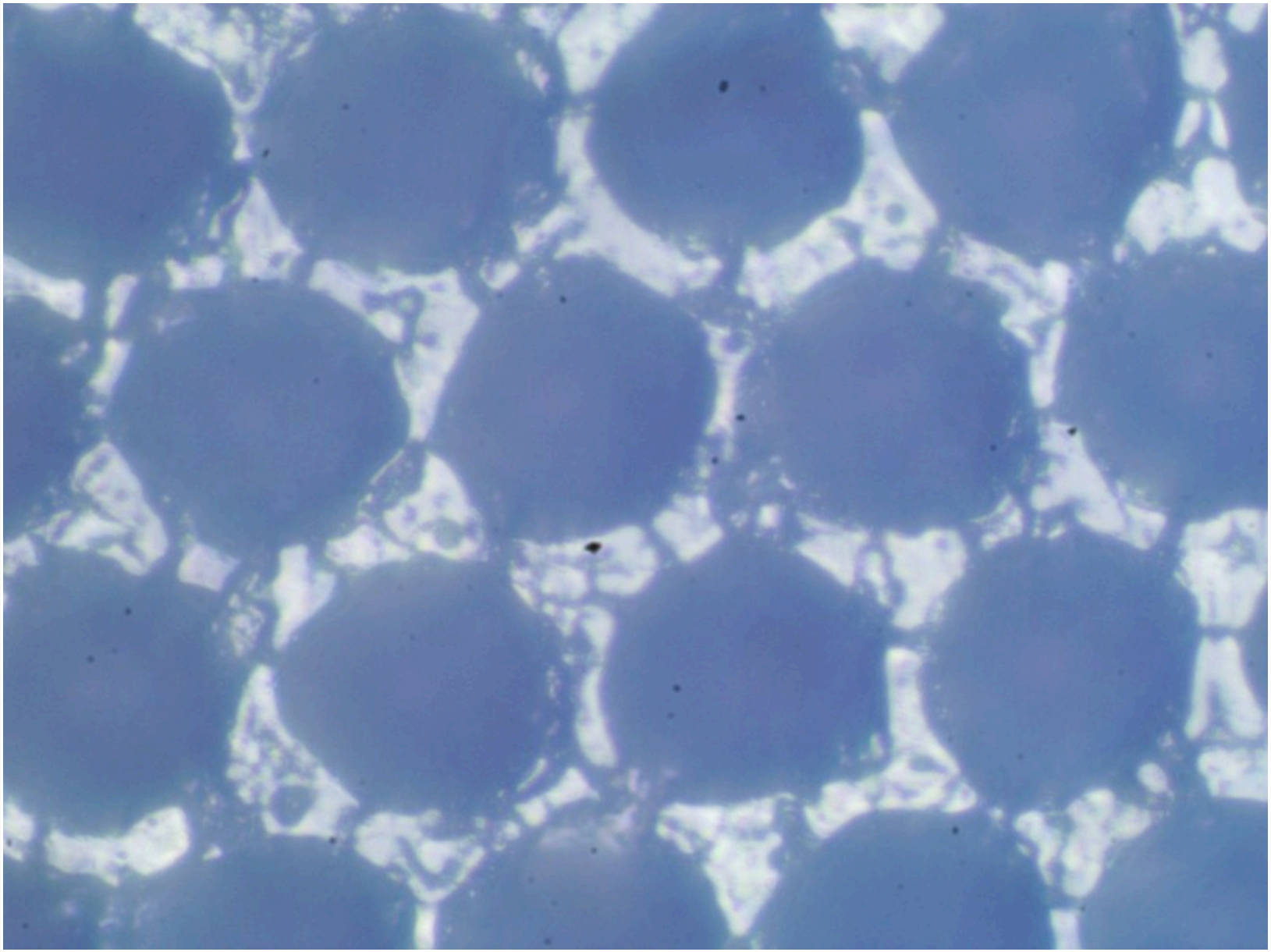
Measured line screen	180	lpcm
Vol	8.10	cm^3/m^2

Ink transfer volume decrease from the nominal value: 19%

Bridge / Cell: 1 / 7
Depth before / after: 27.5 / 27.5 µm
Depth decreased by: 0%

Comment
streaks scratch 205 chips at edges.

Roll is slightly worn.



Page №105. Roll "sg49046-31". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-31".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

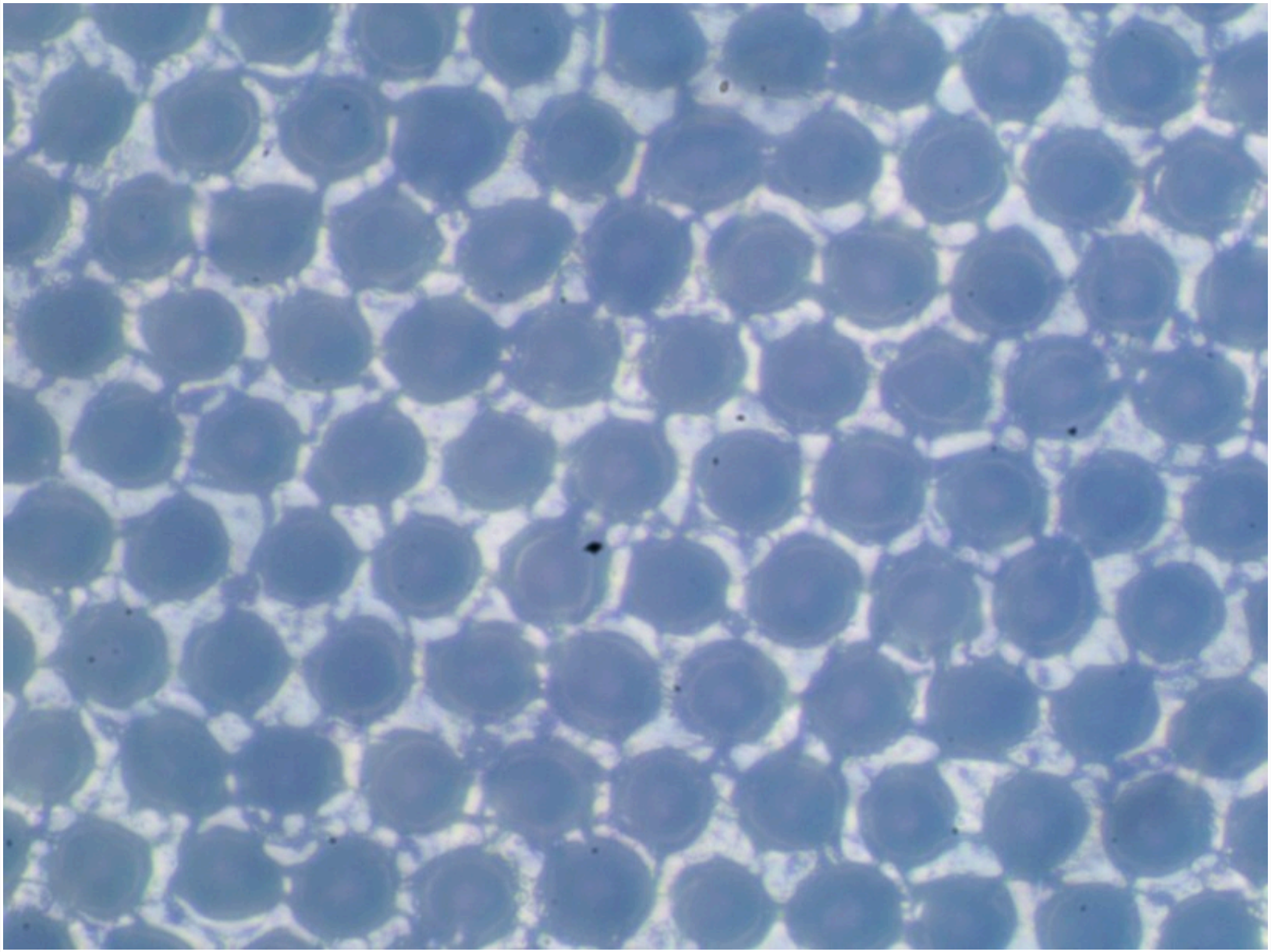
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 15.79%

Bridge / Cell: 1 / 6
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
streak 40.
Roll is worn.



Page №106. Roll "sg49046-5". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-5".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	160	lpcm
Vol	11.0	cm^3/m^2

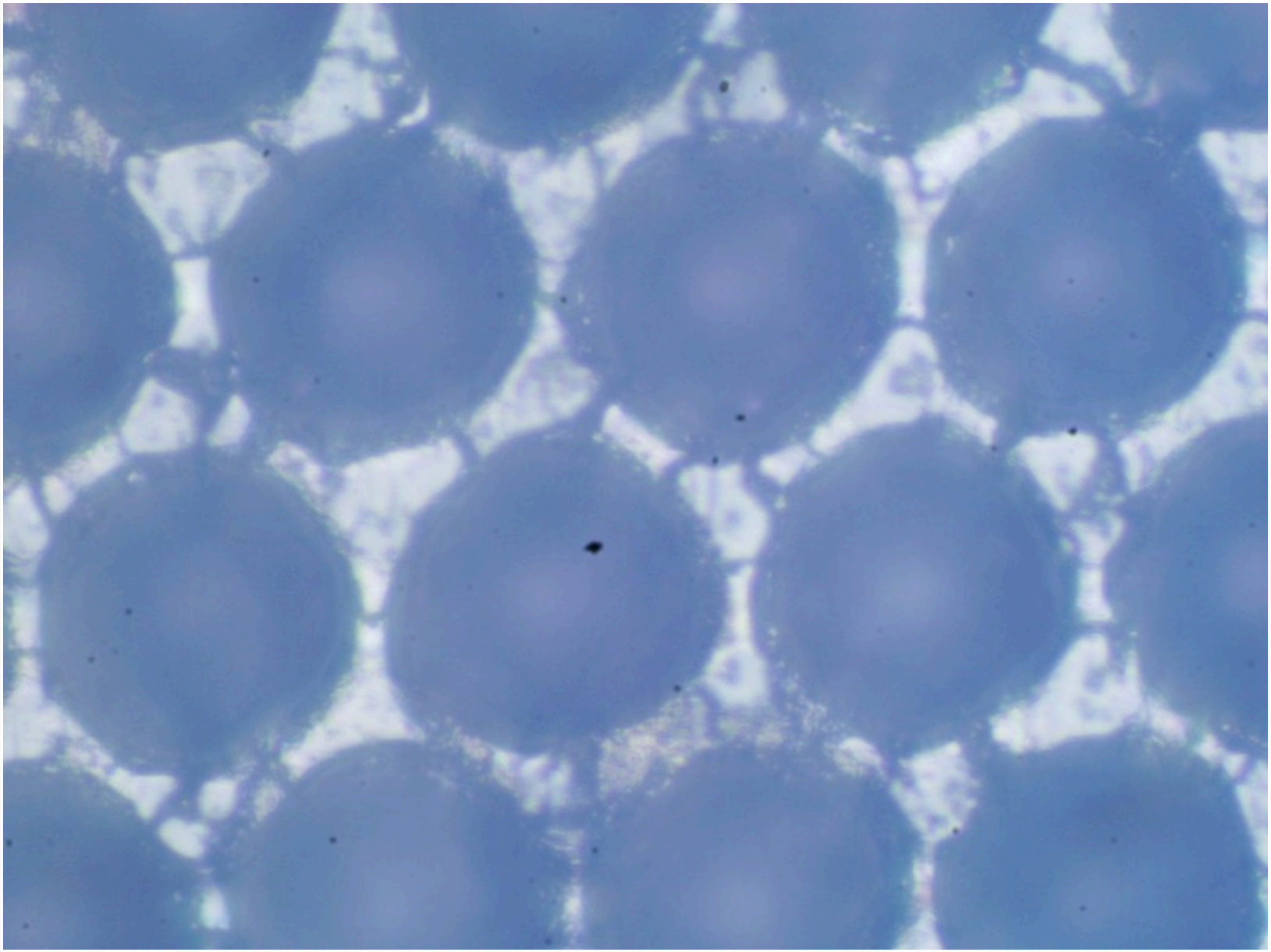
LEC measurements by Troika:

Measured line screen	170	lpcm
Vol	8.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 20.91%

Bridge / Cell: 1 / 8
Depth before / after: 28.5 / 28.5 µm
Depth decreased by: 0%

Comment
streak 480 430.
Roll is slightly worn.



Page №107. Roll "sg49046-20". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-20".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	380	lpcm
Vol	5.0	cm^3/m^2

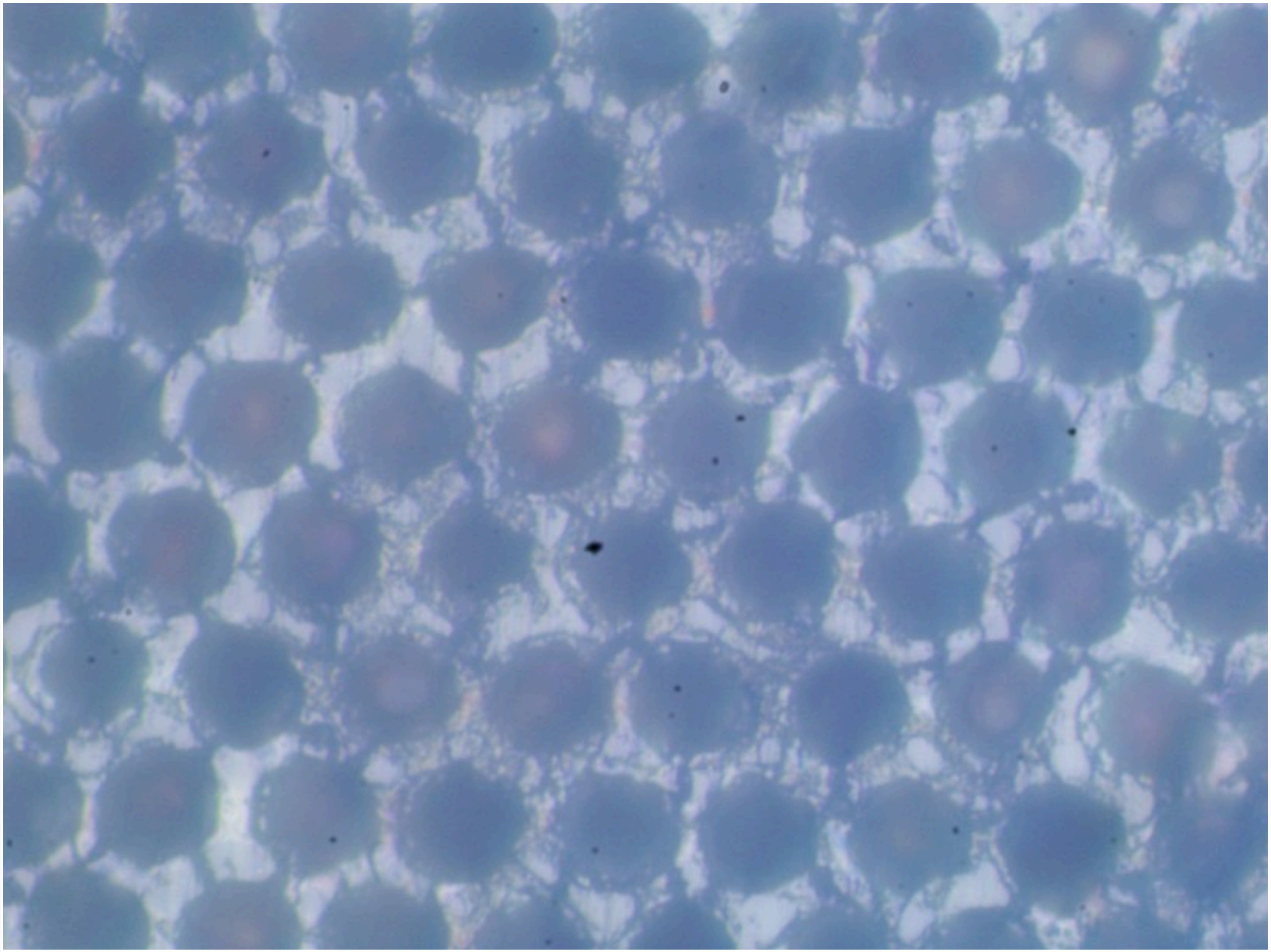
LEC measurements by Troika:

Measured line screen	400	lpcm
Vol	3.10	cm^3/m^2

Ink transfer volume decrease from the nominal value: 38%

Bridge / Cell: 1 / 3
Depth before / after: 13.5 / 13.5 µm
Depth decreased by: 0%

Comment
spot 1335 streak 877 scratch 80.
Roll is heavily worn.



Page №108. Roll "sg49046-14". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-14".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	7.5	cm^3/m^2

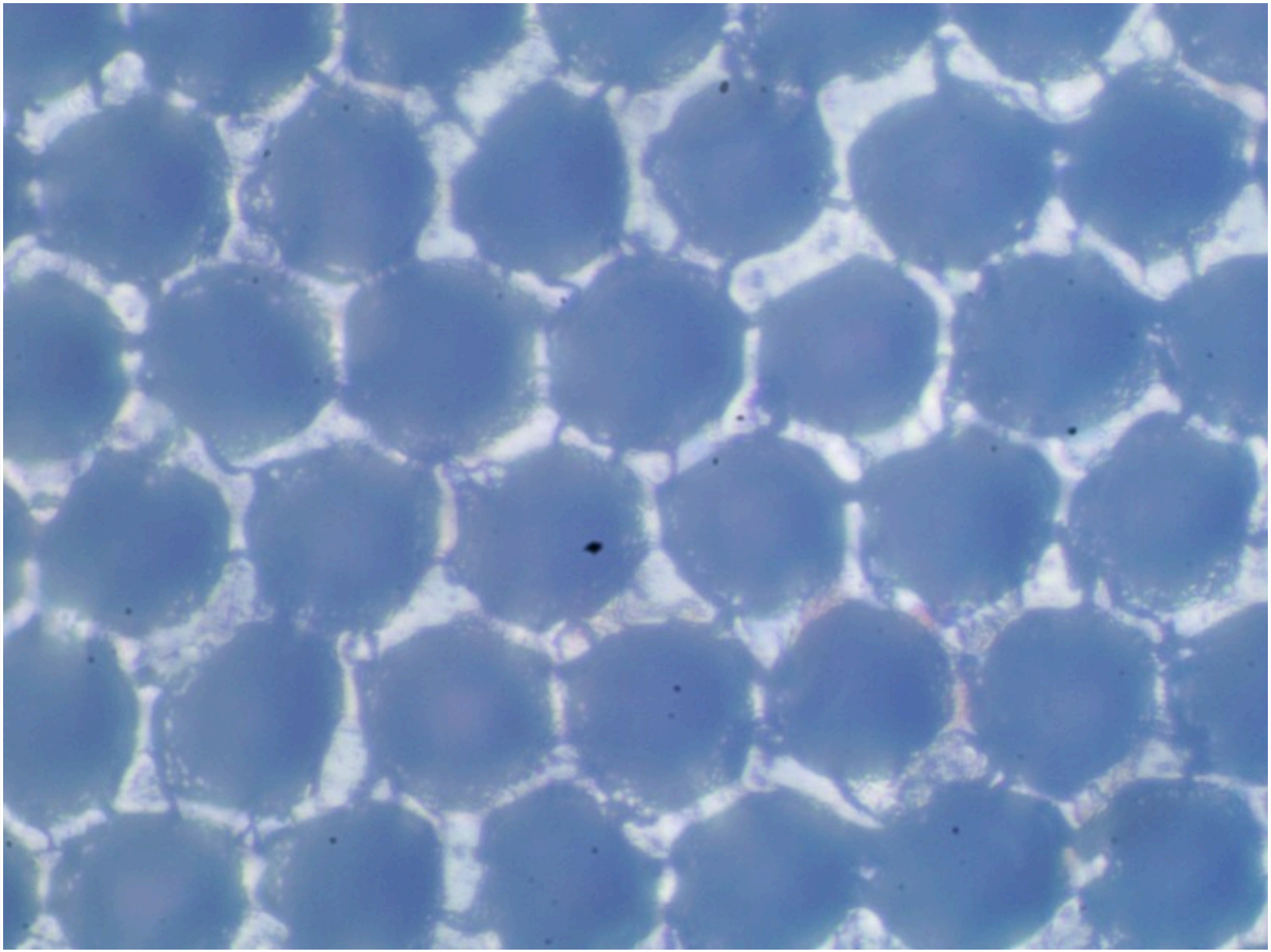
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	7.00	cm^3/m^2

Ink transfer volume decrease from the nominal value: 6.67%

Bridge / Cell: 1 / 8
Depth before / after: 23 / 23 µm
Depth decreased by: 0%

Comment
scratch 1270.
Roll is slightly worn.



Page №109. Roll "sa008602". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008602".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

LEC measurements by Troika:

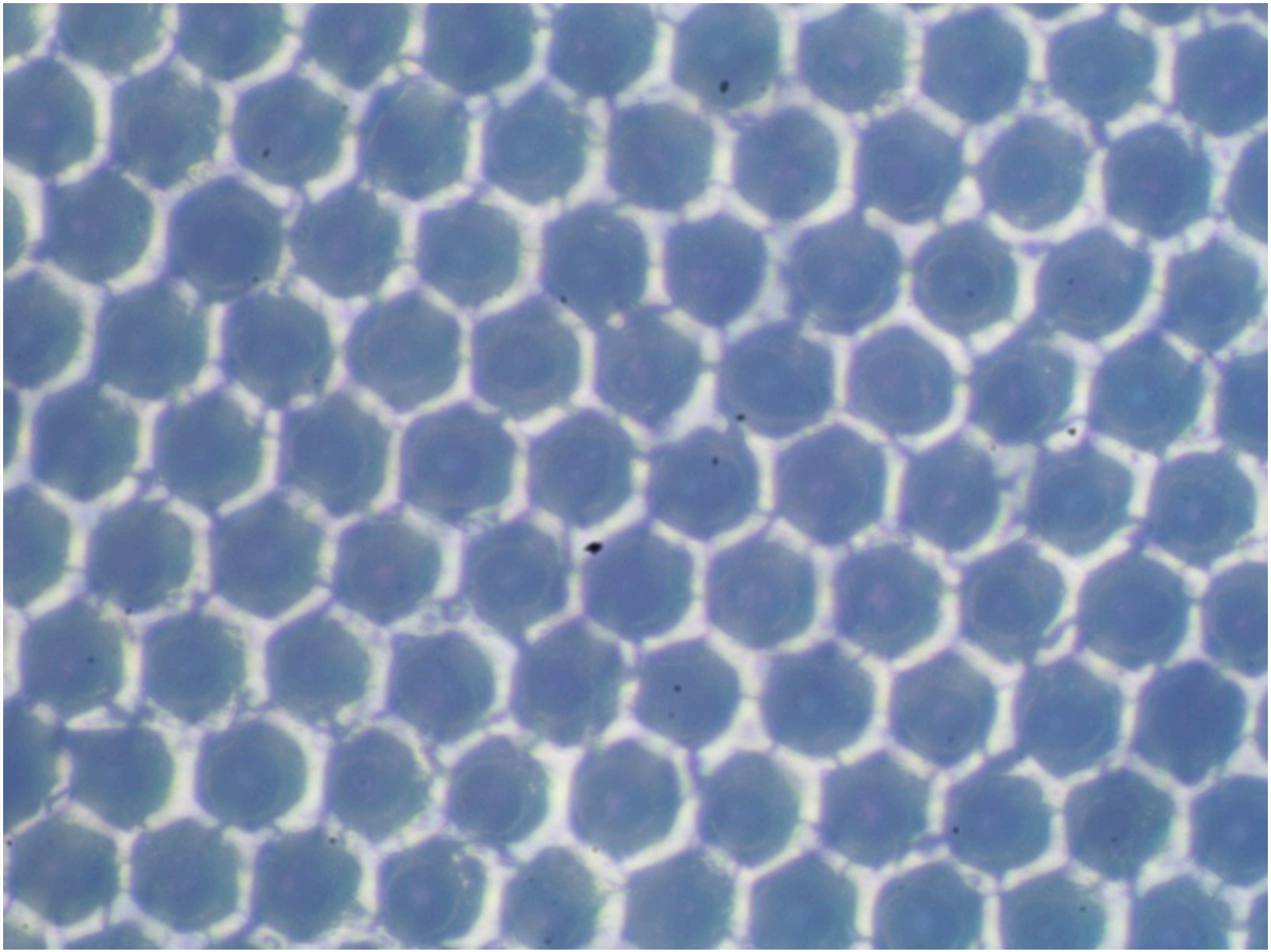
Measured line screen	460	lpcm
Vol	3.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10.53%

Bridge / Cell: 1 / 6
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment
scratch 40 130 1120 90 spots many.

Roll is worn.



Page №110. Roll "z17011016". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011016".	Photo of the anilox roll surface

Roll designations:

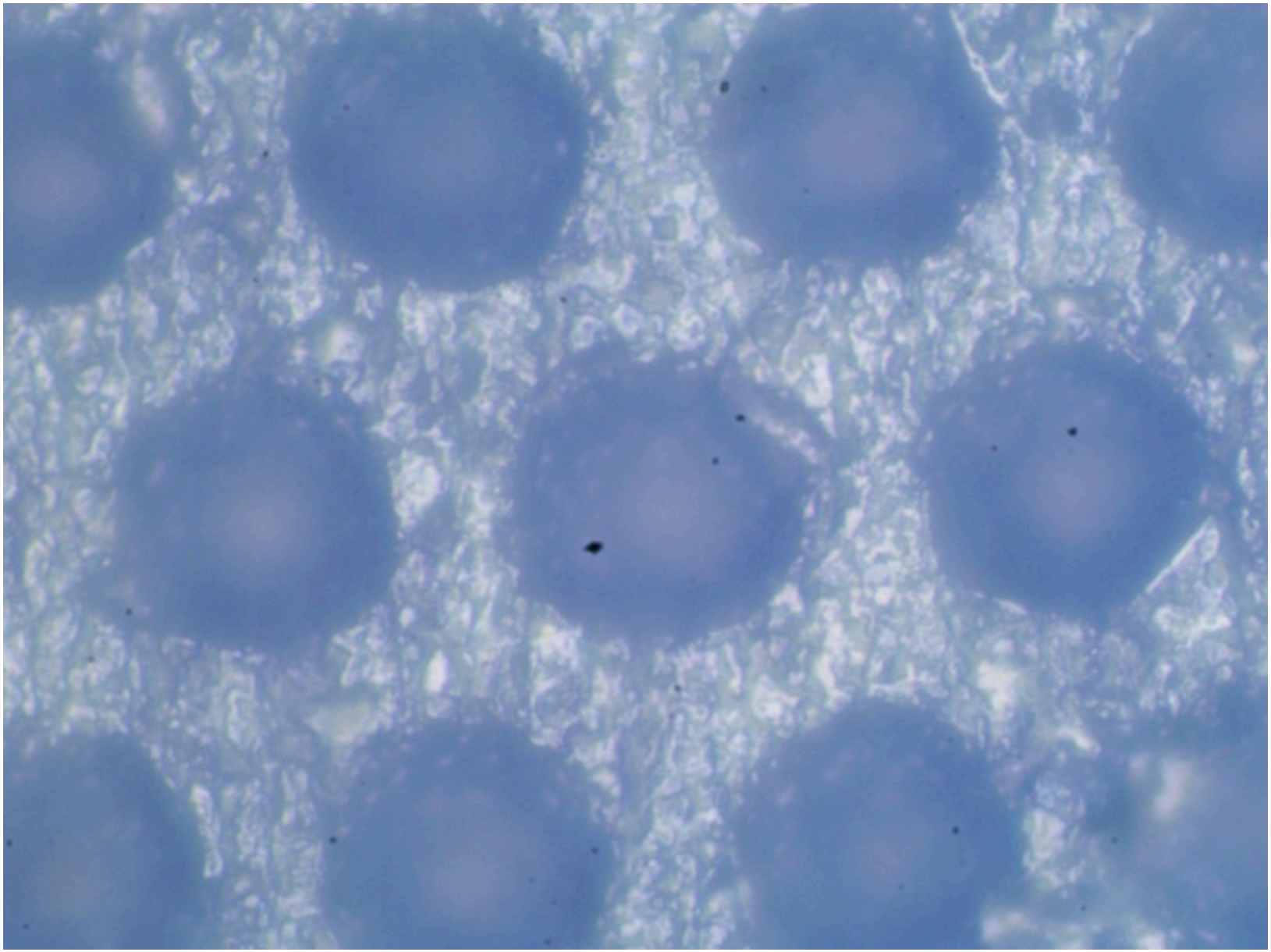
Nominal line screen	140	lpcm
Vol	9.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	110	lpcm
Vol	3.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 64.44%

Bridge / Cell: 1 / 3
Depth before / after: 14 / 14 µm
Depth decreased by: 0%



Comment
worn.
Roll is heavily worn.

Page №111. Roll "sa008593". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008593".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	200	lpcm
Vol	7.5	cm^3/m^2

LEC measurements by Troika:

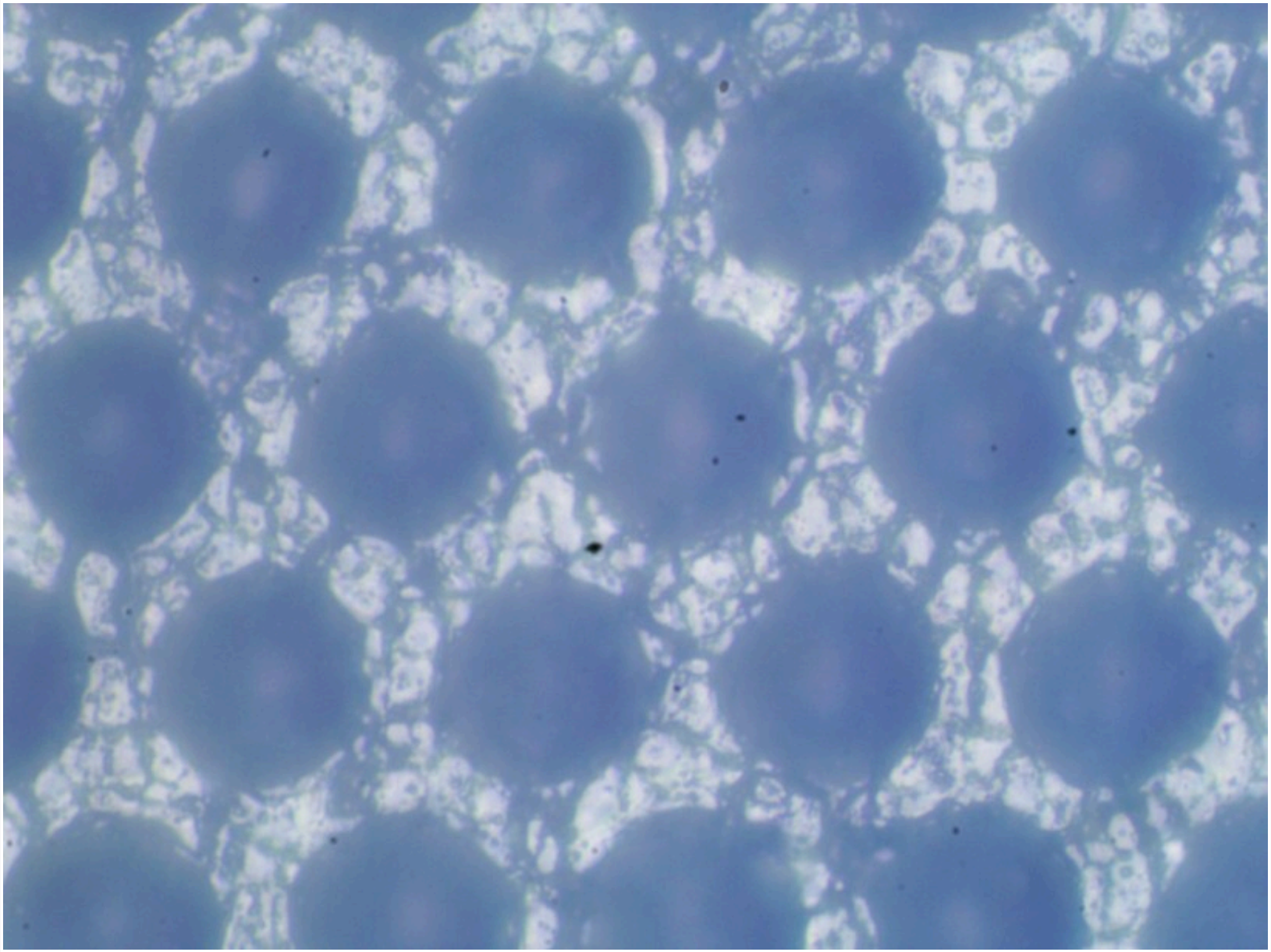
Measured line screen	200	lpcm
Vol	4.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 42.67%

Bridge / Cell: 1 / 4
Depth before / after: 17.5 / 17.5 µm
Depth decreased by: 0%

Comment
streaks many dent 55 worn scratches 55 spots 260

210 180.
Roll is worn.



Page №112. Roll "z48062". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z48062".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	8.5	cm^3/m^2

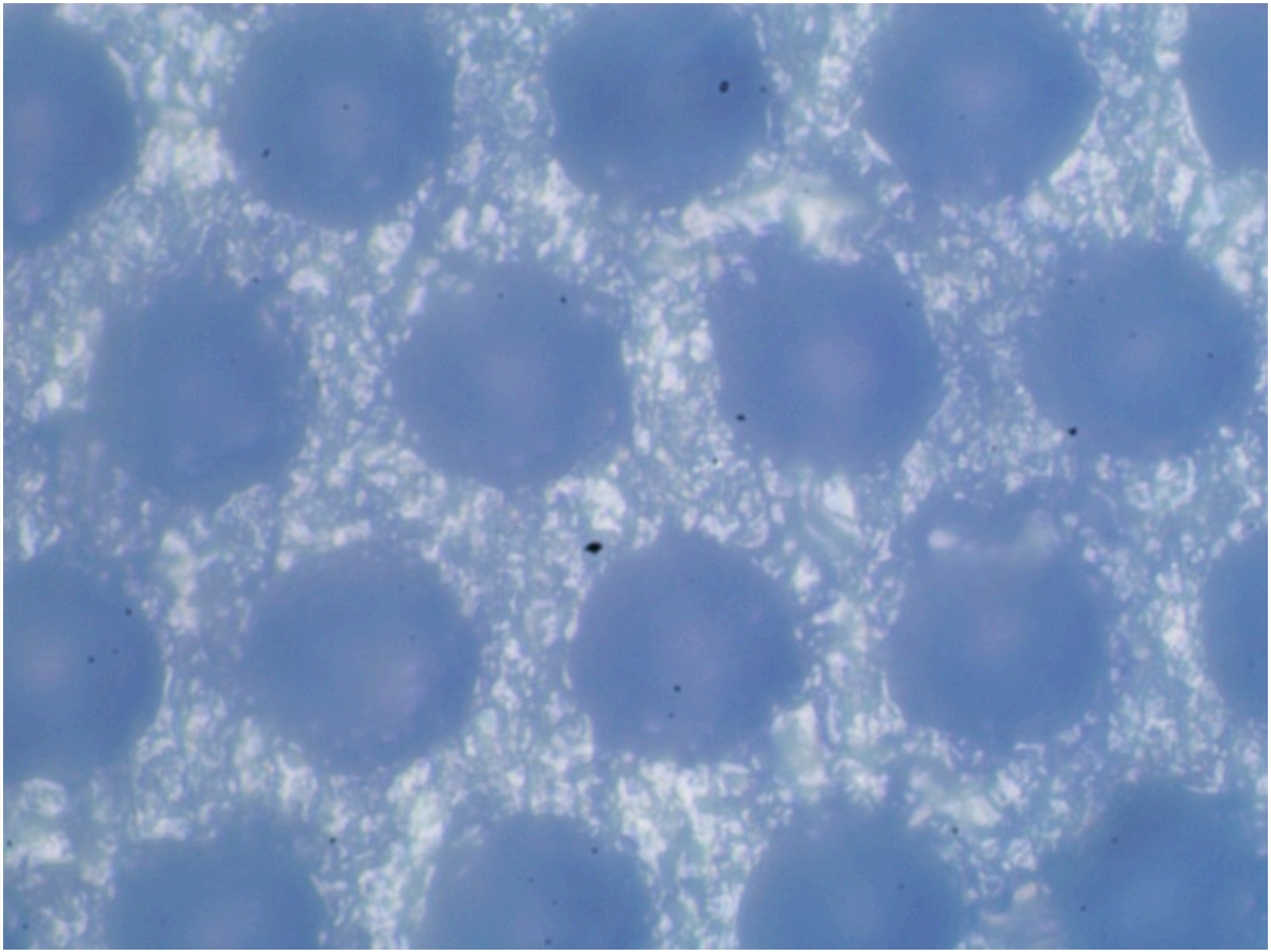
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	3.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 60%

Bridge / Cell: 1 / 3
Depth before / after: 16 / 16 µm
Depth decreased by: 0%

Comment
scratch 80 streaks.
Roll is heavily worn.



Page №113. Roll "h100751-1". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100751-1".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	200	lpcm
Vol	8.5	cm^3/m^2

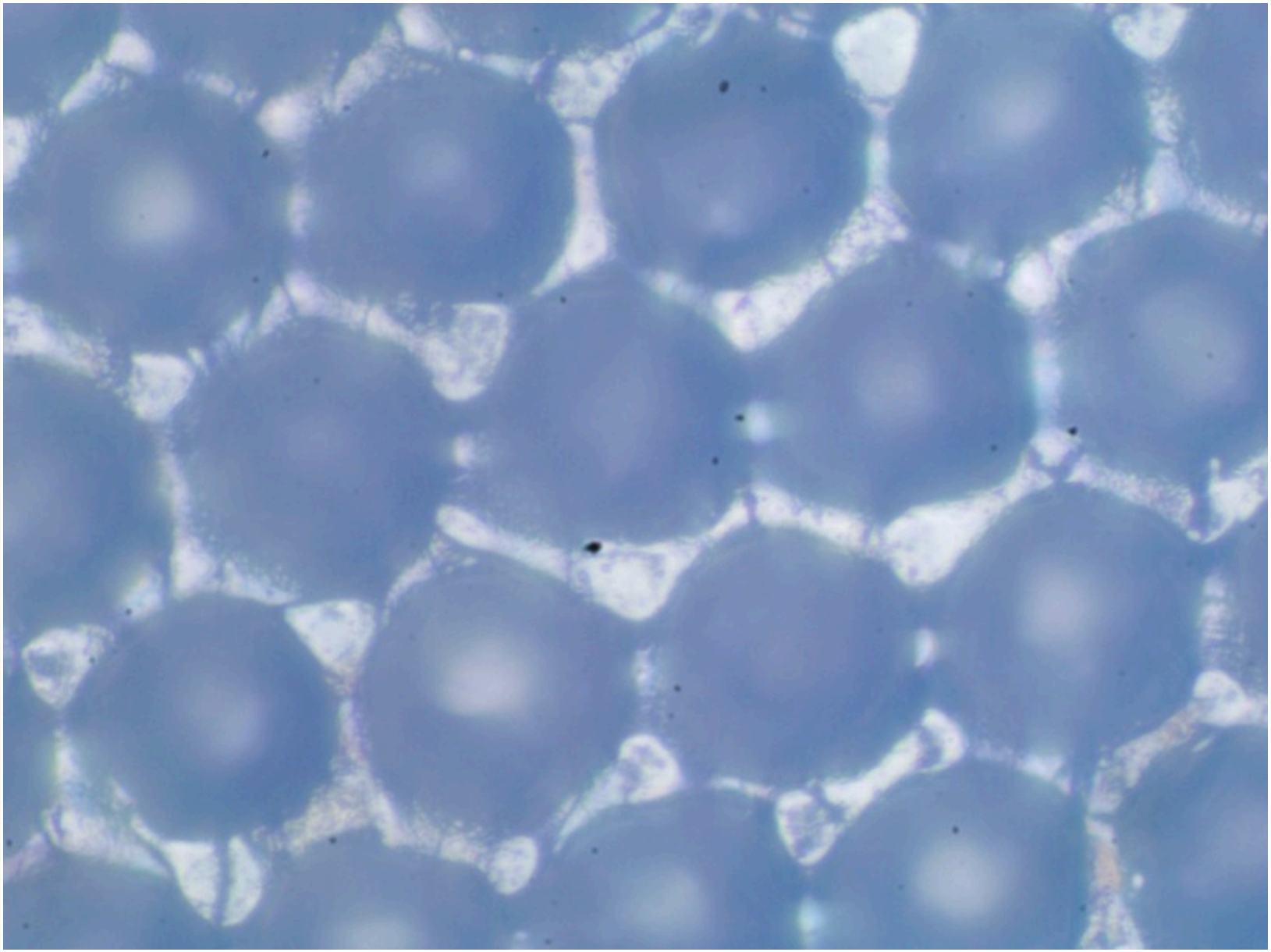
LEC measurements by Troika:

Measured line screen	200	lpcm
Vol	7.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 7.06%

Bridge / Cell: 1 / 9
Depth before / after: 25 / 25 µm
Depth decreased by: 0%

Comment



Page №114. Roll "kk74444". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "kk74444".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	8.0	cm^3/m^2

LEC measurements by Troika:

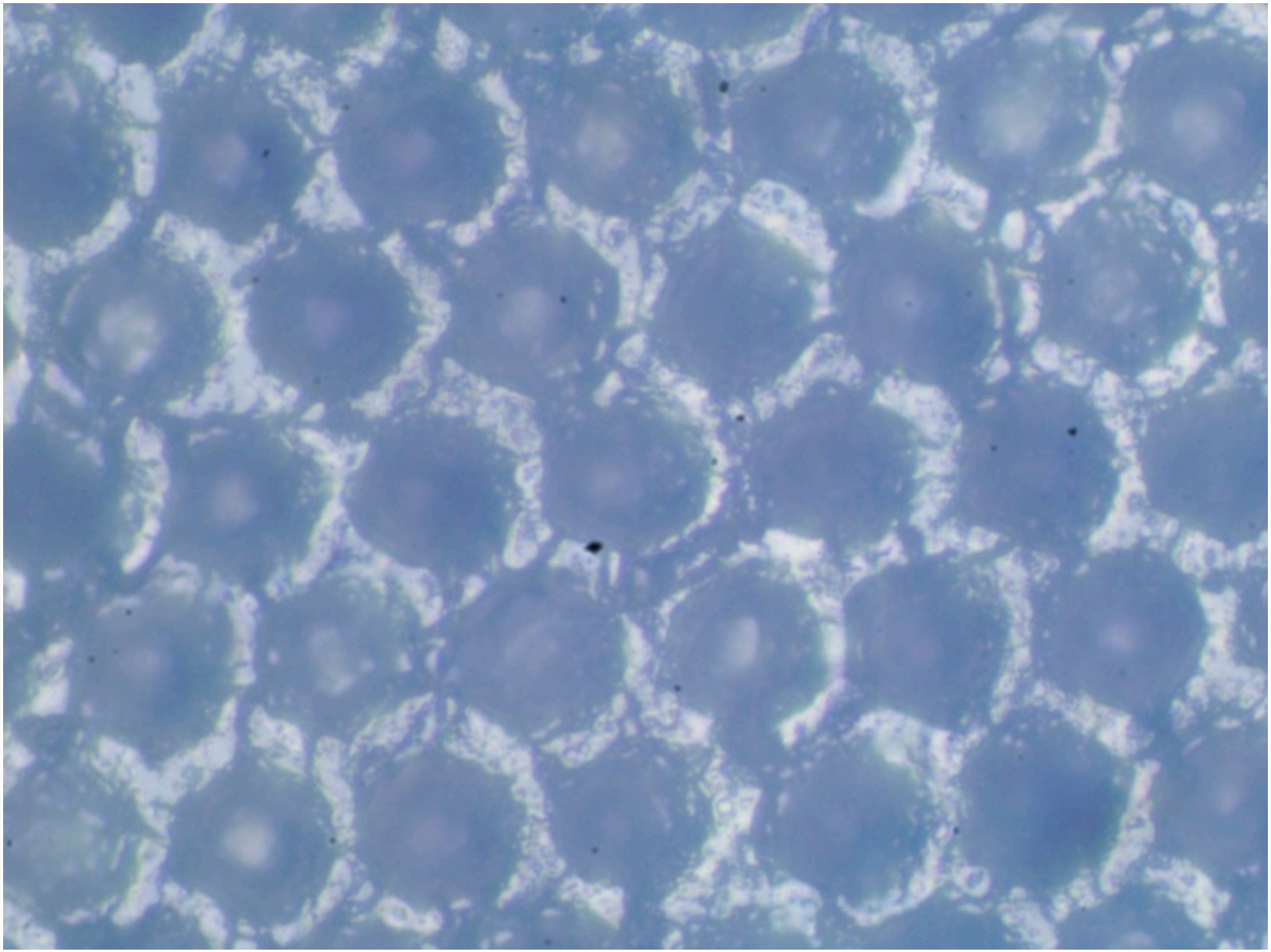
Measured line screen	280	lpcm
Vol	5.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 26.25%

Bridge / Cell: 1 / 4
Depth before / after: 24 / 24 µm
Depth decreased by: 0%

Comment
chips at edges scratch 140 dent 1200 spot 1165 335

260.
Roll is worn.



Page №115. Roll "z45224". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z45224".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	9.5	cm^3/m^2

LEC measurements by Troika:

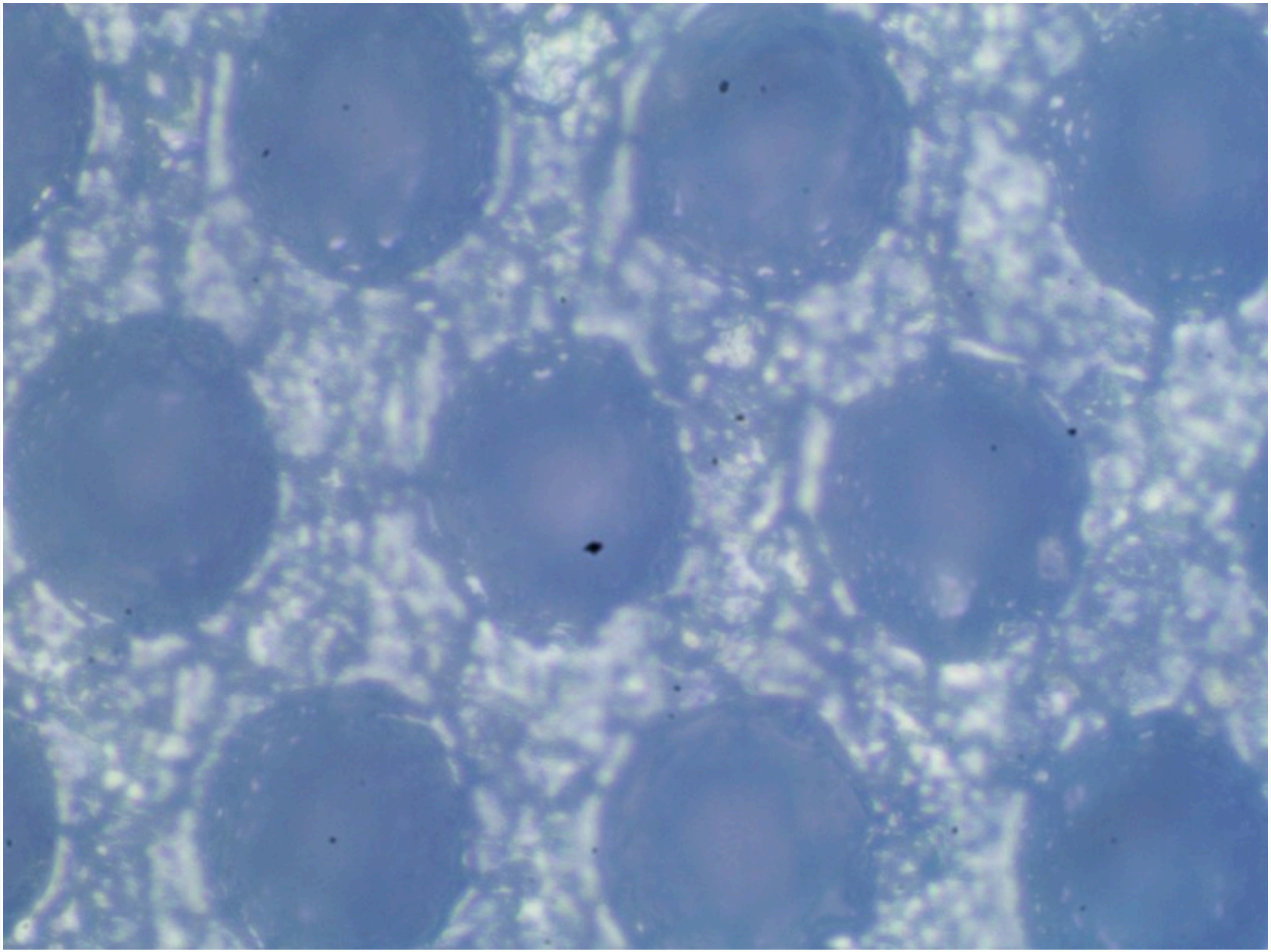
Measured line screen	150	lpcm
Vol	3.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 63.16%

Bridge / Cell: 1 / 3
Depth before / after: 16 / 16 µm
Depth decreased by: 0%

Comment
worn chips at edges scratch 250 dent 45.

Roll is heavily worn.



Page №116. Roll "z17011024". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011024".	Photo of the anilox roll surface

Roll designations:

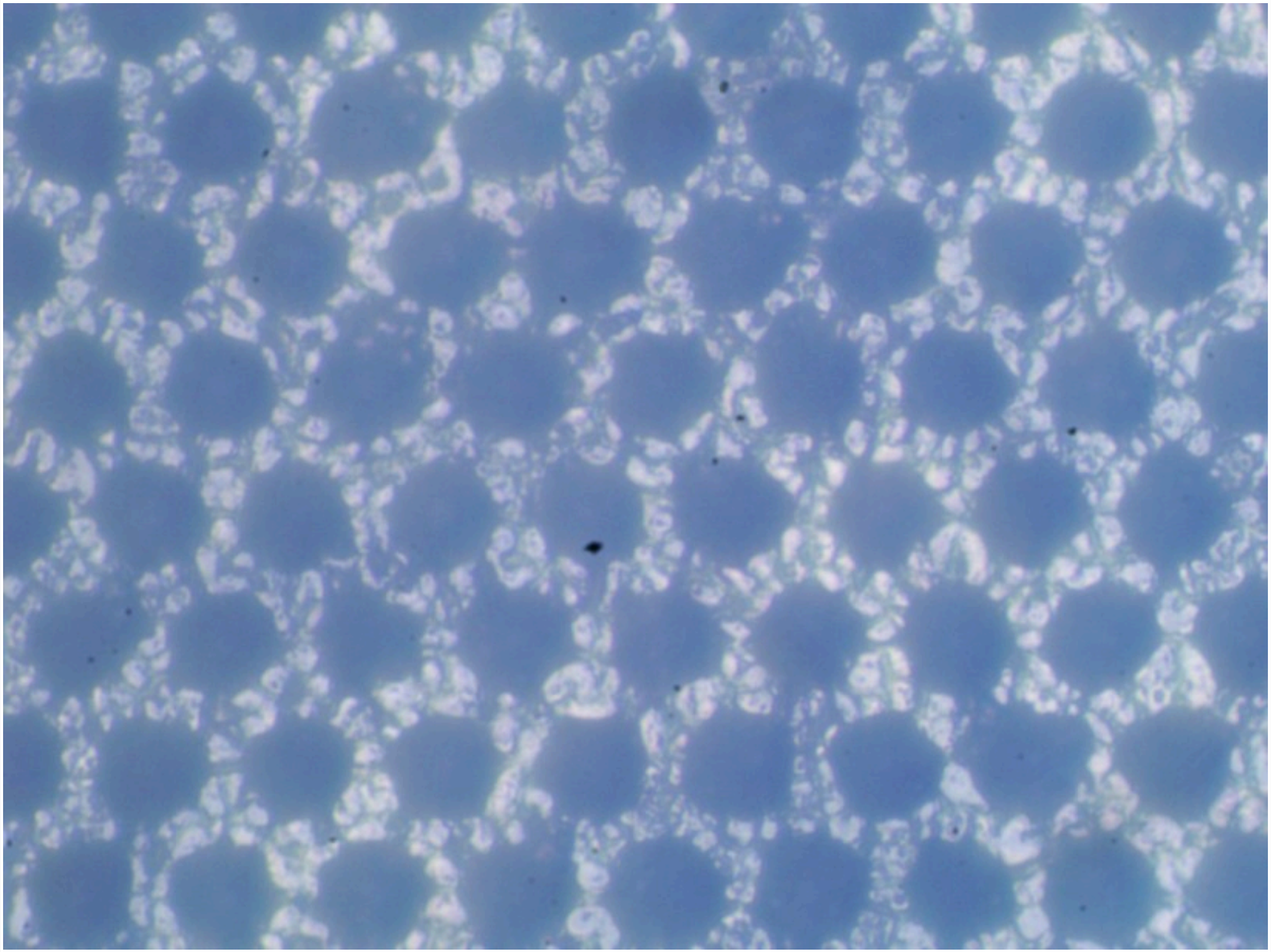
Nominal line screen	400	lpcm
Vol	3.7	cm^3/m^2

LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	1.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 59.46%

Bridge / Cell: 1 / 2
Depth before / after: 10 / 10 µm
Depth decreased by: 0%



Comment
wear spot 1190 1150 590 570 550
streaks scratch 25 dent
1240.
Roll is heavily worn.

Page №117. Roll "h100749-3". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100749-3".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	9.5	cm^3/m^2

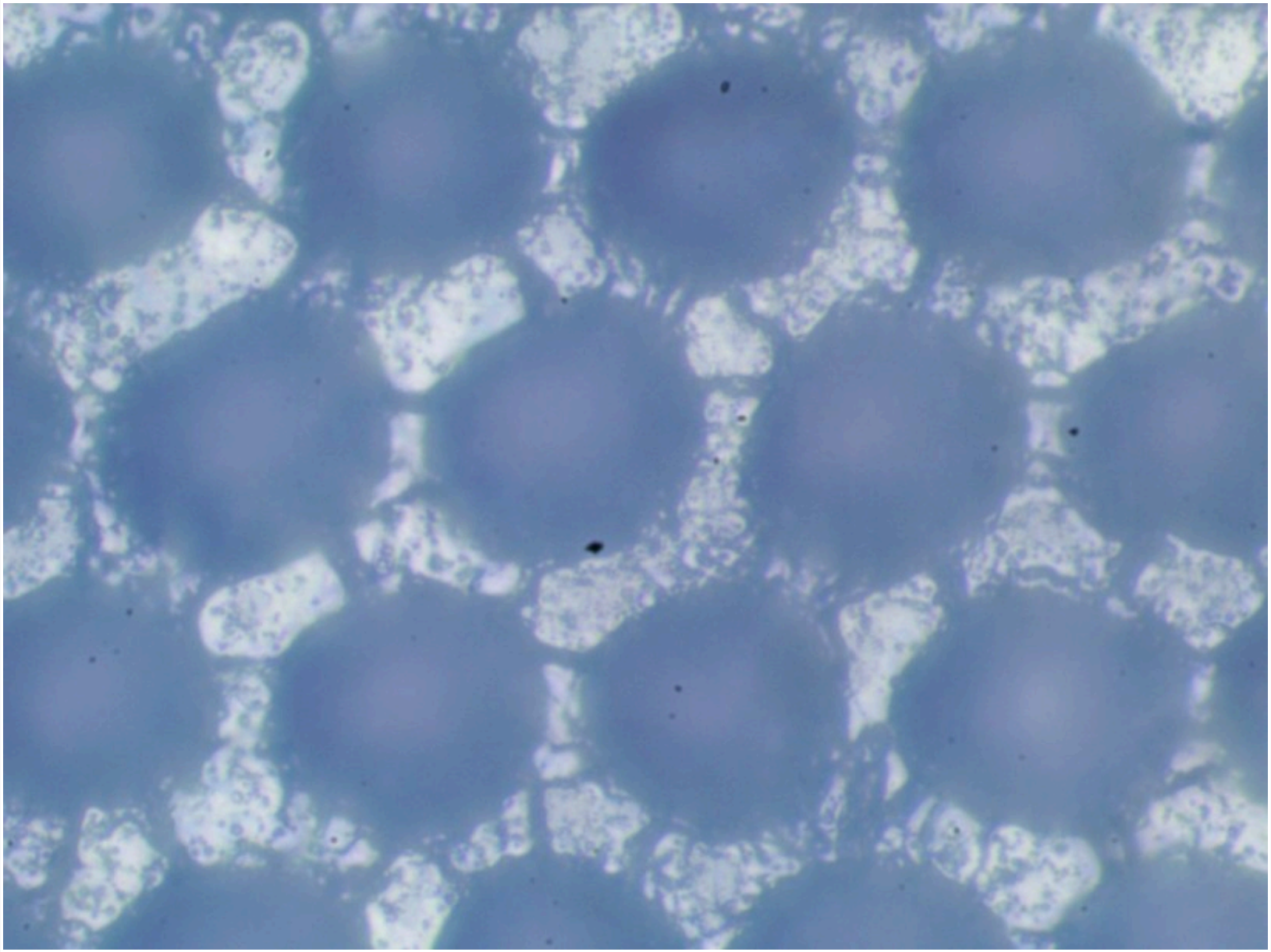
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	7.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 18.95%

Bridge / Cell: 1 / 5
Depth before / after: 28 / 28 µm
Depth decreased by: 0%

Comment
spot many across the entire roll chips 1220 1270.
Roll is worn.



Page №118. Roll "sg4904611". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg4904611".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	240	lpcm
Vol	8.5	cm^3/m^2

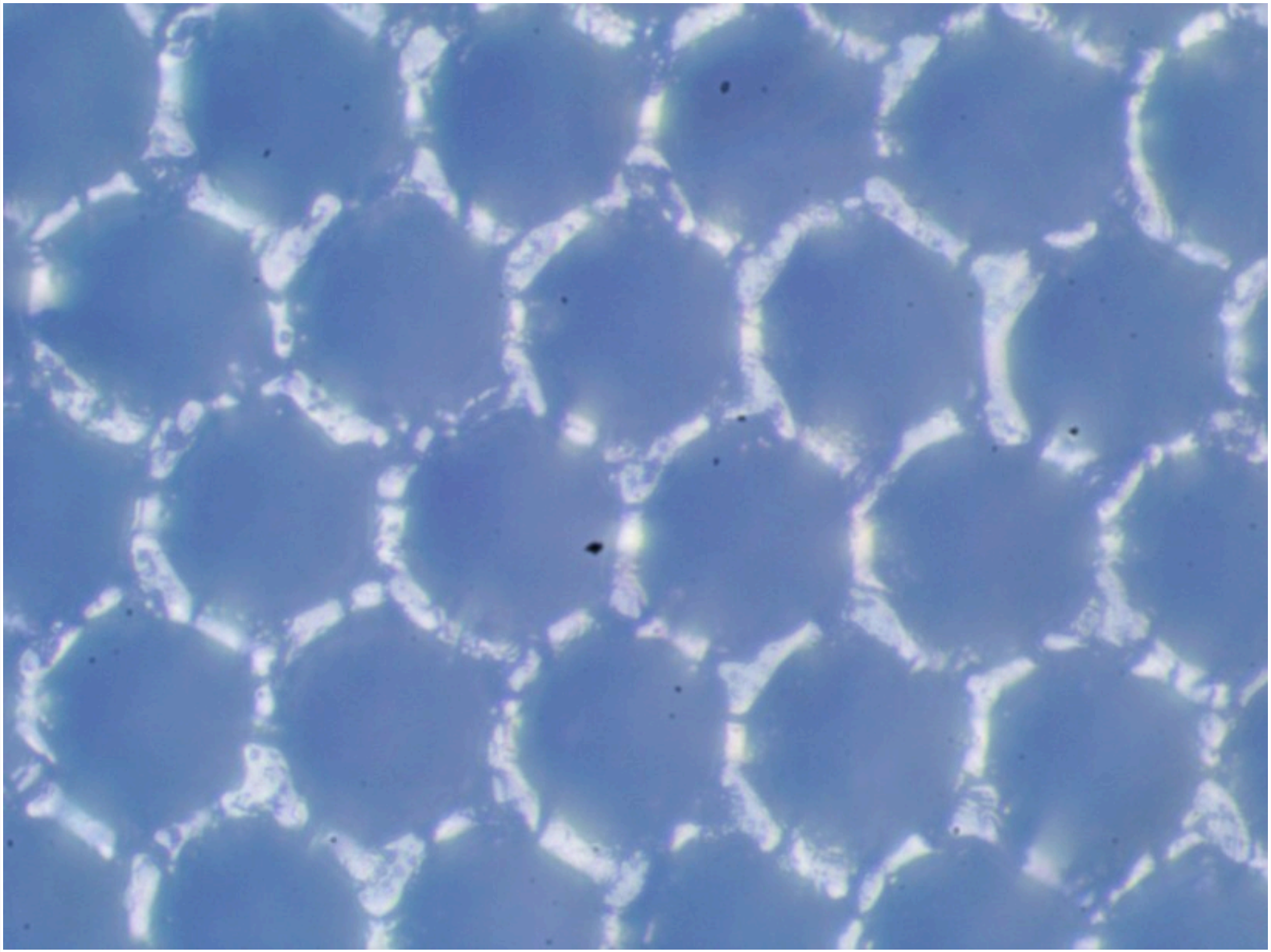
LEC measurements by Troika:

Measured line screen	250	lpcm
Vol	8.50	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 9
Depth before / after: 26 / 26 µm
Depth decreased by: 0%

Comment
chip 278 streak 814.



Page №119. Roll "h100750-4". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100750-4".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	12.5	cm^3/m^2

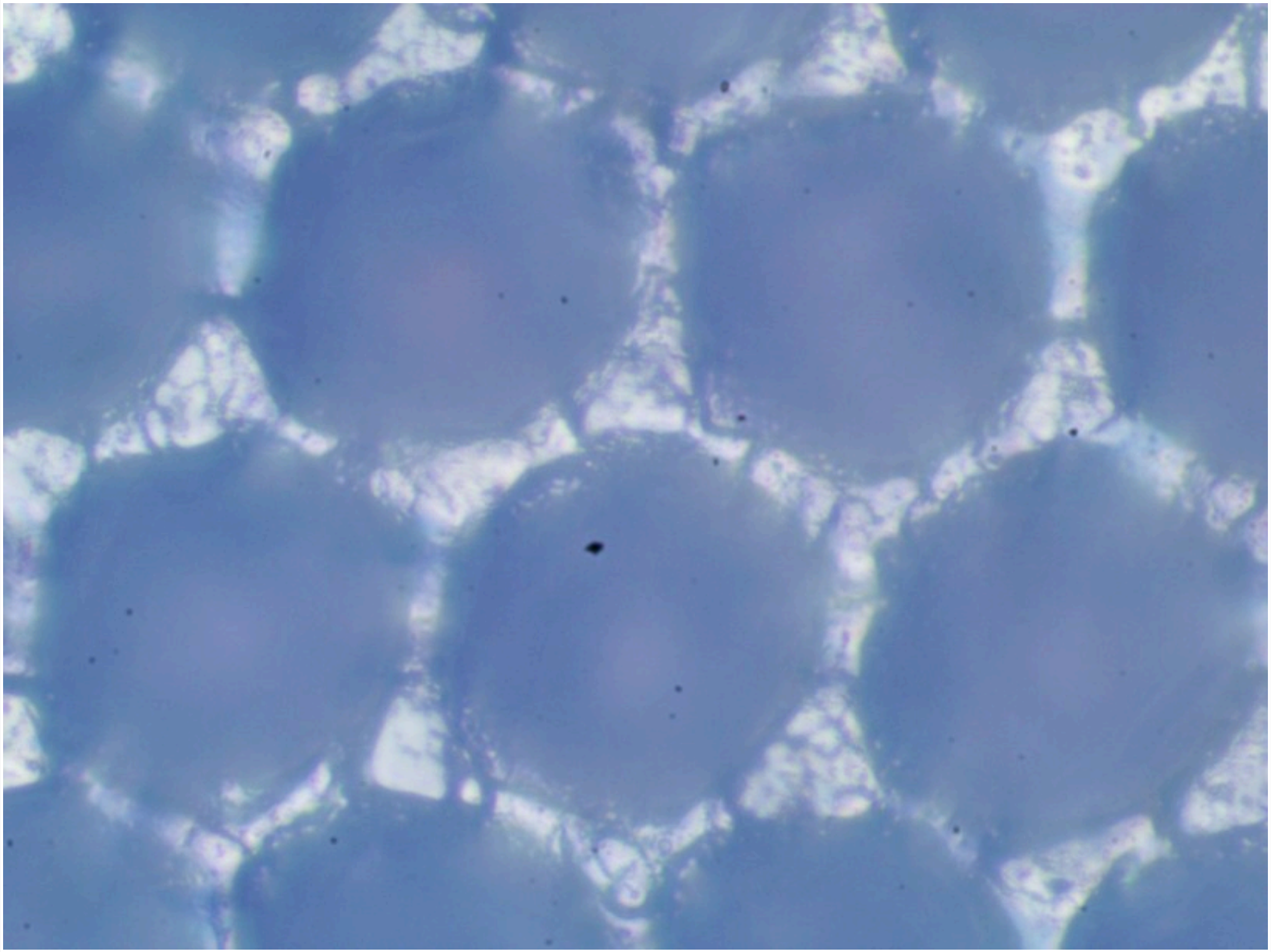
LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	11.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 4.8%

Bridge / Cell: 1 / 13
Depth before / after: 35 / 35 µm
Depth decreased by: 0%

Comment



Page №120. Roll "h100748-2". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100748-2".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	300	lpcm
Vol	6.5	cm^3/m^2

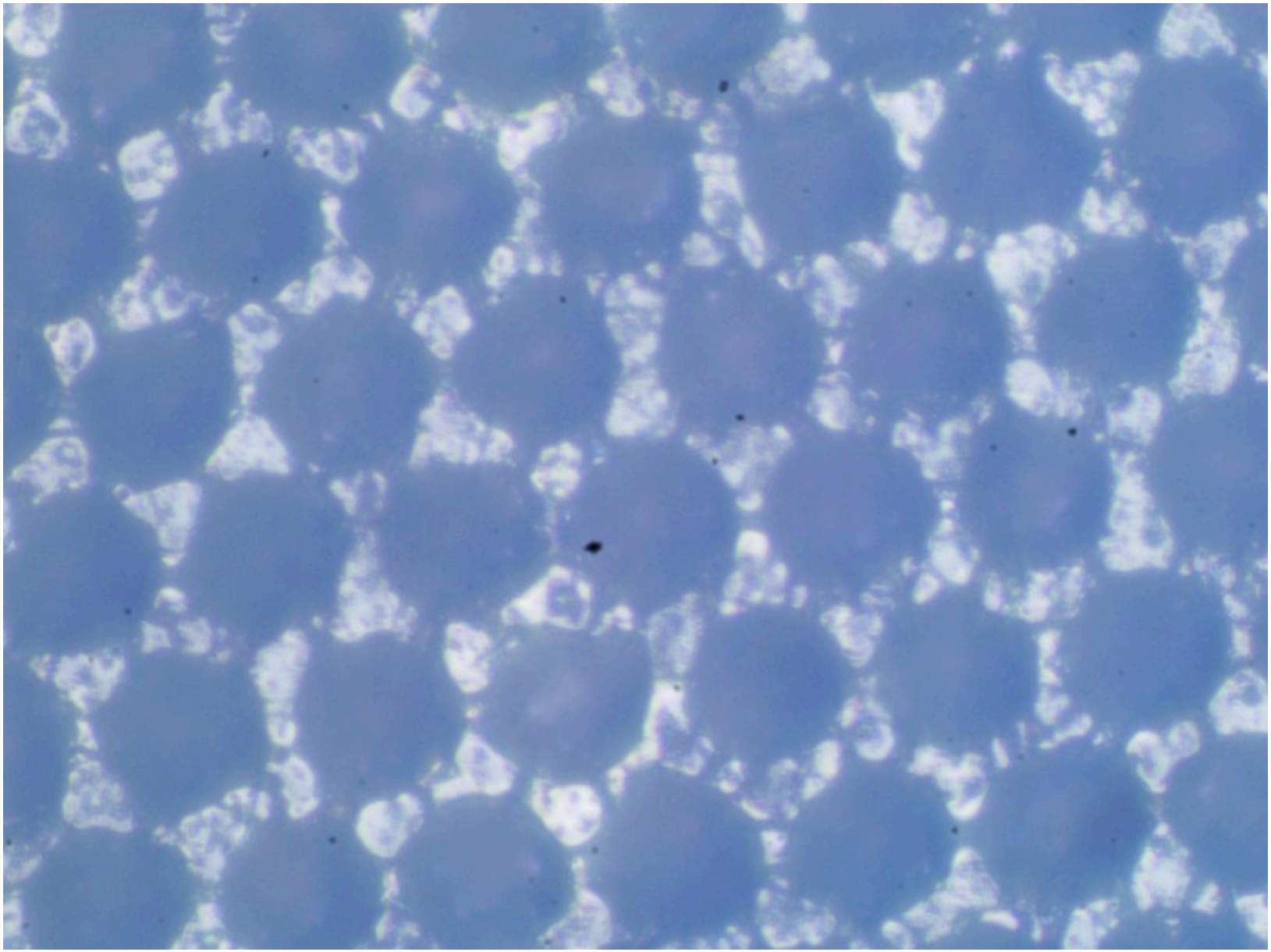
LEC measurements by Troika:

Measured line screen	300	lpcm
Vol	5.00	cm^3/m^2

Ink transfer volume decrease from the nominal value: 23.08%

Bridge / Cell: 1 / 7
Depth before / after: 16.5 / 16.5 µm
Depth decreased by: 0%

Comment
spot 500 635 streaks at edges.
Roll is slightly worn.



Page №121. Roll "sa008609". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008609".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

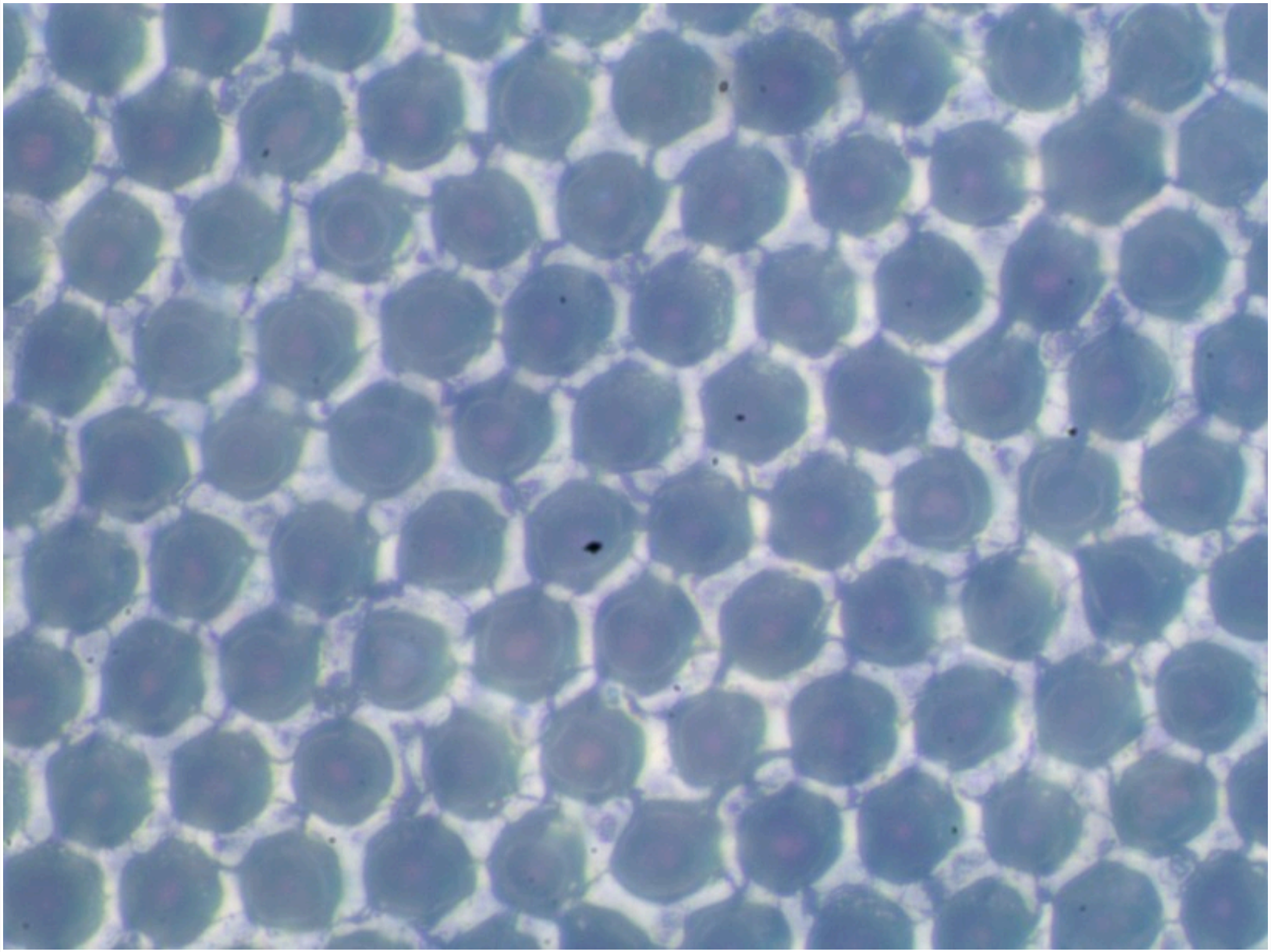
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 7.89%

Bridge / Cell: 1 / 10
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
spot 380.



Page №122. Roll "z16007651". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z16007651".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	9.2	cm^3/m^2

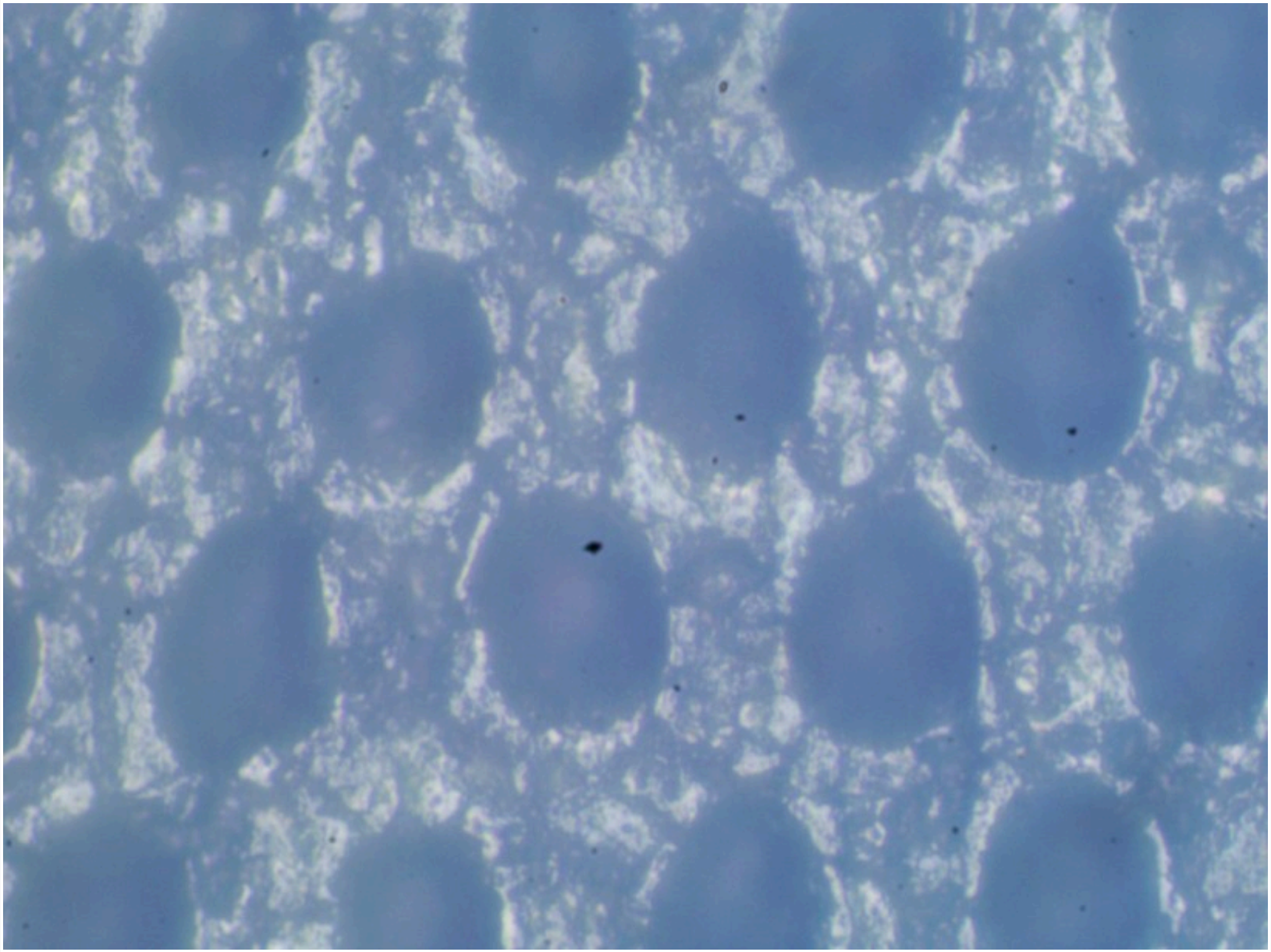
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	2.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 76.09%

Bridge / Cell: 1 / 2
Depth before / after: 15 / 15 µm
Depth decreased by: 0%

Comment
worn.
Roll is heavily worn.



Page №123. Roll "z16007652". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z16007652".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	160	lpcm
Vol	12.0	cm^3/m^2

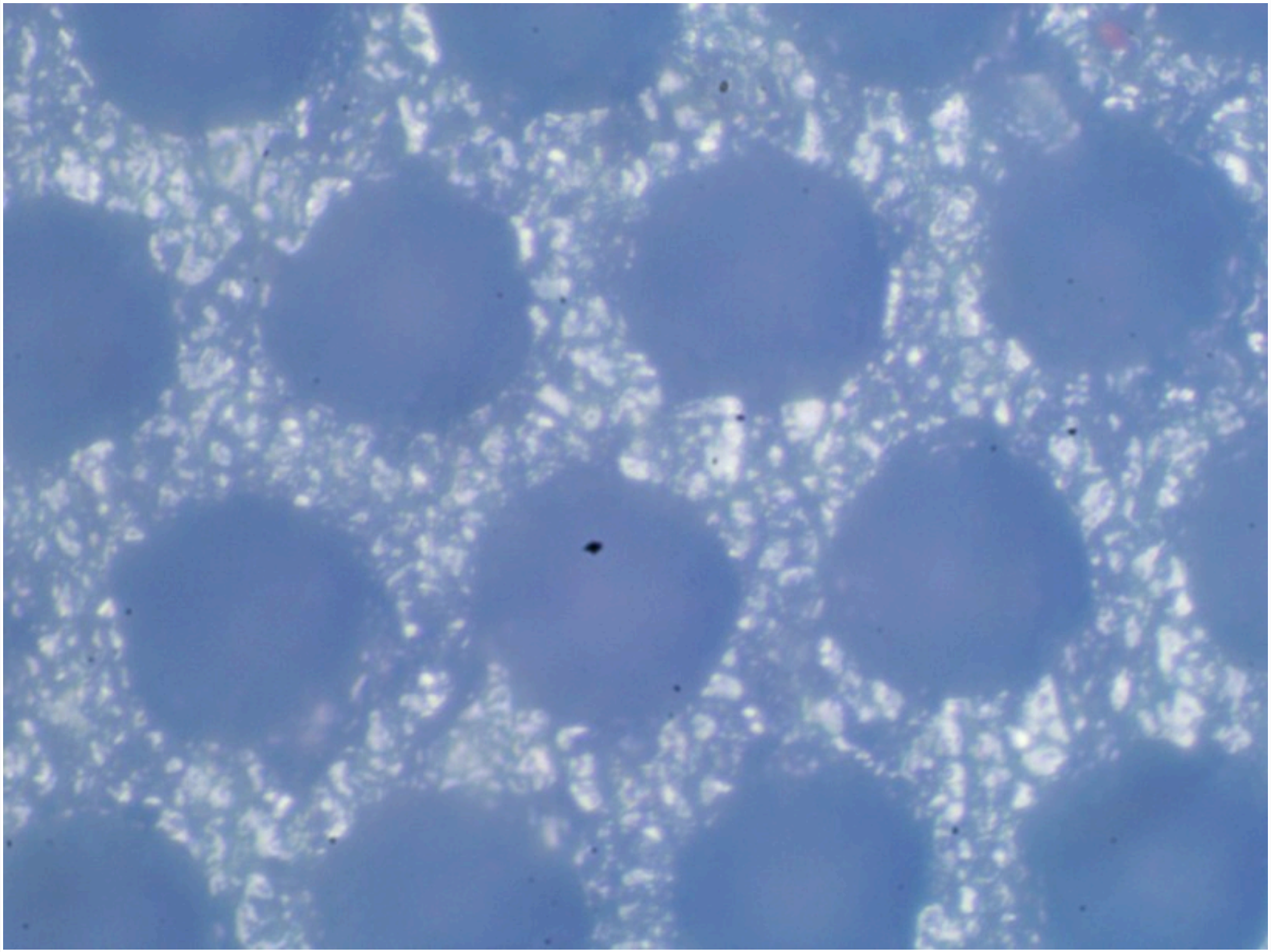
LEC measurements by Troika:

Measured line screen	160	lpcm
Vol	5.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 56.67%

Bridge / Cell: 1 / 3
Depth before / after: 23 / 23 µm
Depth decreased by: 0%

Comment
streaks at edges , 640.
Roll is heavily worn.



Page №124. Roll "sa008607". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008607".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

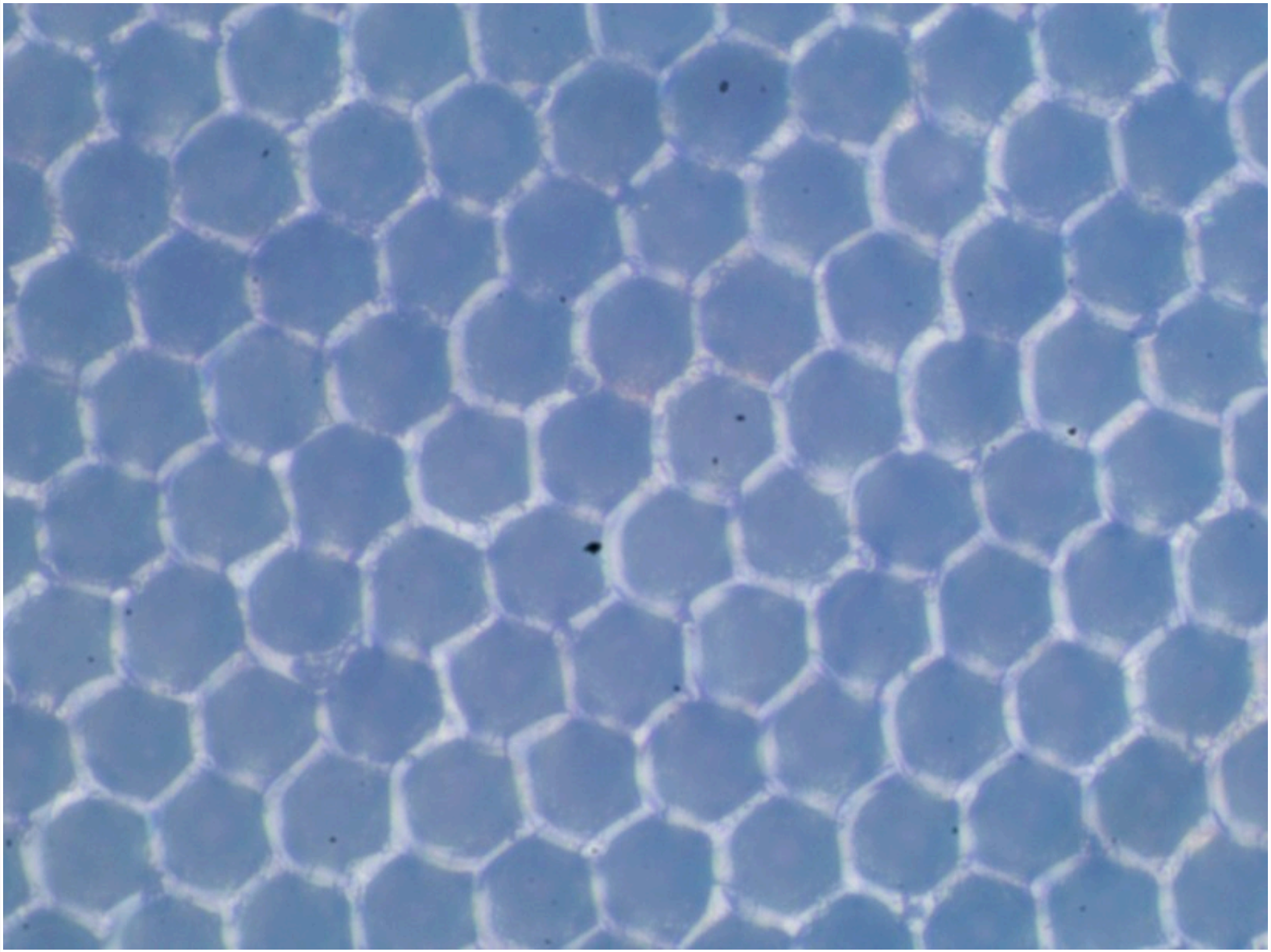
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 15.79%

Bridge / Cell: 1 / 10
Depth before / after: 10 / 10 µm
Depth decreased by: 0%

Comment



Page №125. Roll "aa2413872". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413872".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

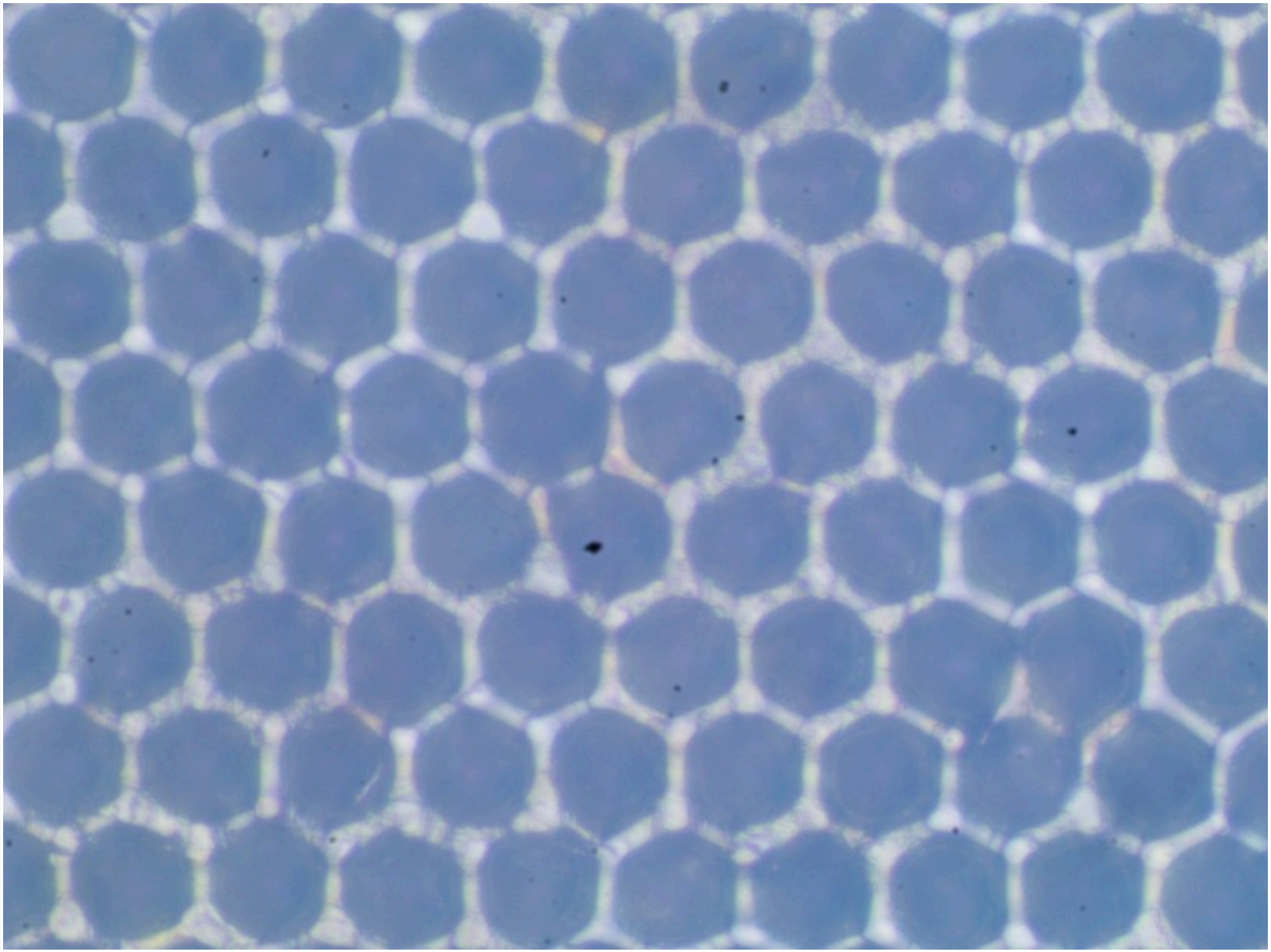
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	3.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 5%

Bridge / Cell: 1 / 7
Depth before / after: 12.5 / 12.5 µm
Depth decreased by: 0%

Comment
streak at edge.
Roll is slightly worn.



Page №126. Roll "h100748-3". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100748-3".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	12.5	cm^3/m^2

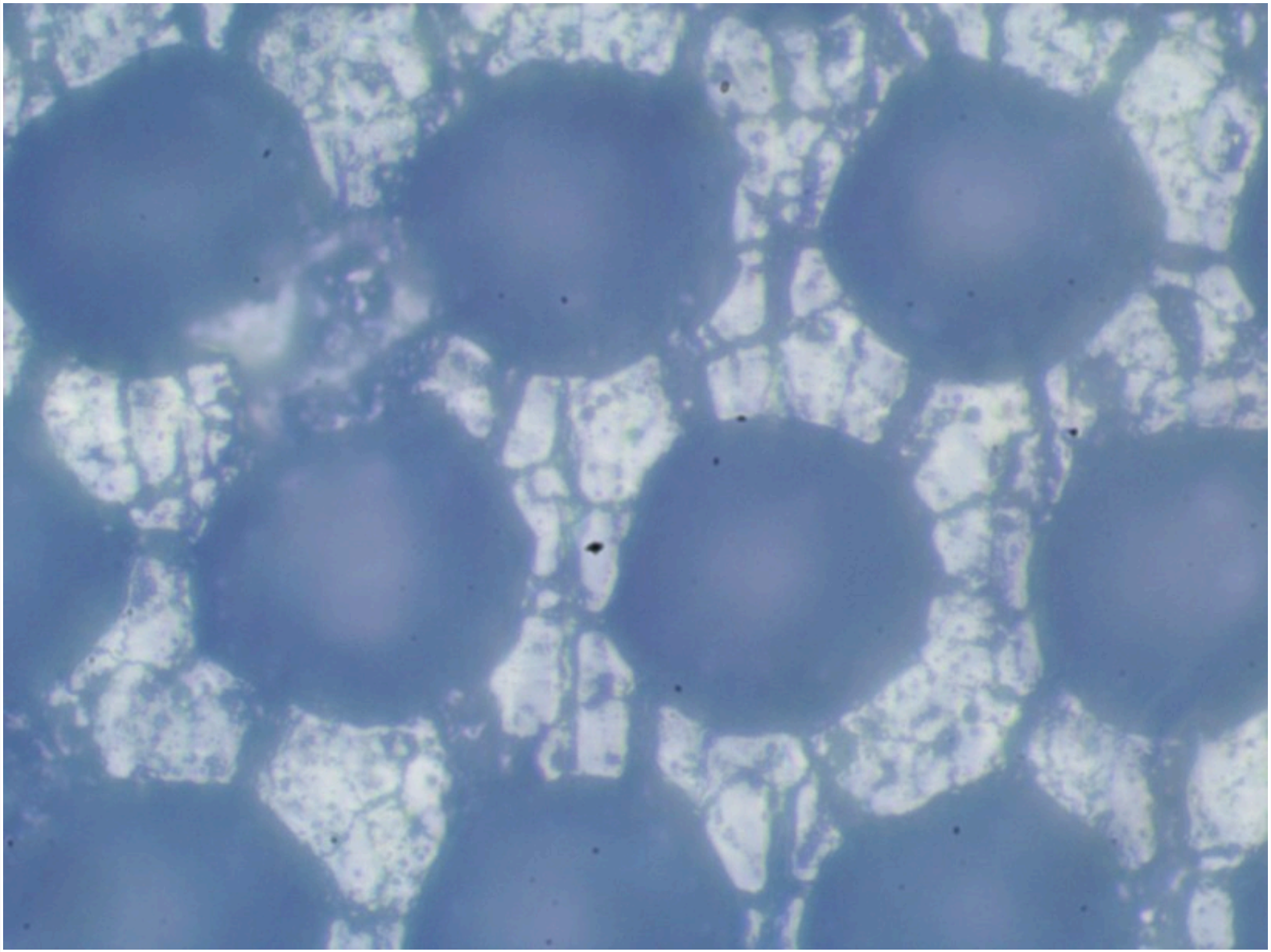
LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	5.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 56.8%

Bridge / Cell: 1 / 4
Depth before / after: 22 / 22 µm
Depth decreased by: 0%

Comment
streak 610.
Roll is worn.



Page №127. Roll "sa008608". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008608".	Photo of the anilox roll surface

Roll designations:

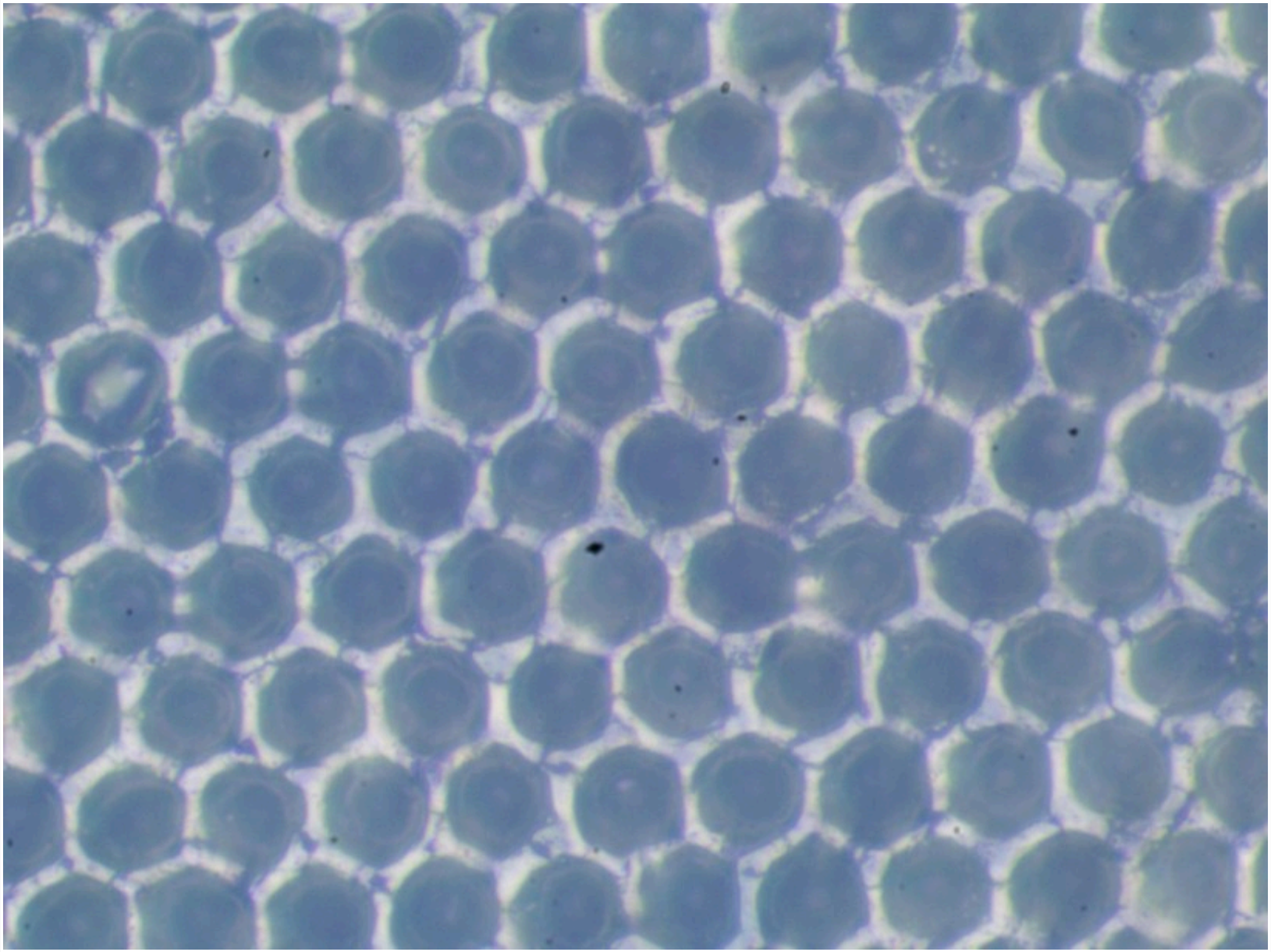
Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 7.89%

Bridge / Cell: 1 / 6
Depth before / after: 12 / 12 µm
Depth decreased by: 0%



Comment
spots.
Roll is worn.

Page №128. Roll "aa2413869". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413869".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	340	lpcm
Vol	5.5	cm^3/m^2

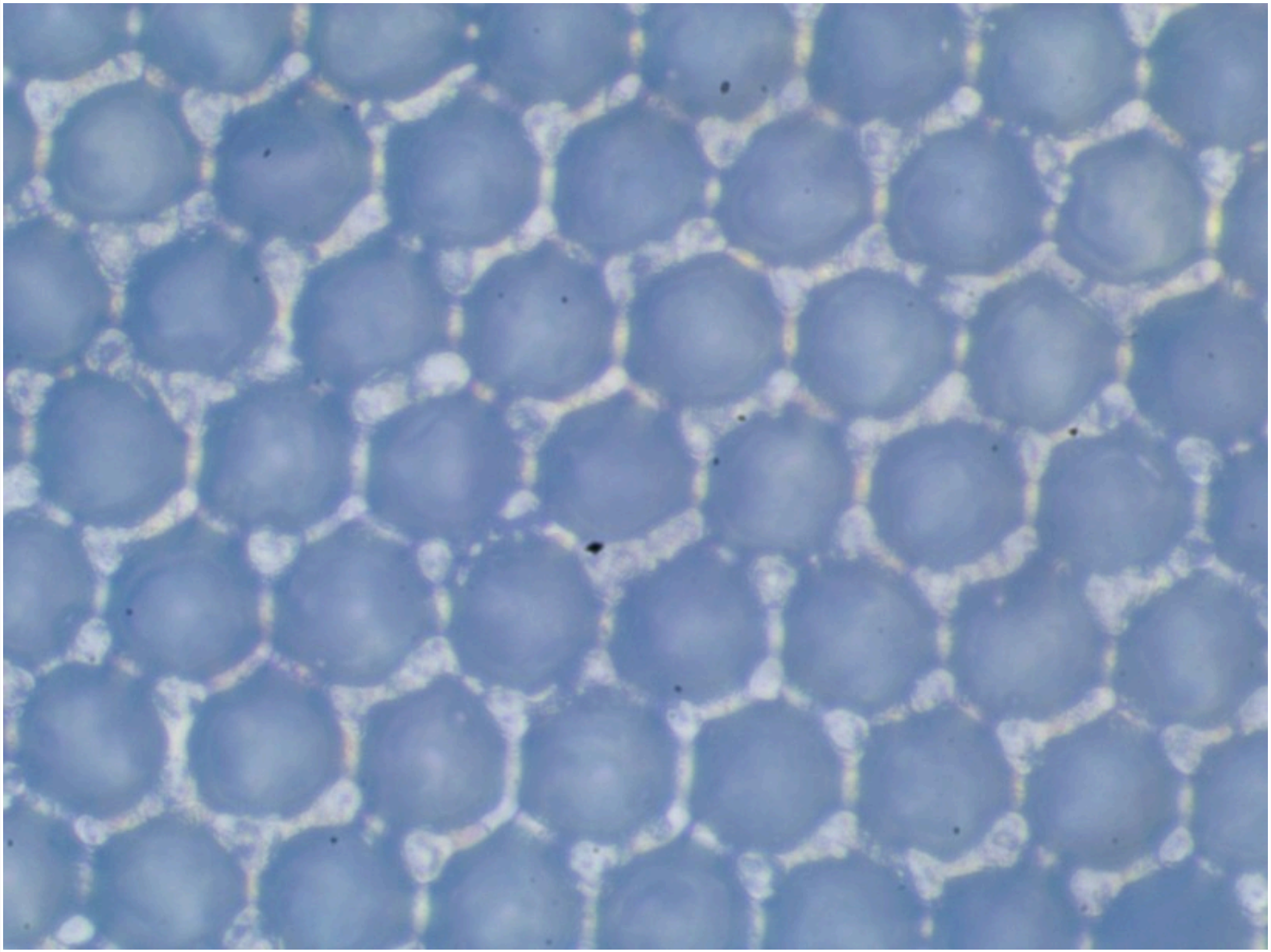
LEC measurements by Troika:

Measured line screen	340	lpcm
Vol	4.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 14.55%

Bridge / Cell: 1 / 9
Depth before / after: 15 / 15 µm
Depth decreased by: 0%

Comment
streak at edge.



Page №129. Roll "s2401658". Length: 1320 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "s2401658".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

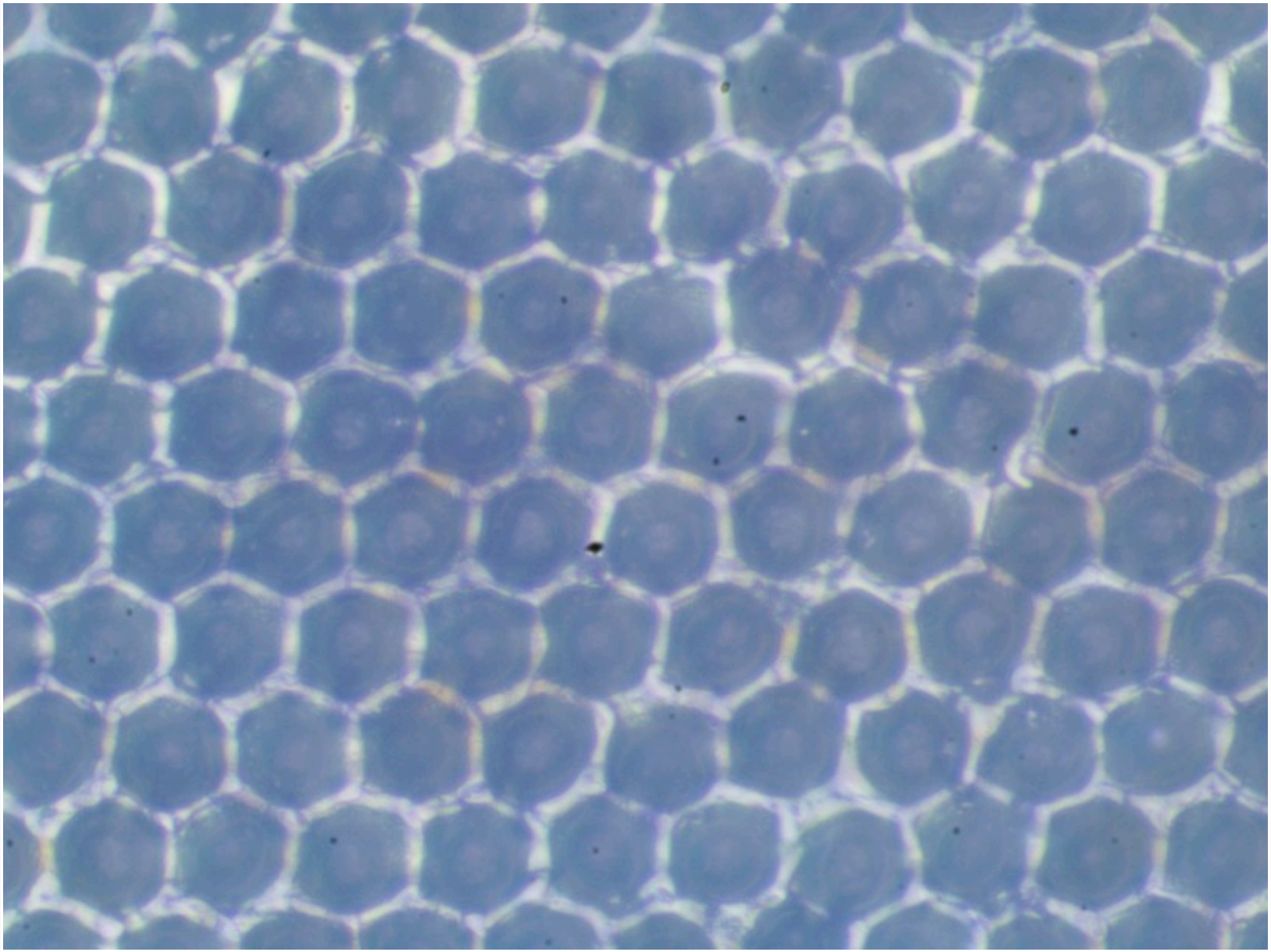
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 7.89%

Bridge / Cell: 1 / 6
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment
streaks.
Roll is worn.



Page №130. Roll "sa008612". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008612".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

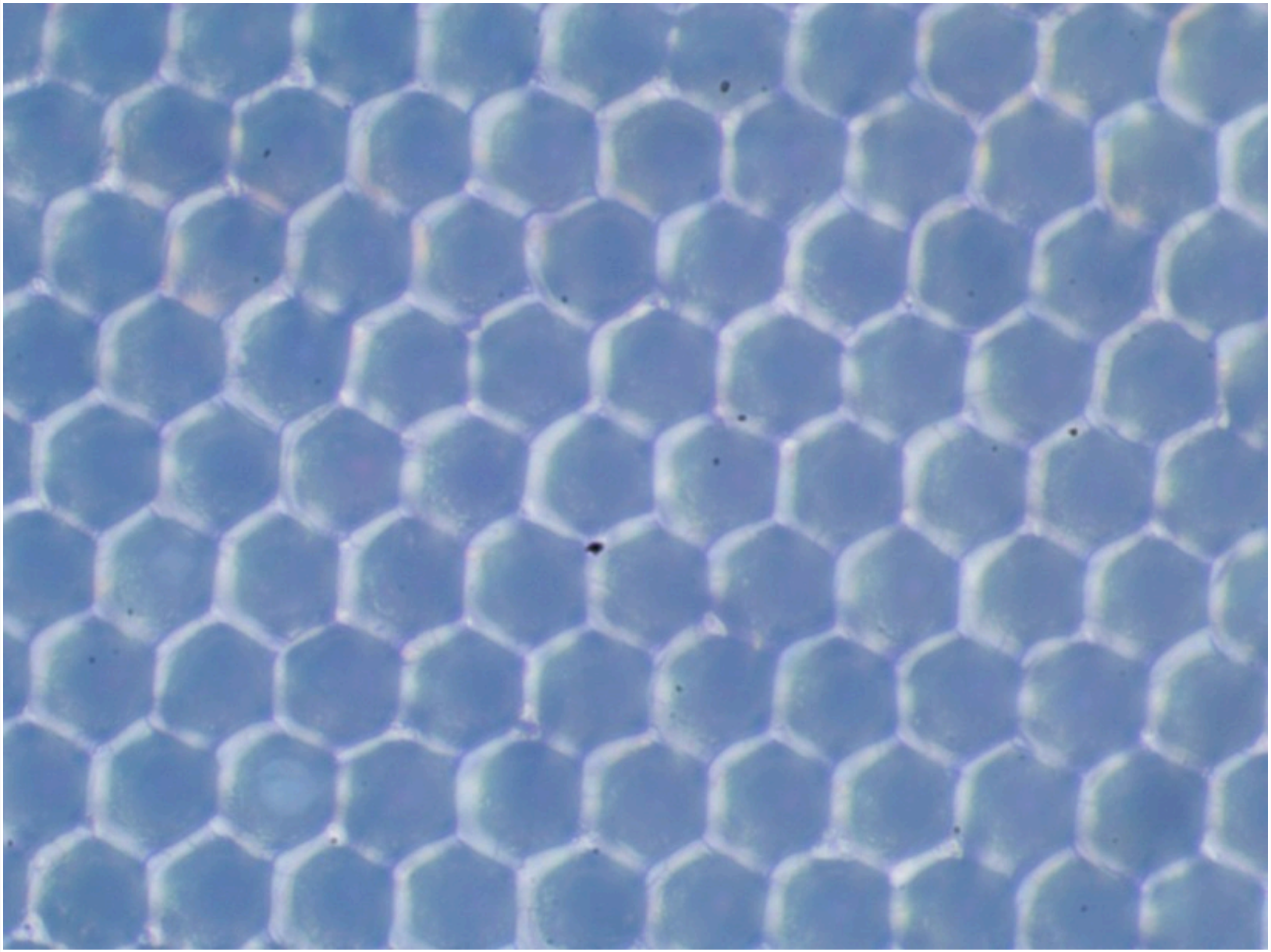
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.80	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 6
Depth before / after: 13 / 13 µm
Depth decreased by: 0%

Comment
Roll is worn.



Page №131. Roll "z16007667". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z16007667".	Photo of the anilox roll surface

Roll designations:

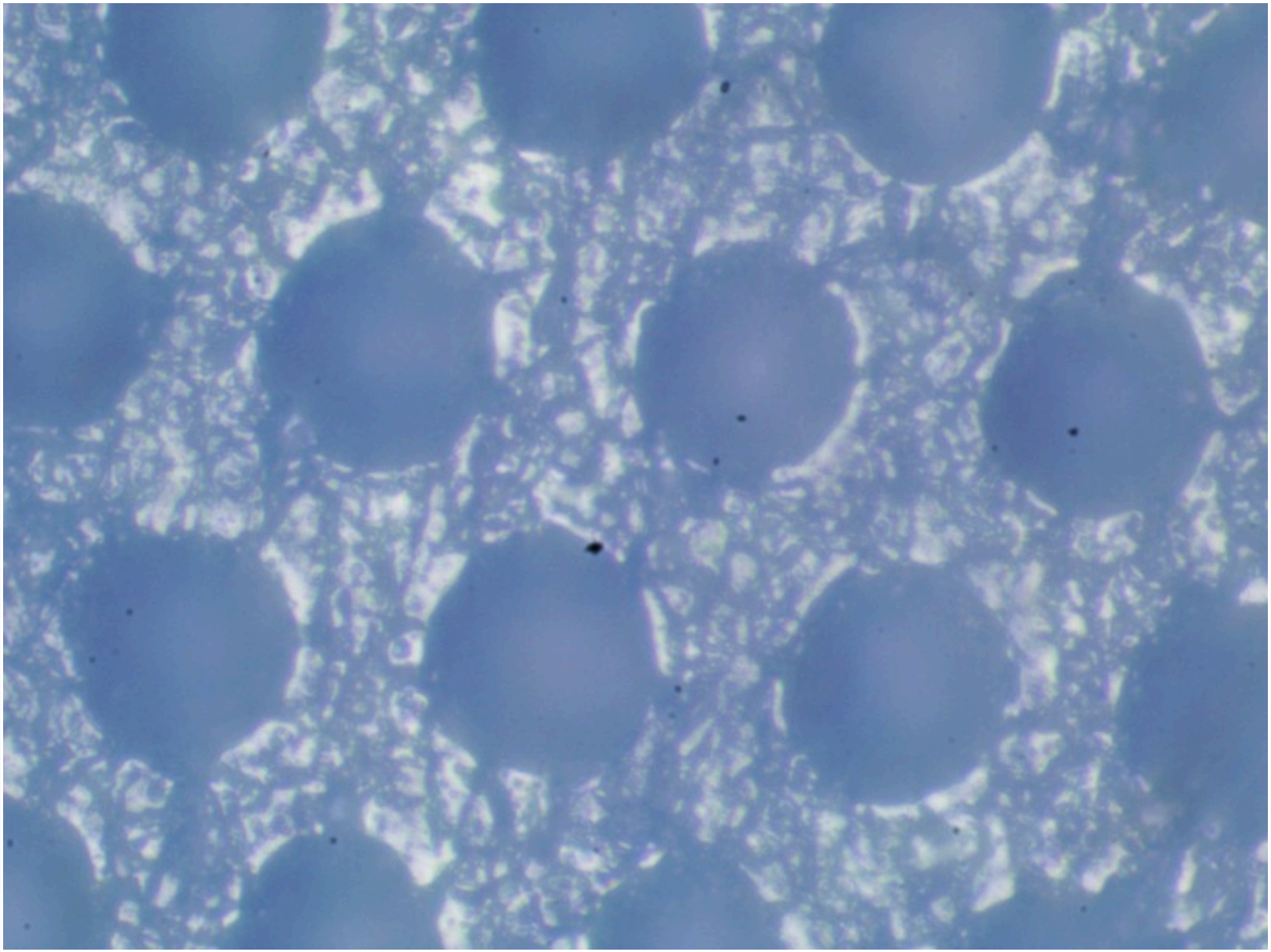
Nominal line screen	160	lpcm
Vol	12.2	cm^3/m^2

LEC measurements by Troika:

Measured line screen	170	lpcm
Vol	3.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 69.67%

Bridge / Cell: 1 / 2
Depth before / after: 20 / 20 µm
Depth decreased by: 0%



Comment
worn.
Roll is heavily worn.

Page №132. Roll "z16007650". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z16007650".	Photo of the anilox roll surface

Roll designations:

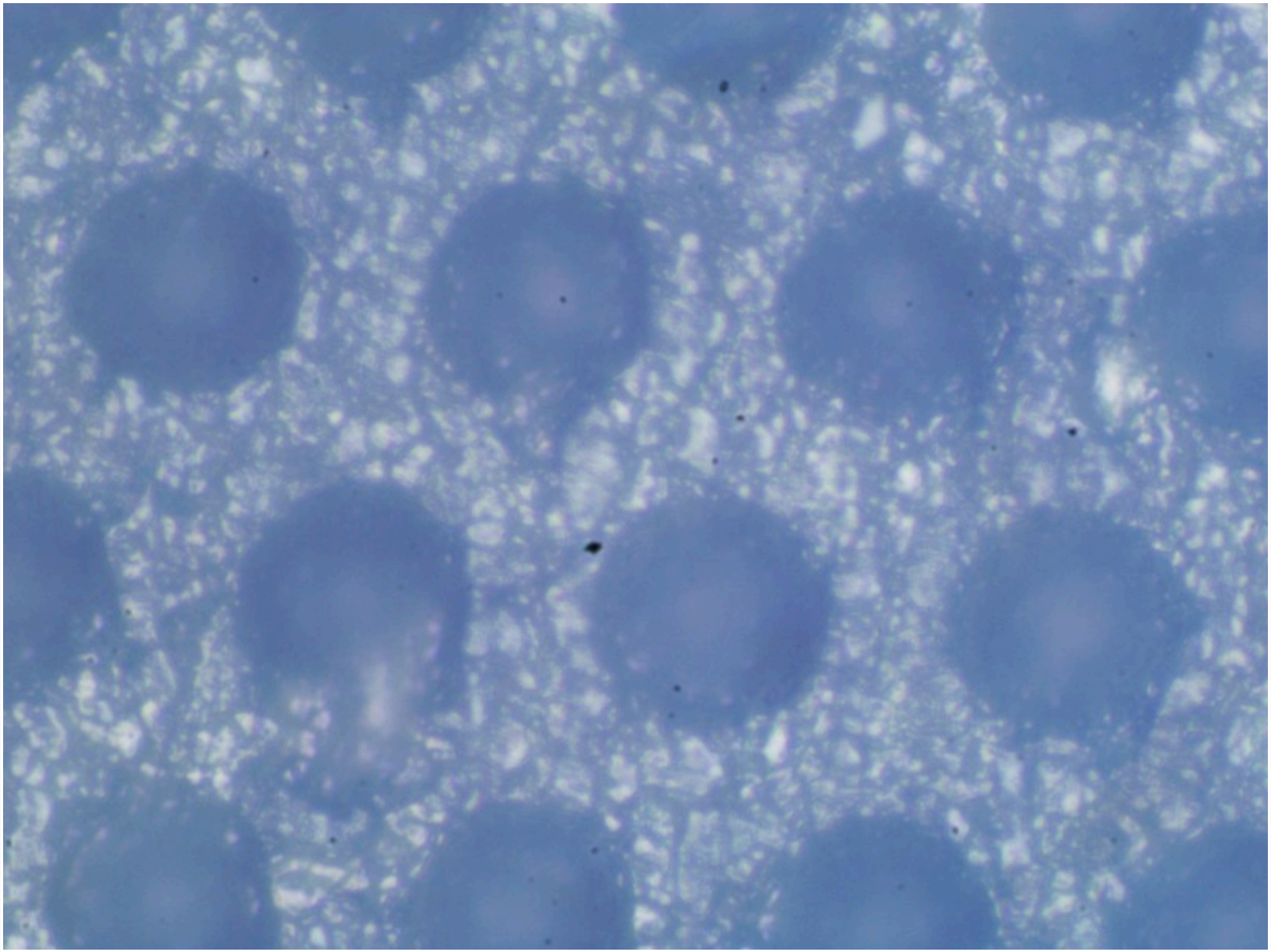
Nominal line screen	160	lpcm
Vol	12.3	cm^3/m^2

LEC measurements by Troika:

Measured line screen	160	lpcm
Vol	3.10	cm^3/m^2

Ink transfer volume decrease from the nominal value: 74.8%

Bridge / Cell: 1 / 2
Depth before / after: 17 / 17 µm
Depth decreased by: 0%



Comment
worn streaks.
Roll is heavily worn.

Page №133. Roll "sg49046-15". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-15".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	300	lpcm
Vol	6.5	cm^3/m^2

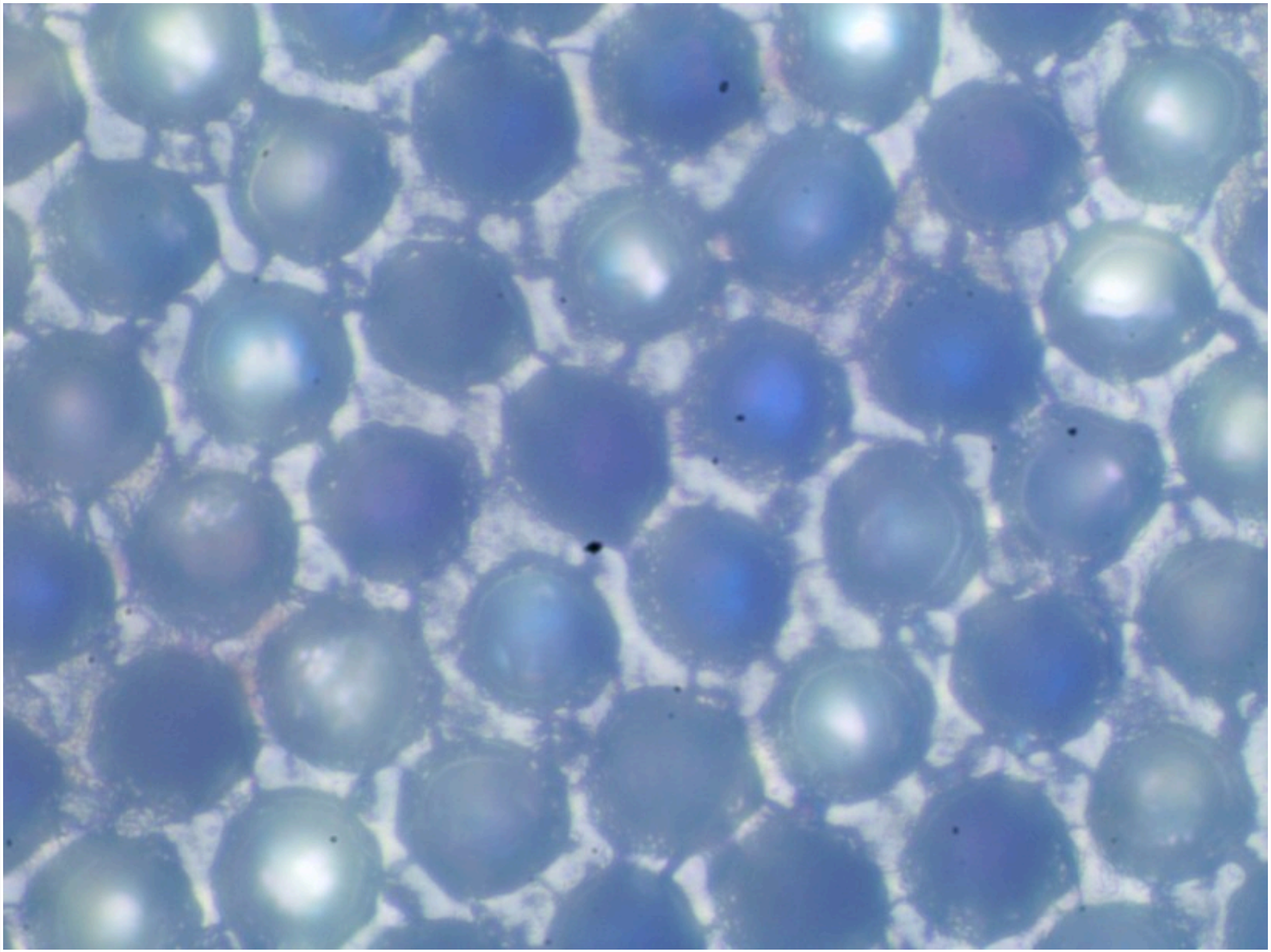
LEC measurements by Troika:

Measured line screen	300	lpcm
Vol	5.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 15.38%

Bridge / Cell: 1 / 10
Depth before / after: 17 / 17 µm
Depth decreased by: 0%

Comment
streaks streak 123.



Page №134. Roll "sg49046-25". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-25".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

LEC measurements by Troika:

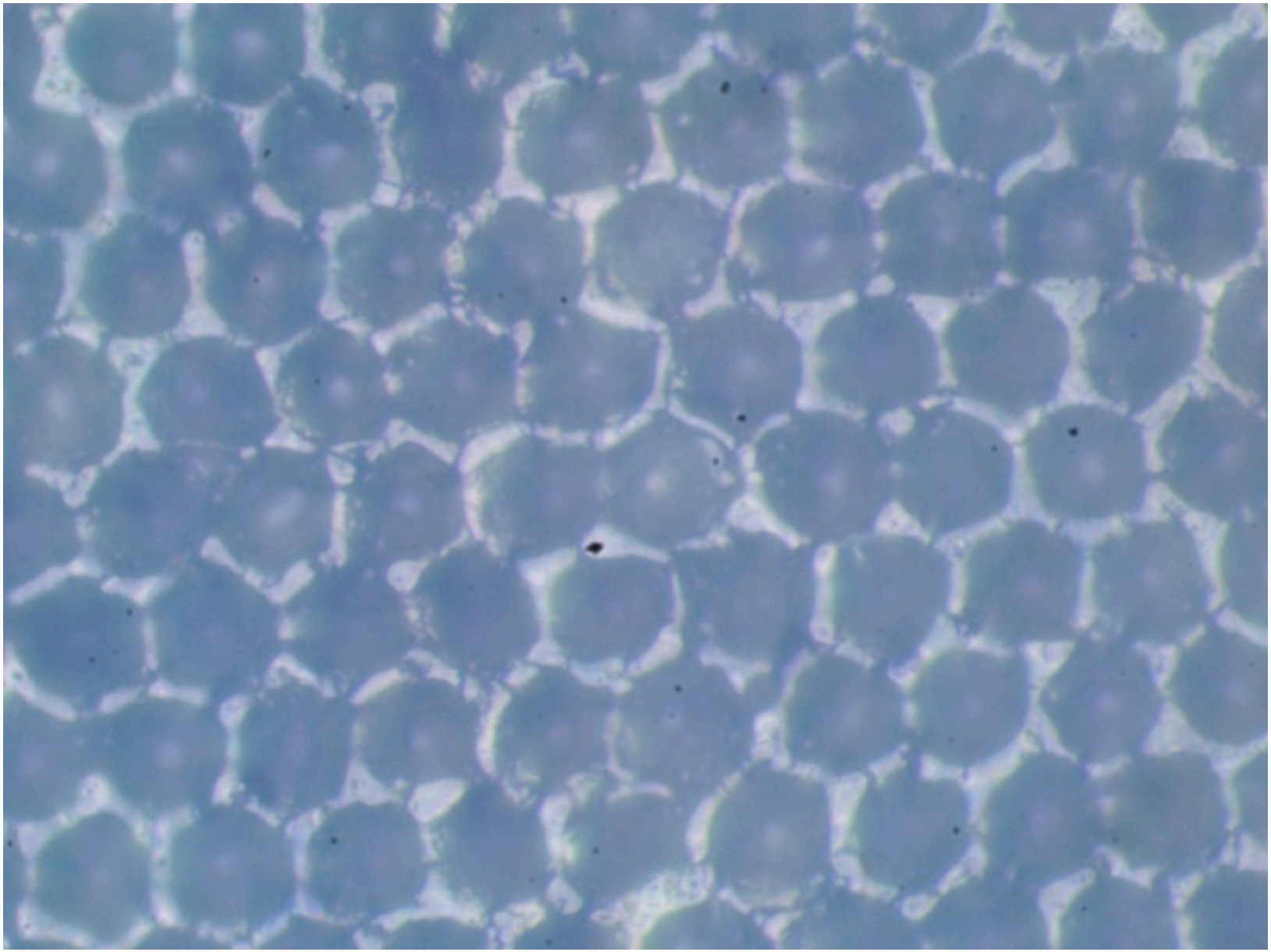
Measured line screen	420	lpcm
Vol	4.00	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 7
Depth before / after: 13 / 13 µm
Depth decreased by: 0%

Comment

.
Roll is slightly worn.



Page №135. Roll "sg49046-27". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-27".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

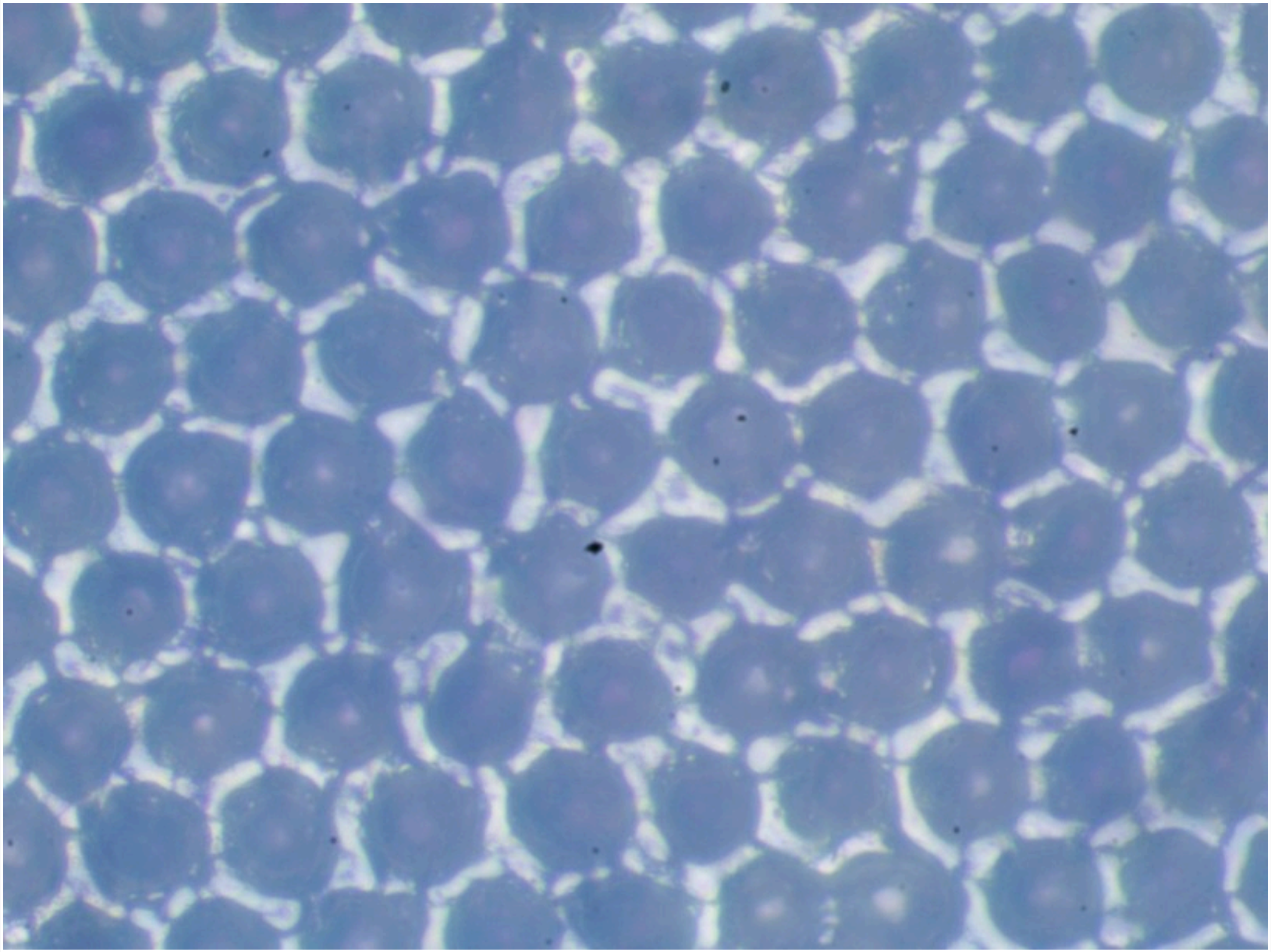
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	3.60	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10%

Bridge / Cell: 1 / 7
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment
chips at edges.
Roll is slightly worn.



Page №136. Roll "sg49046-3". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-3".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	130	lpcm
Vol	12.0	cm^3/m^2

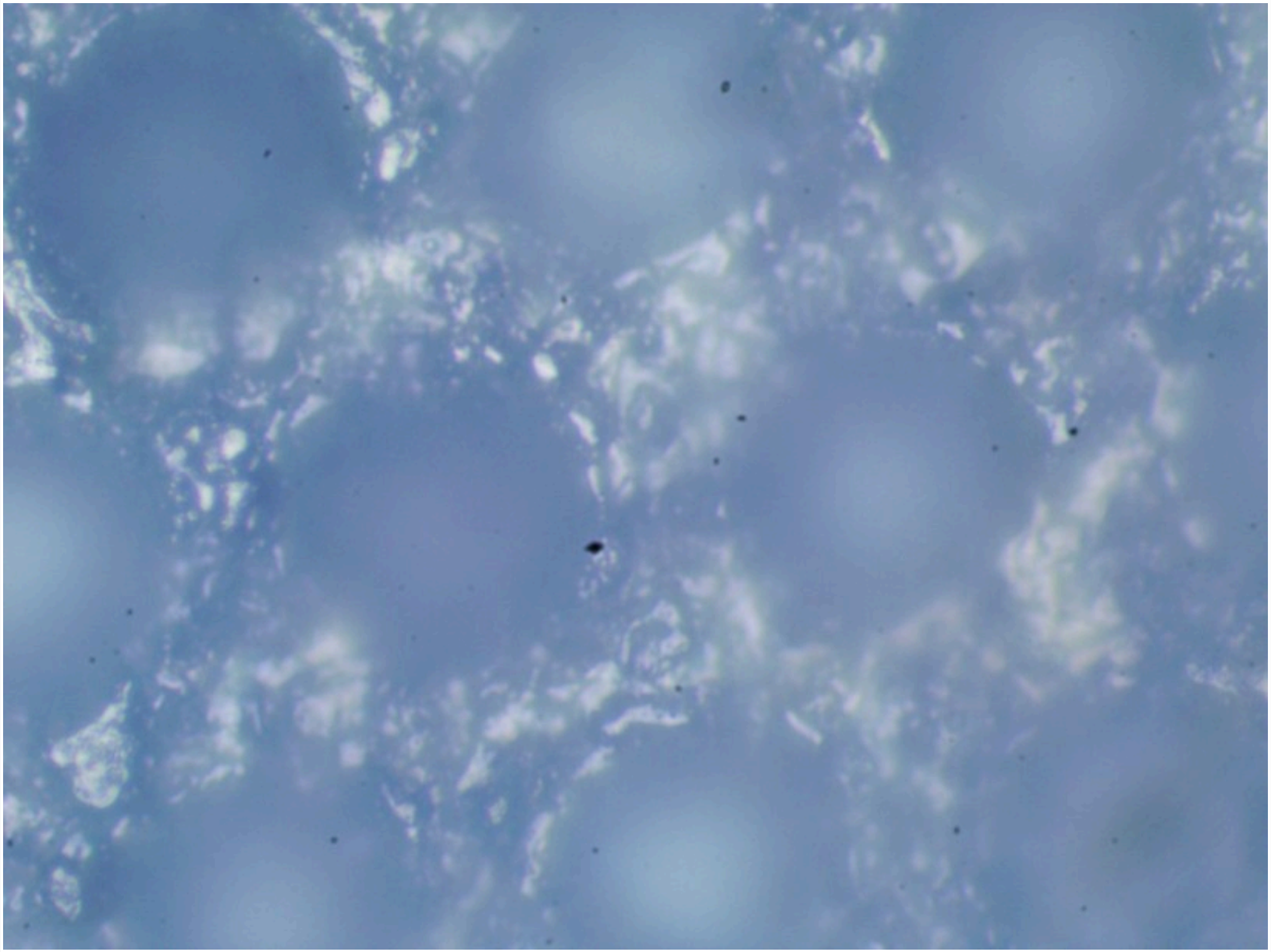
LEC measurements by Troika:

Measured line screen	130	lpcm
Vol	5.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 51.67%

Bridge / Cell: 1 / 3
Depth before / after: 27 / 27 µm
Depth decreased by: 0%

Comment
cell walls are damaged streaks.
Roll is heavily worn.



Page №137. Roll "sg49046-6". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-6".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	10.0	cm^3/m^2

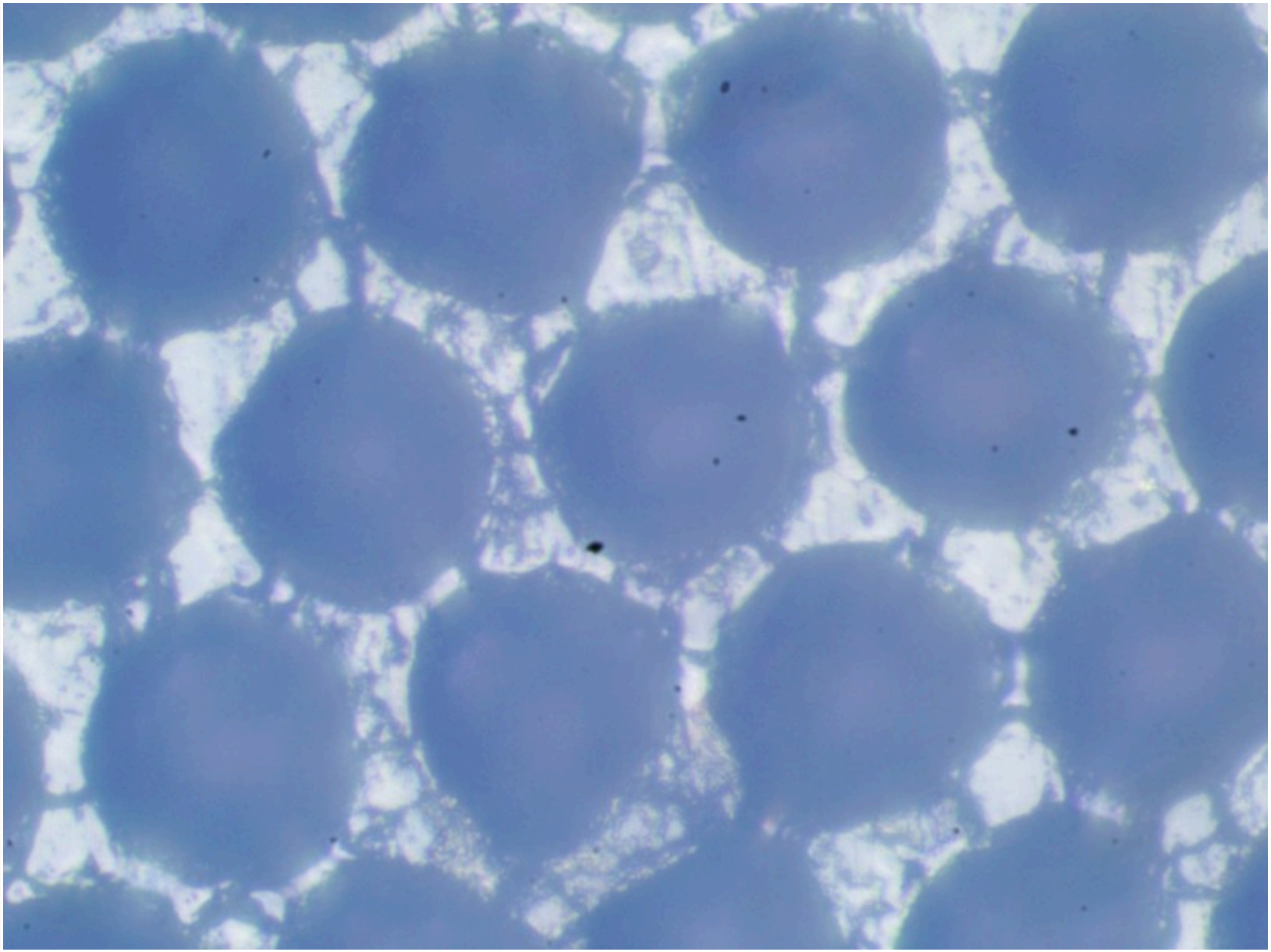
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	7.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 28%

Bridge / Cell: 1 / 10
Depth before / after: 22 / 22 µm
Depth decreased by: 0%

Comment
dents 34 scratch 460 chips at edges.



Page №138. Roll "sg49046-4". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-4".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	160	lpcm
Vol	11.0	cm^3/m^2

LEC measurements by Troika:

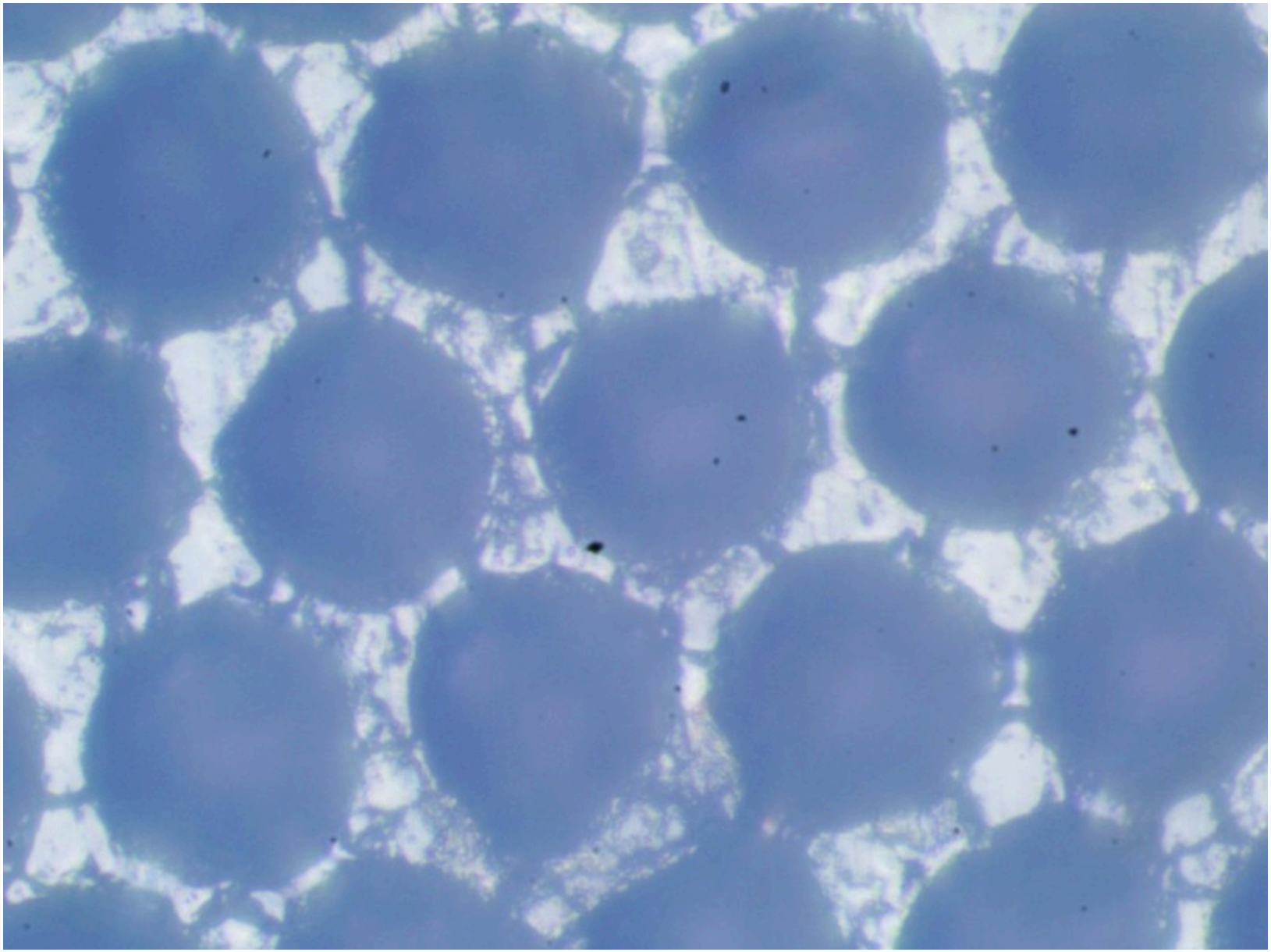
Measured line screen	160	lpcm
Vol	8.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 23.64%

Bridge / Cell: 1 / 8
Depth before / after: 27 / 27 µm
Depth decreased by: 0%

Comment
streaks 295 564 spot 1180 scratch 28.

Roll is slightly worn.



Page №139. Roll "sg49046-1". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-1".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	130	lpcm
Vol	12.0	cm^3/m^2

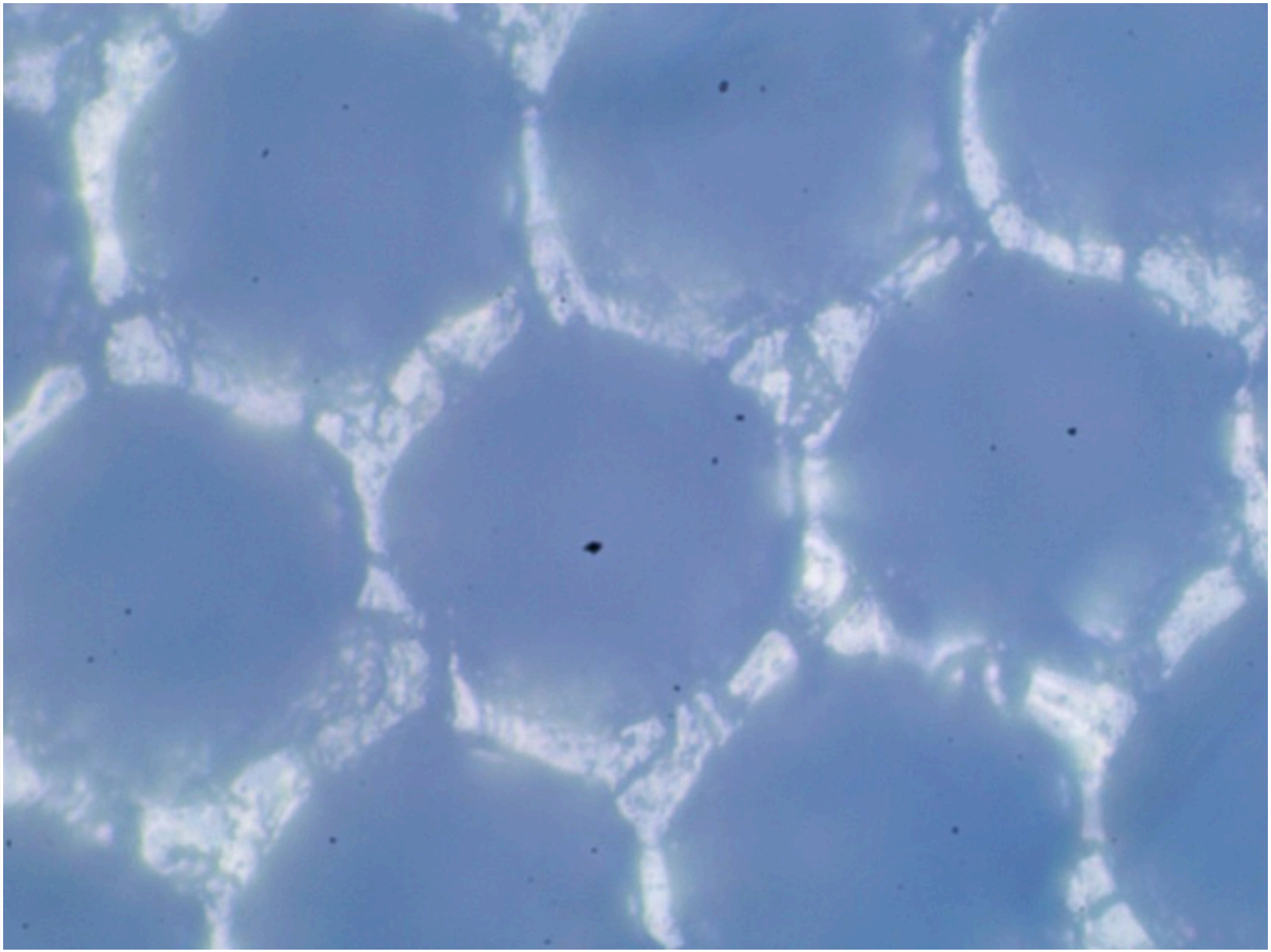
LEC measurements by Troika:

Measured line screen	130	lpcm
Vol	9.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 18.33%

Bridge / Cell: 1 / 24
Depth before / after: 27 / 27 µm
Depth decreased by: 0%

Comment
not worn, no visible damage.



Page №140. Roll "z48064". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z48064".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	8.8	cm^3/m^2

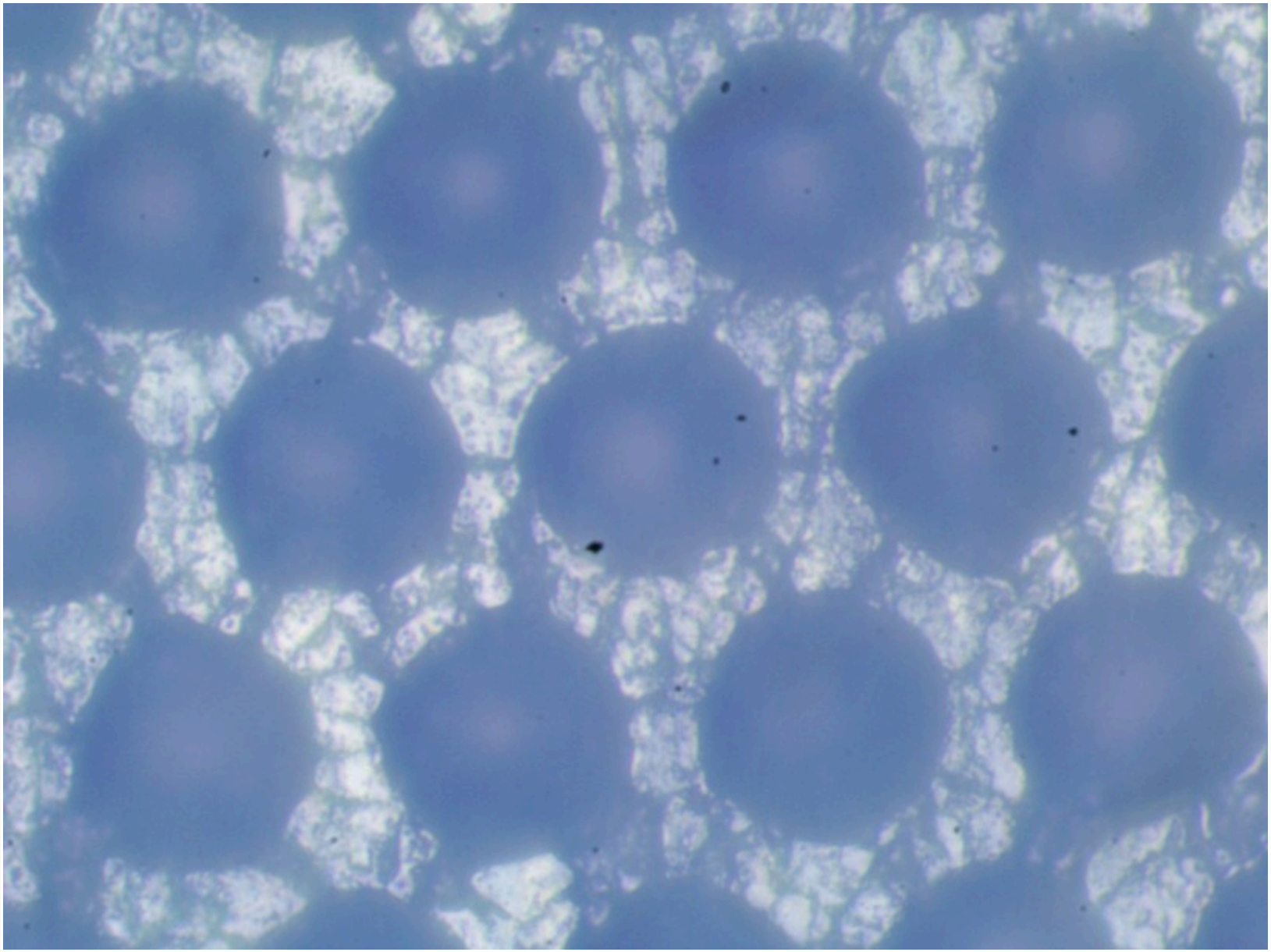
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	5.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 40.91%

Bridge / Cell: 1 / 6
Depth before / after: 18 / 18 µm
Depth decreased by: 0%

Comment
edge chips worn dent 190
248.
Roll is worn.



Page №141. Roll "sg49046-19". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-19".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	380	lpcm
Vol	5.0	cm^3/m^2

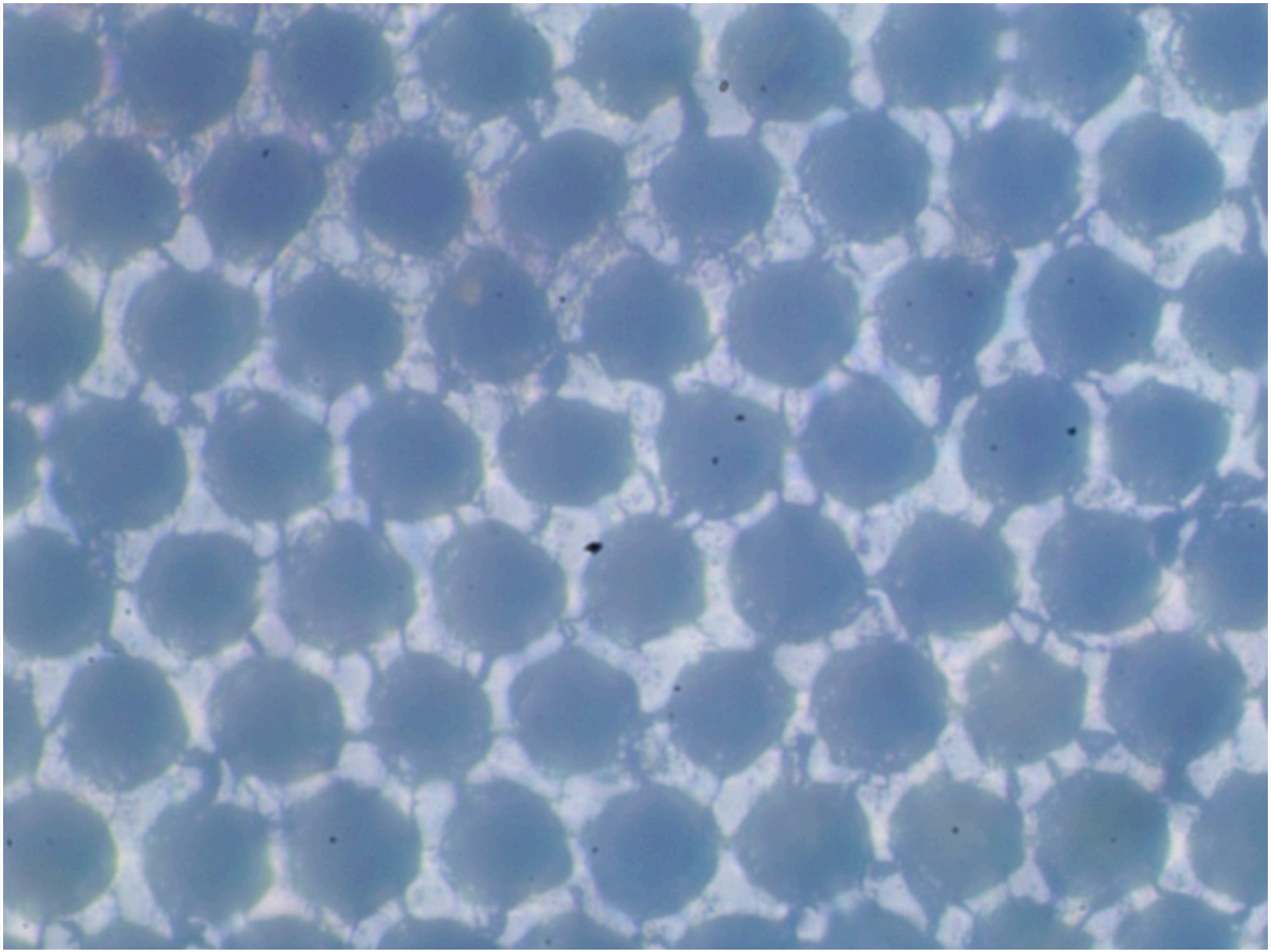
LEC measurements by Troika:

Measured line screen	380	lpcm
Vol	5.00	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 12
Depth before / after: 15 / 15 µm
Depth decreased by: 0%

Comment
streak 1135 64.



Page №142. Roll "z56917". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z56917".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.9	cm^3/m^2

LEC measurements by Troika:

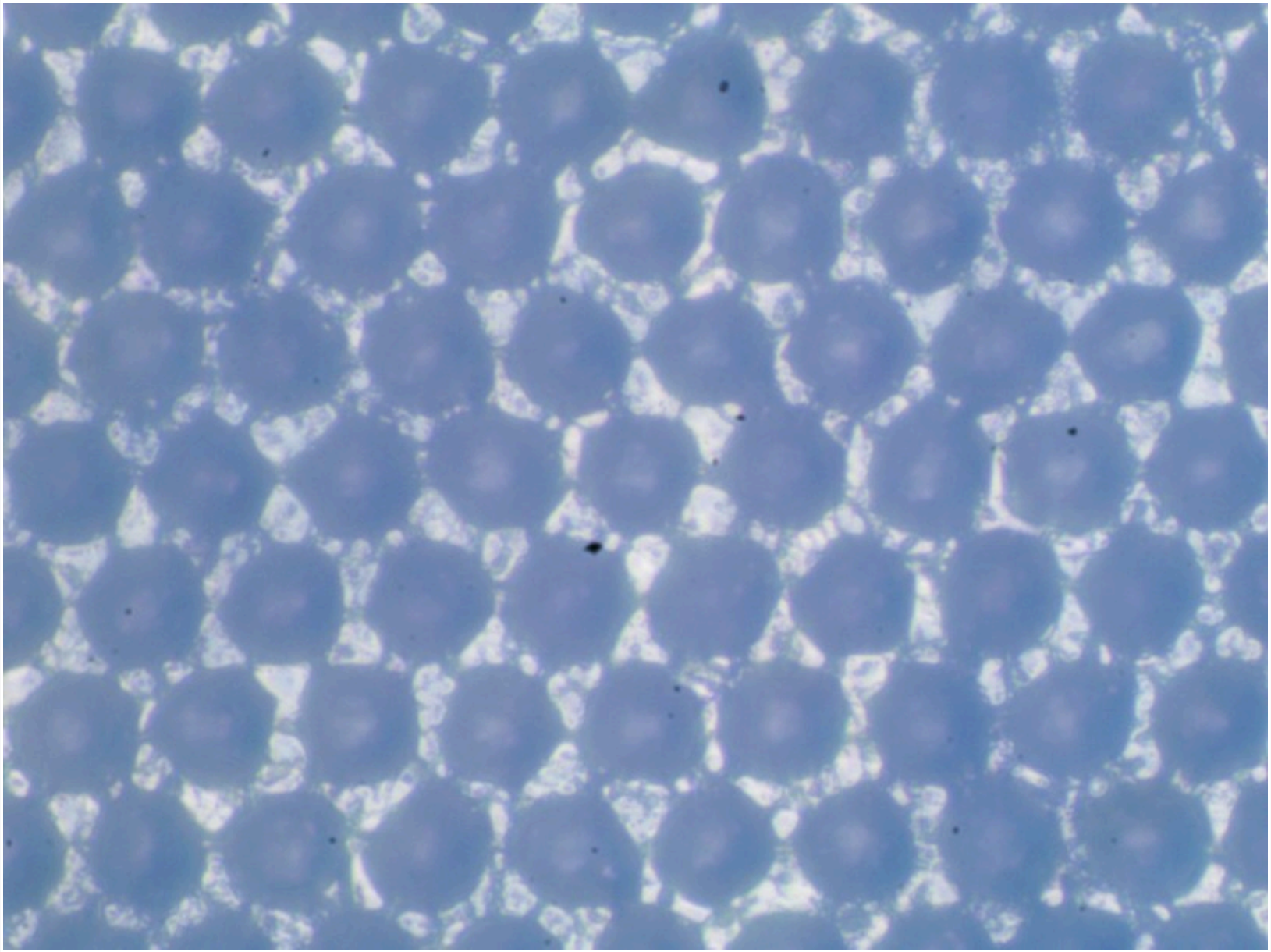
Measured line screen	420	lpcm
Vol	3.90	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 5
Depth before / after: 14 / 14 µm
Depth decreased by: 0%

Comment
chips at edges streaks streak 345 795 spot 85.

Roll is worn.



Page №143. Roll "z48069". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z48069".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	7.4	cm^3/m^2

LEC measurements by Troika:

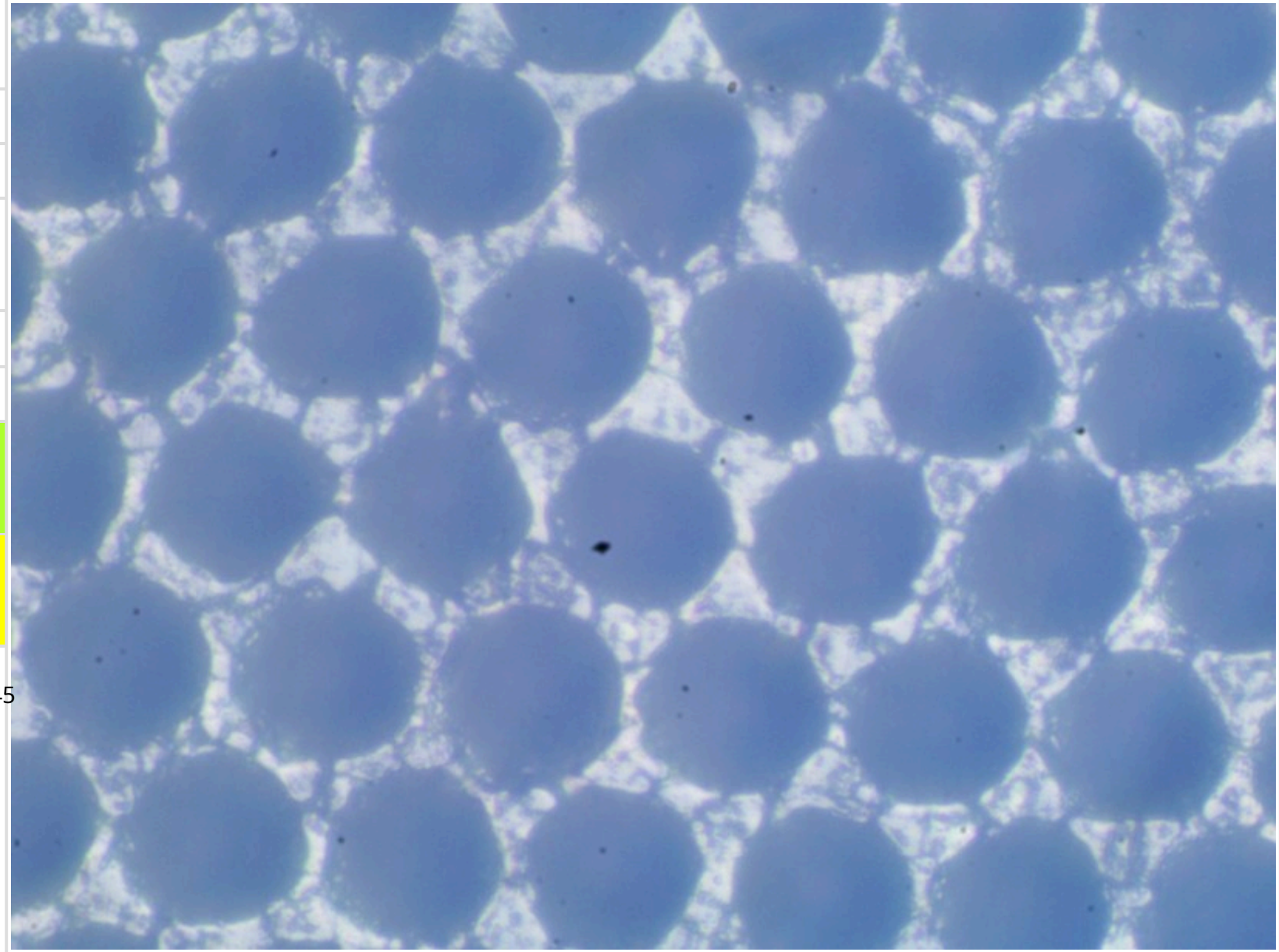
Measured line screen	280	lpcm
Vol	6.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 8.11%

Bridge / Cell: 1 / 8
Depth before / after: 22 / 22 µm
Depth decreased by: 0%

Comment
dent 390 415 445 460 490 320 330 345 365 770 streak 275 chips at edges.

Roll is slightly worn.



Page №144. Roll "17011018". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "17011018".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	8.5	cm^3/m^2

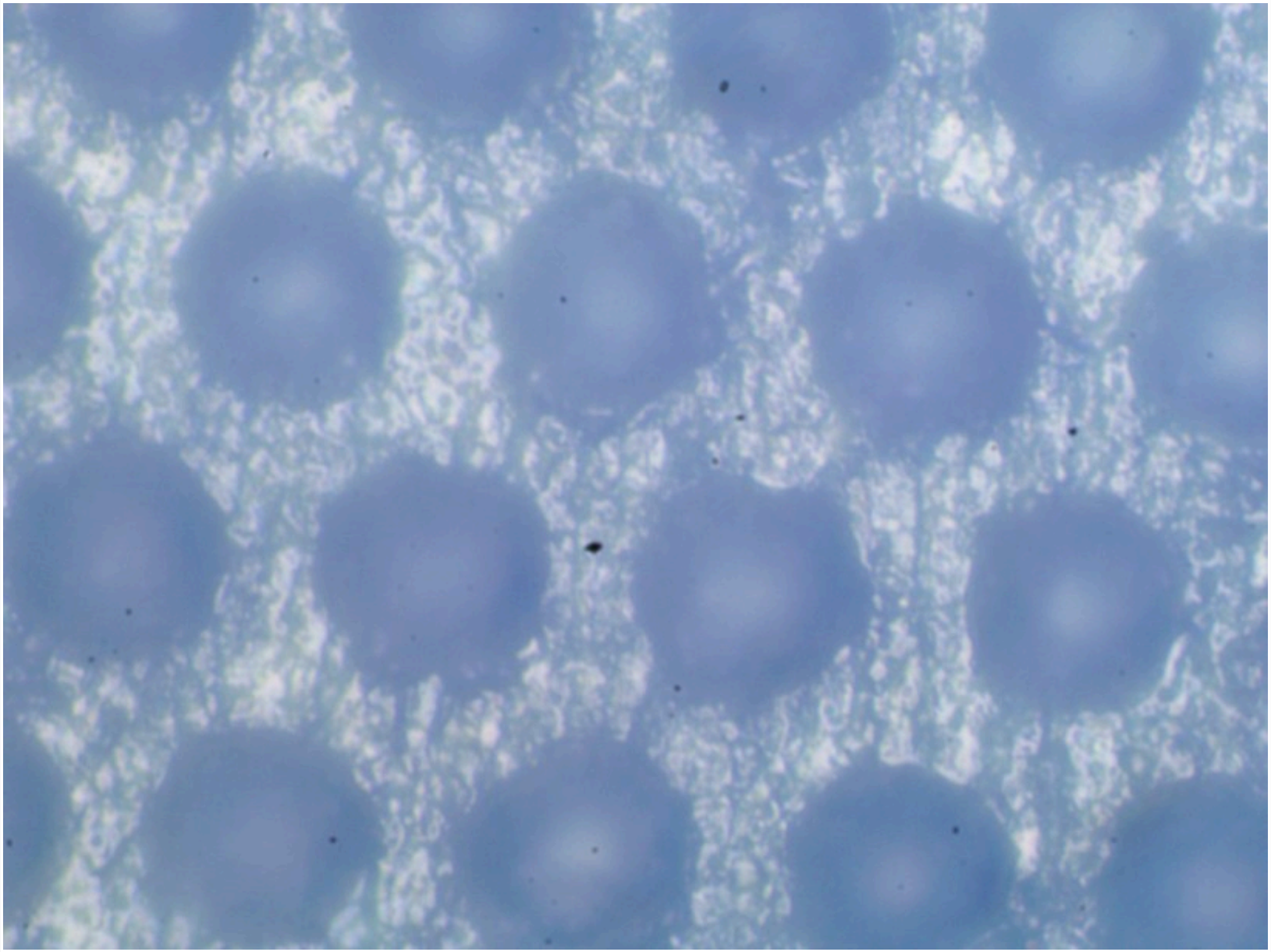
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	3.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 55.29%

Bridge / Cell: 1 / 3
Depth before / after: 17 / 17 µm
Depth decreased by: 0%

Comment
worn scratch 1240 spots
1280.
Roll is heavily worn.



Page №145. Roll "z17011031". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011031".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	6.9	cm^3/m^2

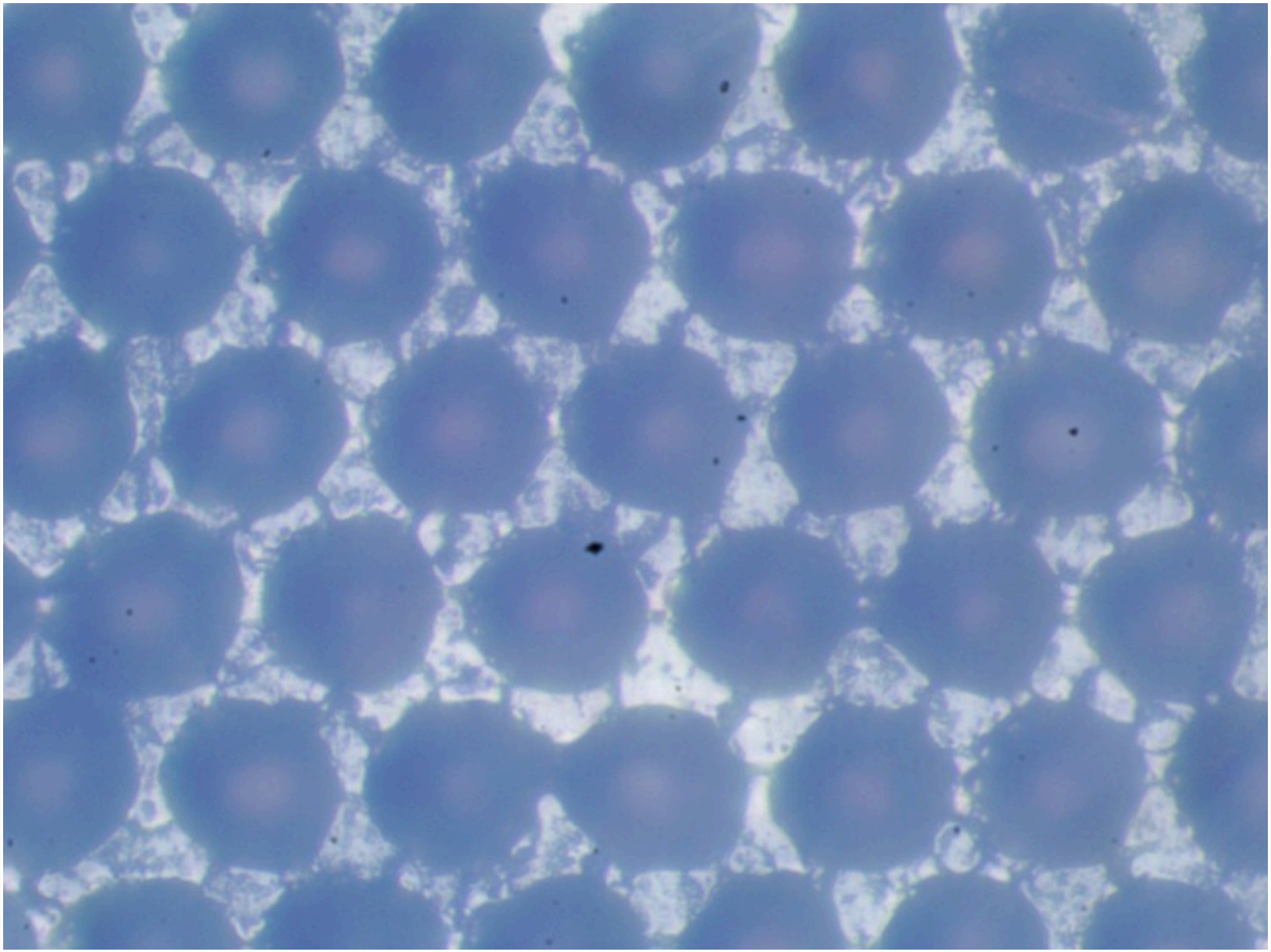
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	5.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 21.74%

Bridge / Cell: 1 / 6
Depth before / after: 19 / 19 µm
Depth decreased by: 0%

Comment
dents 155 180 220.
Roll is worn.



Page №146. Roll "z17011013". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011013".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.7	cm^3/m^2

LEC measurements by Troika:

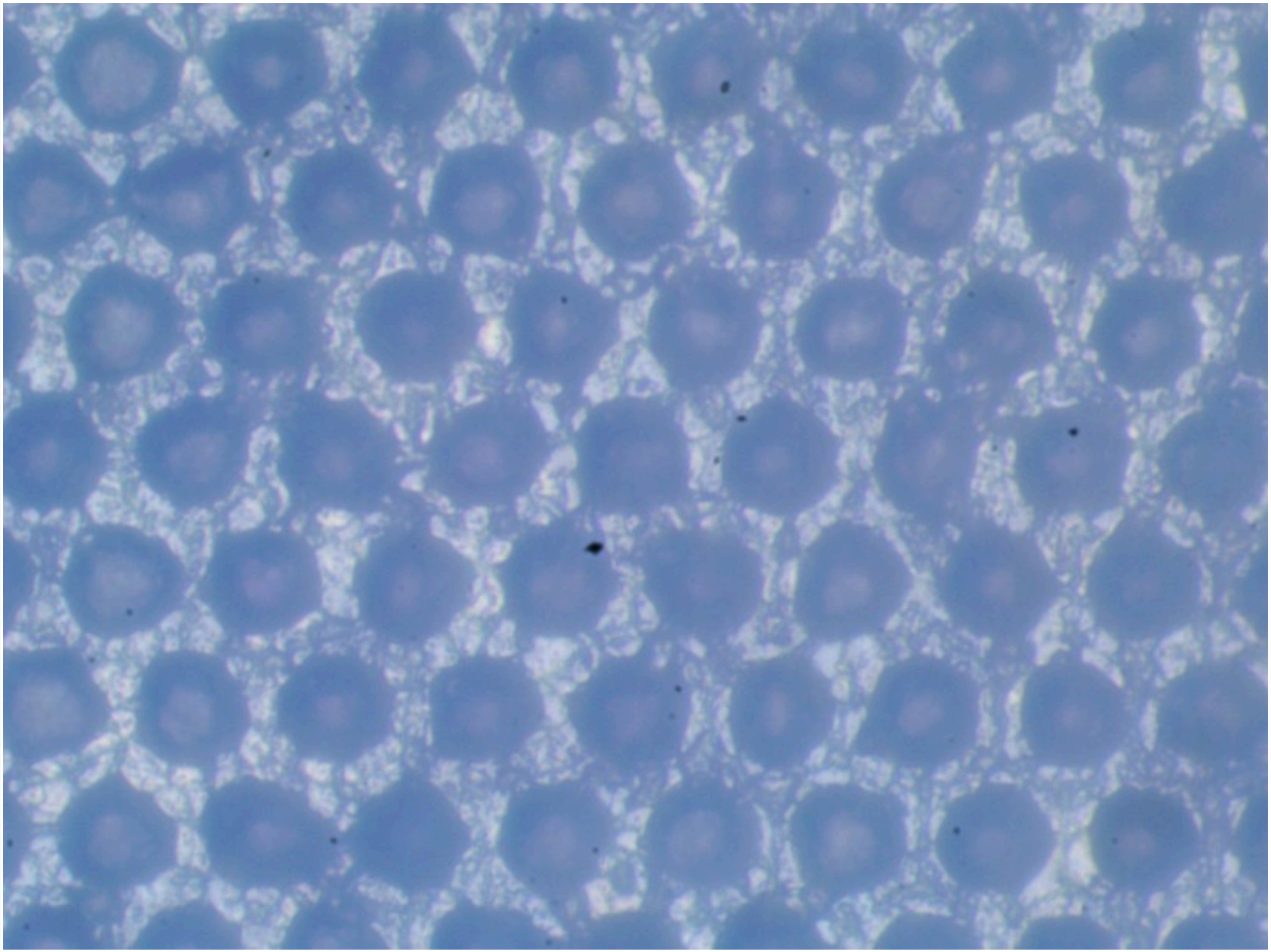
Measured line screen	400	lpcm
Vol	2.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 32.43%

Bridge / Cell: 1 / 4
Depth before / after: 10 / 10 µm
Depth decreased by: 0%

Comment
dents 370 340 scratch 45 spots.

Roll is worn.



Page №147. Roll "z48065". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z48065".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	8.8	cm^3/m^2

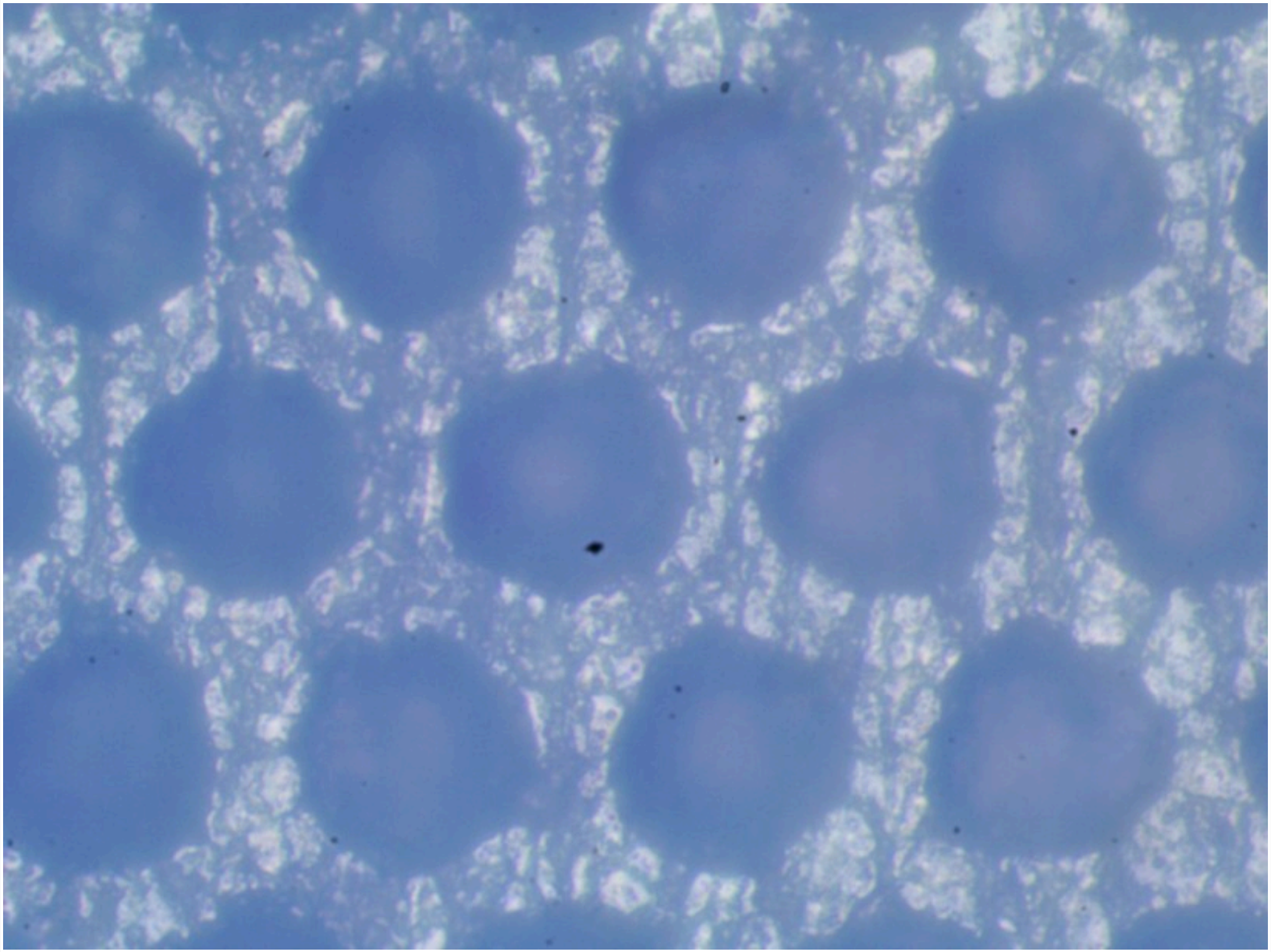
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	2.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 73.86%

Bridge / Cell: 1 / 3
Depth before / after: 11 / 11 µm
Depth decreased by: 0%

Comment
scratch 72 spots.
Roll is heavily worn.



Page №148. Roll "sg4904610". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg4904610".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	240	lpcm
Vol	8.5	cm^3/m^2

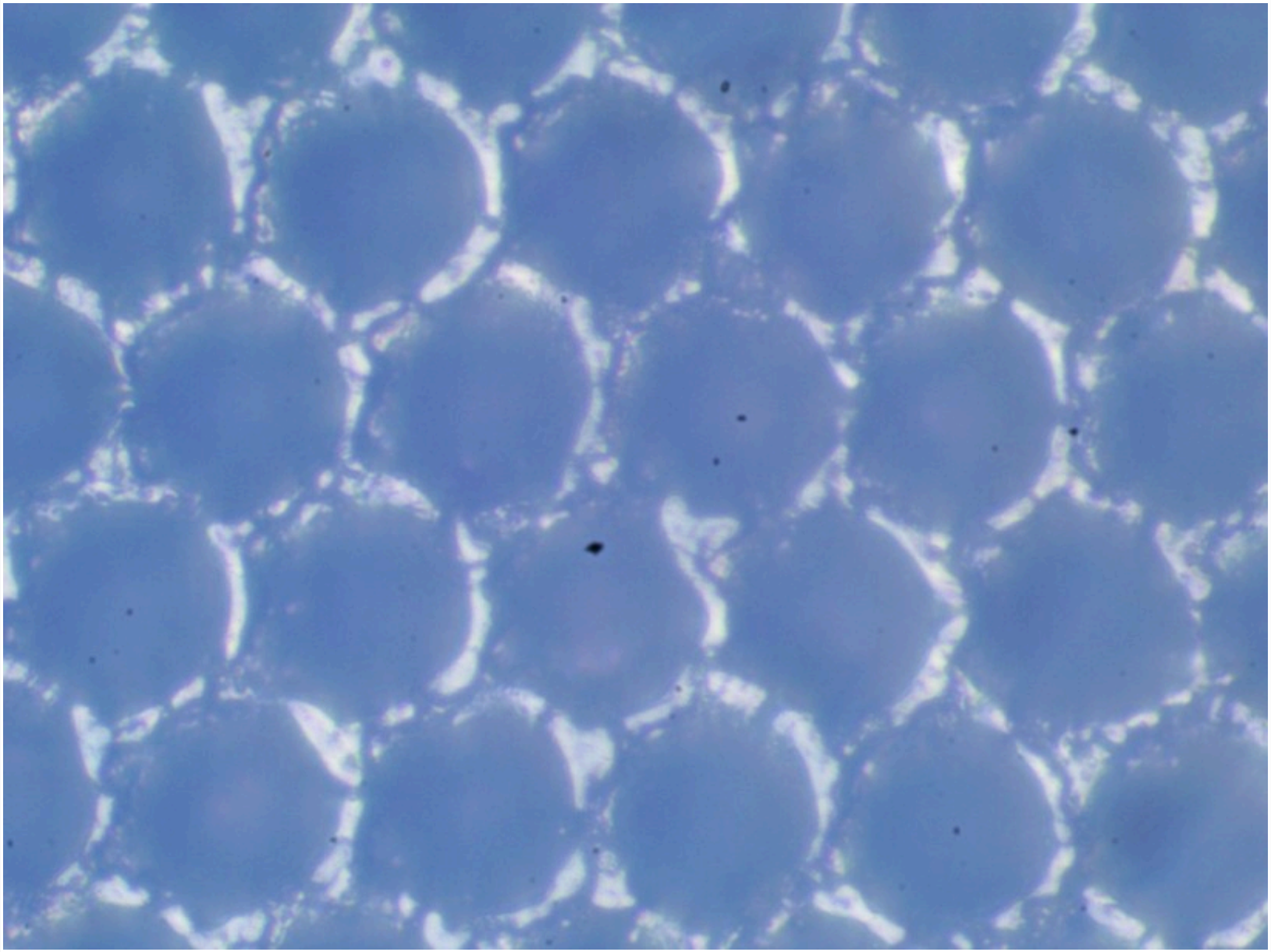
LEC measurements by Troika:

Measured line screen	240	lpcm
Vol	8.50	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 13
Depth before / after: 25 / 25 µm
Depth decreased by: 0%

Comment



Page №149. Roll "h100748-6". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100748-6".	Photo of the anilox roll surface

Roll designations:

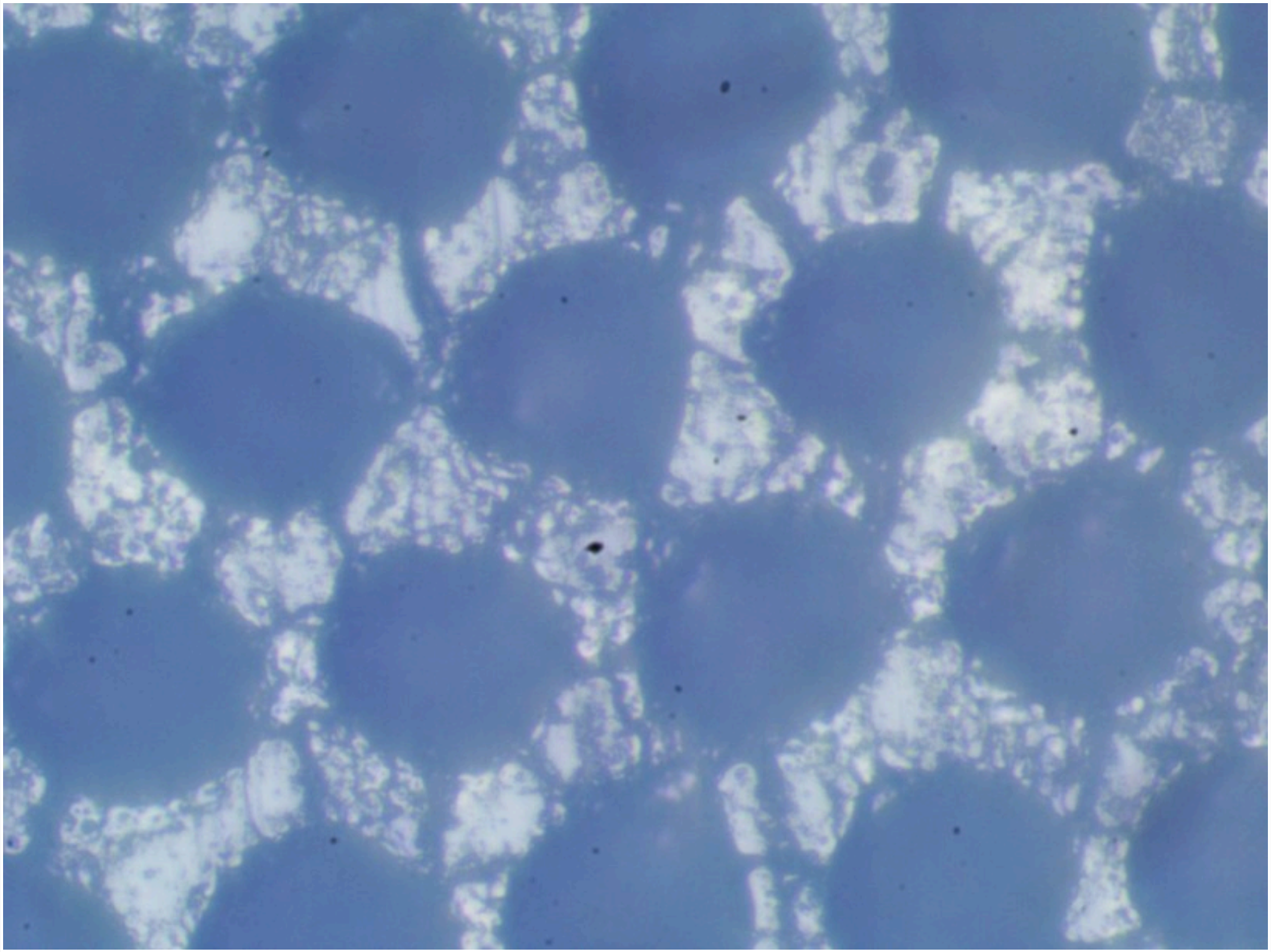
Nominal line screen	180	lpcm
Vol	9.5	cm^3/m^2

LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	3.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 65.26%

Bridge / Cell: 1 / 3
Depth before / after: 16 / 16 µm
Depth decreased by: 0%



Comment
worn streaks.
Roll is heavily worn.

Page №150. Roll "z17011040". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011040".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.6	cm^3/m^2

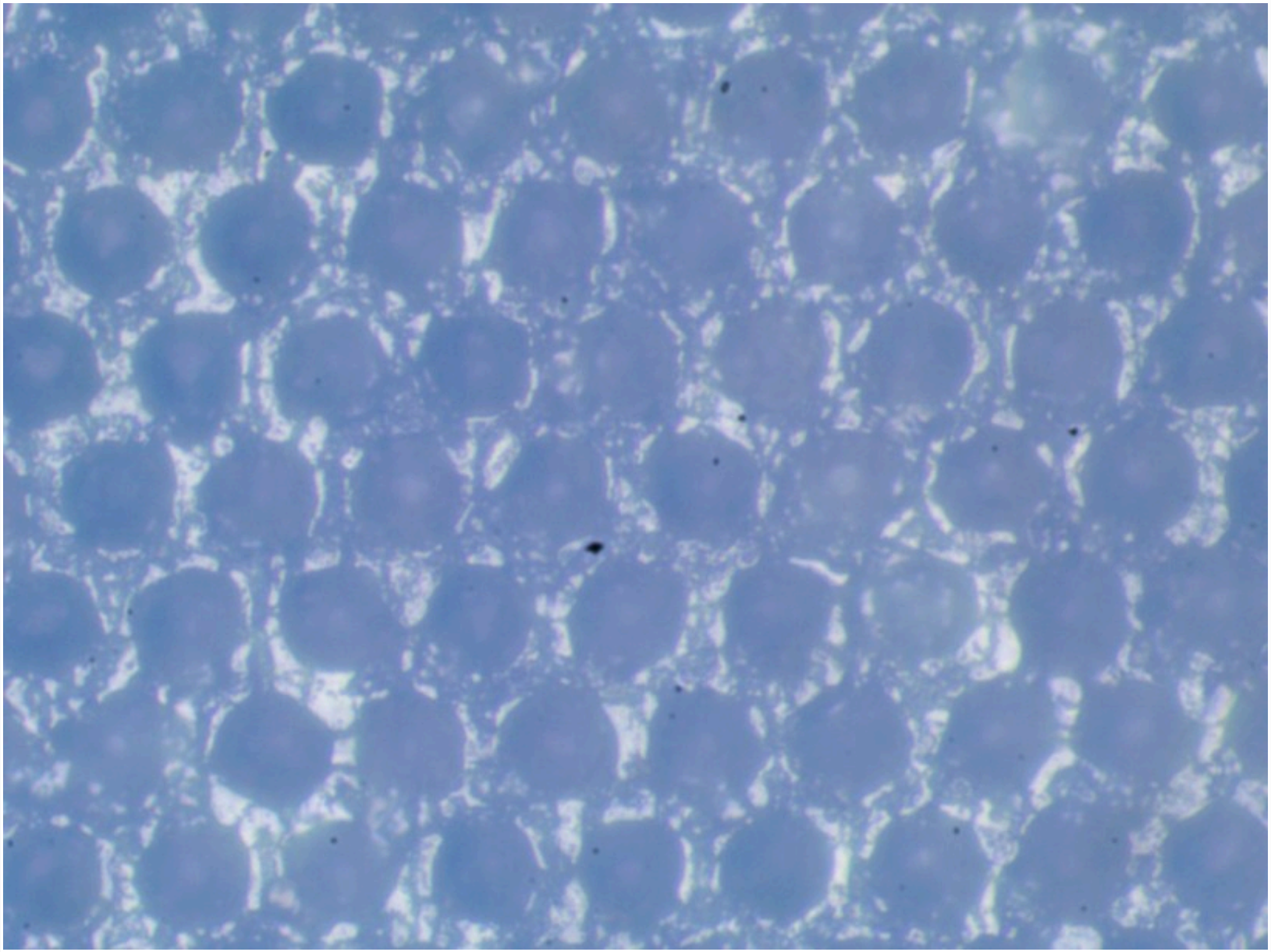
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	2.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 38.89%

Bridge / Cell: 1 / 3
Depth before / after: 10 / 10 µm
Depth decreased by: 0%

Comment
wear streaks 65 130.
Roll is heavily worn.



Page №151. Roll "aa2413870". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "aa2413870".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	340	lpcm
Vol	5.5	cm^3/m^2

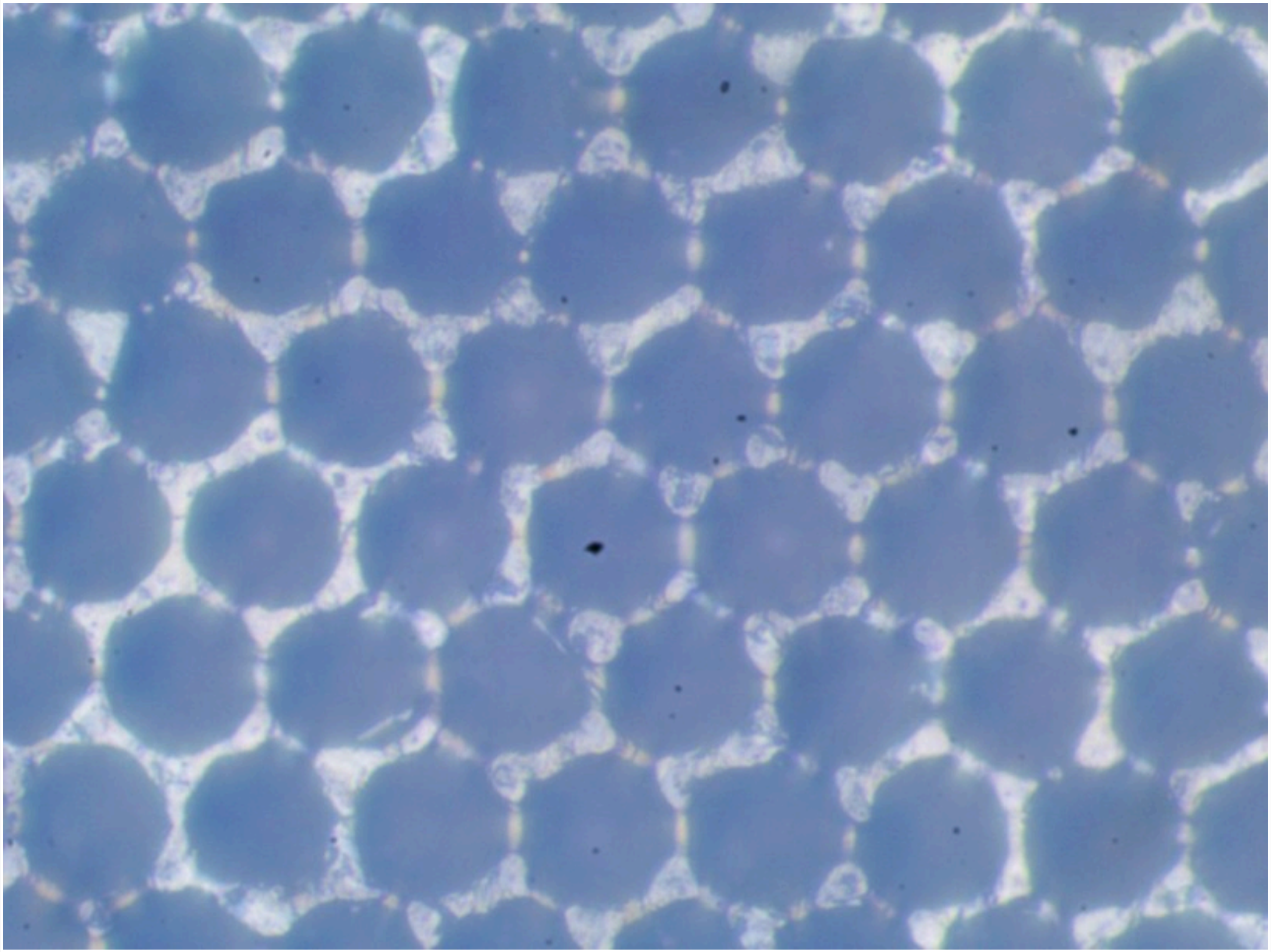
LEC measurements by Troika:

Measured line screen	360	lpcm
Vol	5.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 3.64%

Bridge / Cell: 1 / 8
Depth before / after: 17 / 17 µm
Depth decreased by: 0%

Comment
streak 855.
Roll is slightly worn.



Page №152. Roll "z16007664". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z16007664".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	13.0	cm^3/m^2

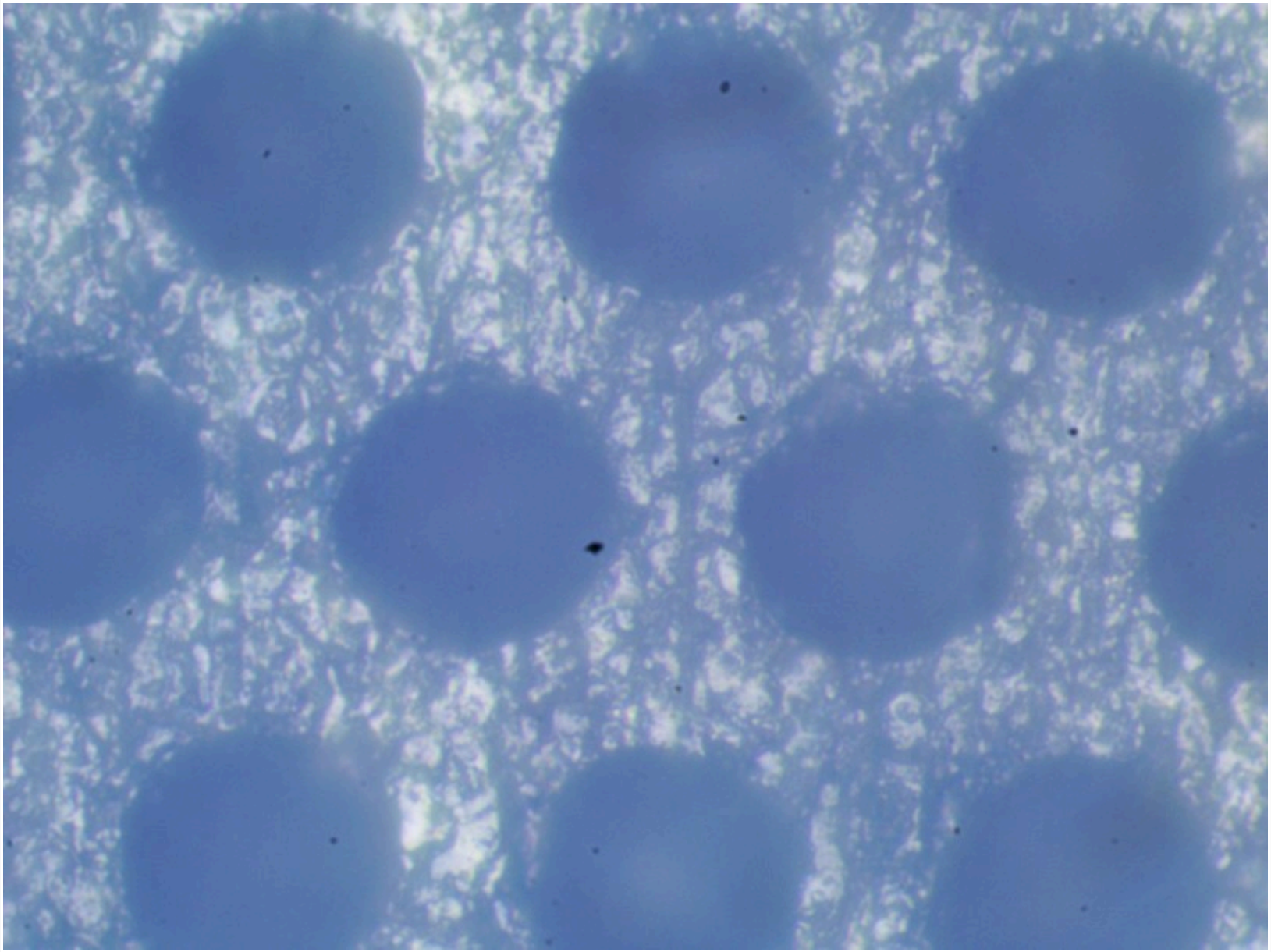
LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	3.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 71.54%

Bridge / Cell: 1 / 2
Depth before / after: 19 / 19 µm
Depth decreased by: 0%

Comment
wear streak 300.
Roll is heavily worn.



Page №153. Roll "3016198-3". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "3016198-3".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	220	lpcm
Vol	8.0	cm^3/m^2

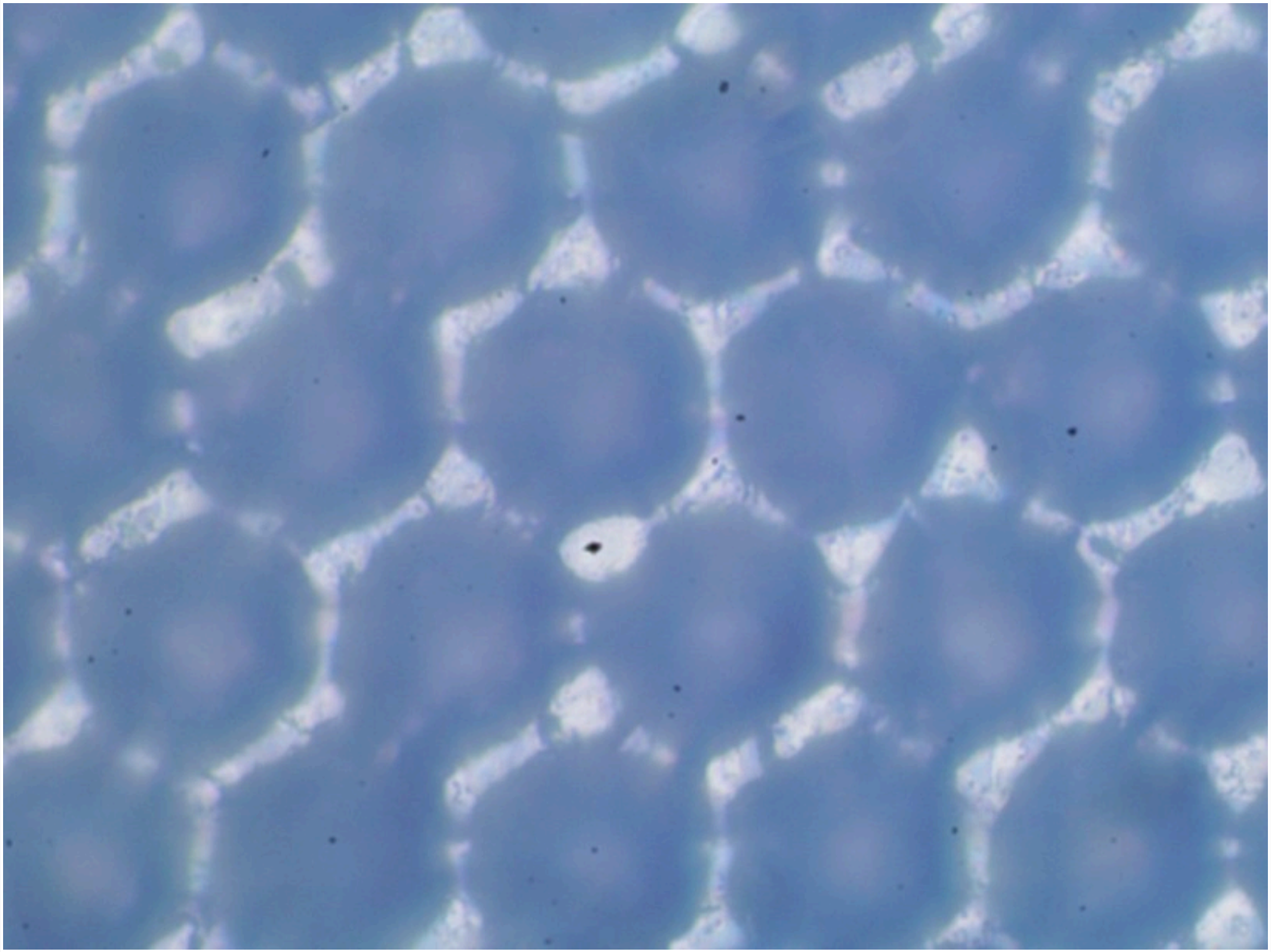
LEC measurements by Troika:

Measured line screen	220	lpcm
Vol	6.10	cm^3/m^2

Ink transfer volume decrease from the nominal value: 23.75%

Bridge / Cell: 1 / 13
Depth before / after: 18 / 18 µm
Depth decreased by: 0%

Comment
streak 95.



Page №154. Roll "sg49046-18". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-18".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	380	lpcm
Vol	5.0	cm^3/m^2

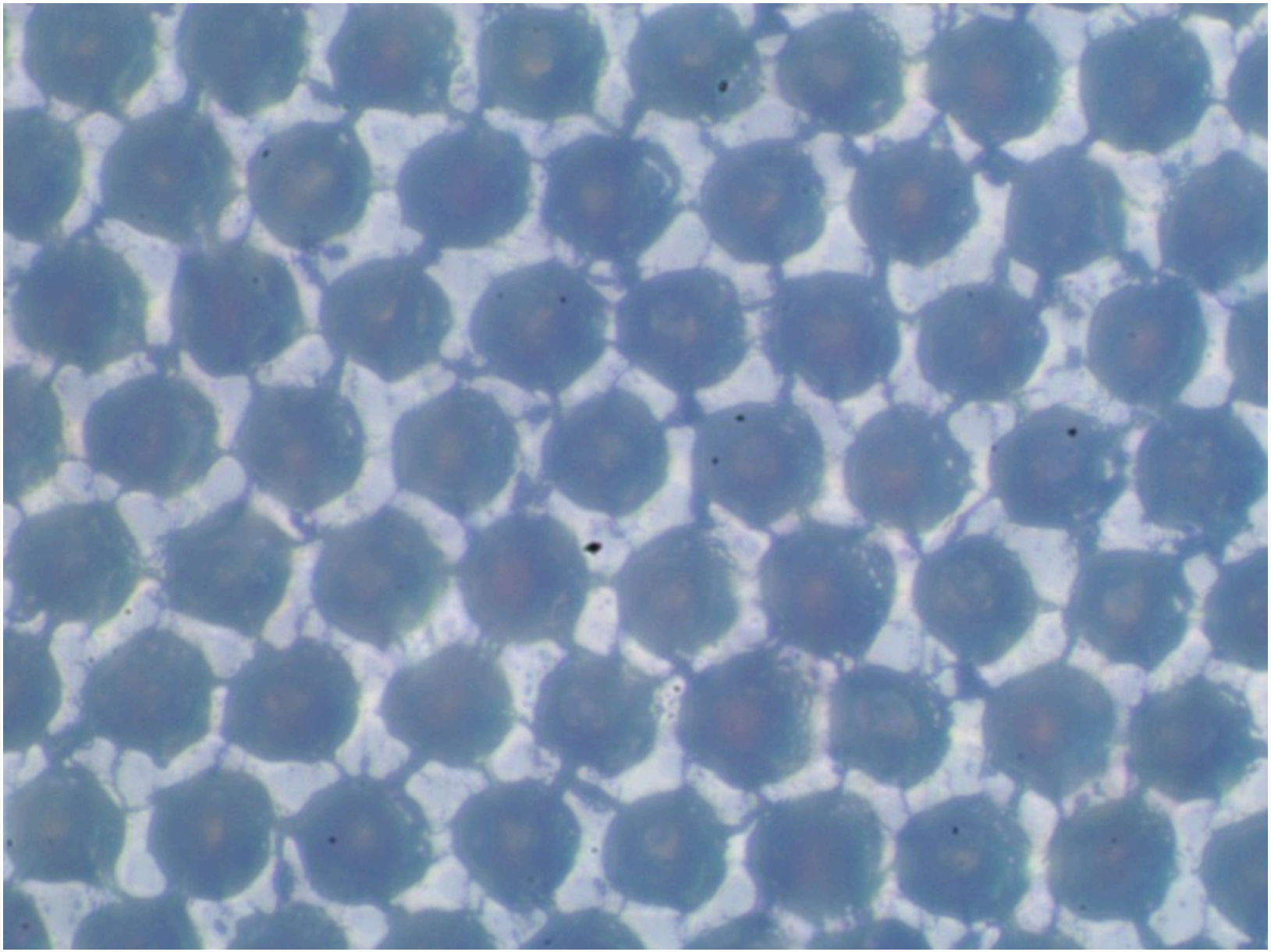
LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	3.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 24%

Bridge / Cell: 1 / 5
Depth before / after: 14 / 14 µm
Depth decreased by: 0%

Comment
Roll is worn.



Page №155. Roll "sg49046-23". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-23".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	420	lpcm
Vol	4.0	cm^3/m^2

LEC measurements by Troika:

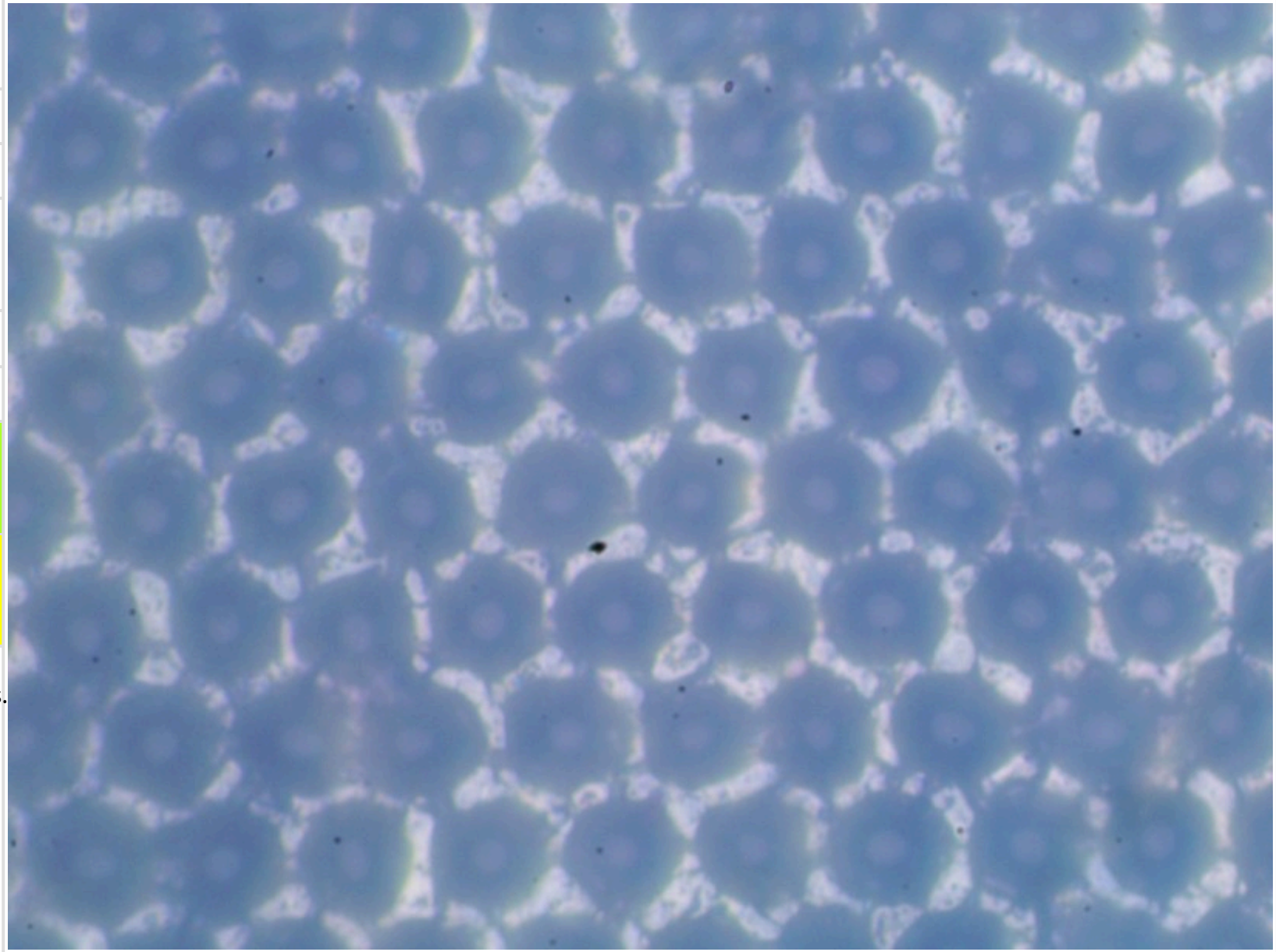
Measured line screen	420	lpcm
Vol	4.00	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 7
Depth before / after: 13.5 / 13.5 µm
Depth decreased by: 0%

Comment
streaks streak 50 1335 chips at edges.

Roll is slightly worn.



Page №156. Roll "sg49046-17". Length: 1360 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sg49046-17".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	340	lpcm
Vol	5.5	cm^3/m^2

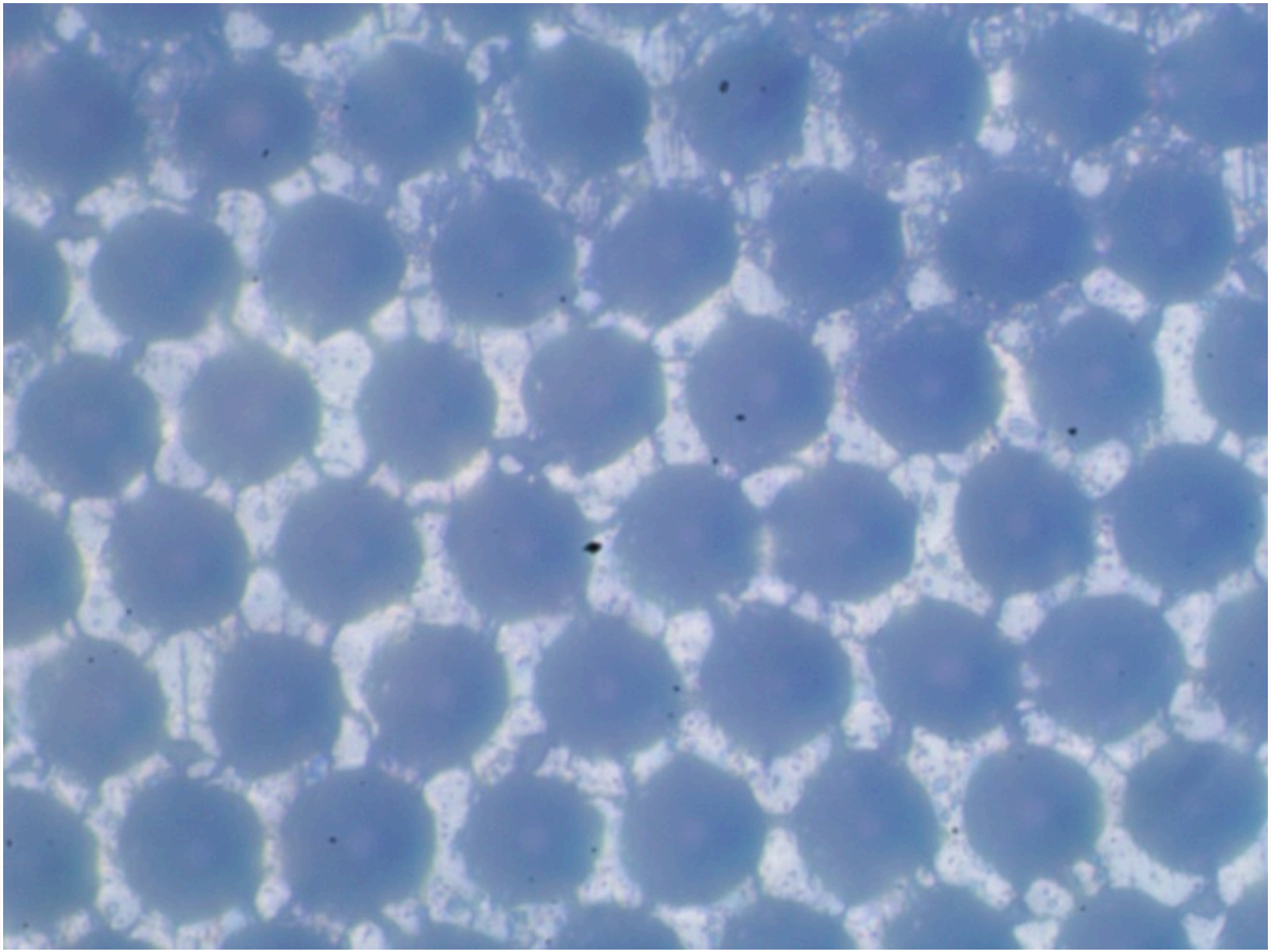
LEC measurements by Troika:

Measured line screen	360	lpcm
Vol	4.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10.91%

Bridge / Cell: 1 / 6
Depth before / after: 17 / 17 µm
Depth decreased by: 0%

Comment
streak 1260 chips at edges.
Roll is worn.



Page №157. Roll "z17011022". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011022".	Photo of the anilox roll surface

Roll designations:

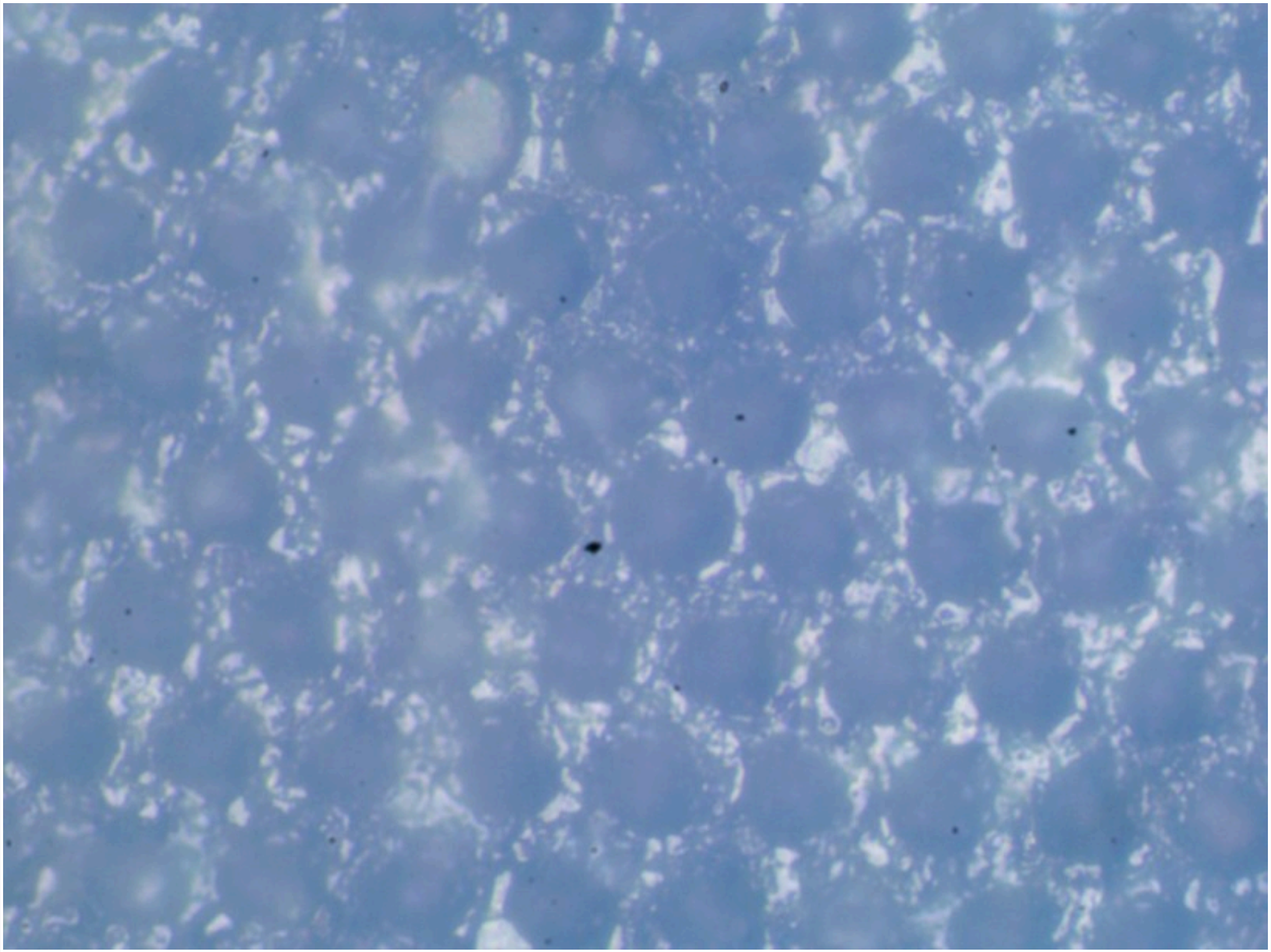
Nominal line screen	400	lpcm
Vol	3.7	cm^3/m^2

LEC measurements by Troika:

Measured line screen	420	lpcm
Vol	1.80	cm^3/m^2

Ink transfer volume decrease from the nominal value: 51.35%

Bridge / Cell: 1 / 3
Depth before / after: 8 / 8 µm
Depth decreased by: 0%



Comment
streaks cell walls are missing.
Roll is heavily worn.

Page №158. Roll "sa008599". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008599".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

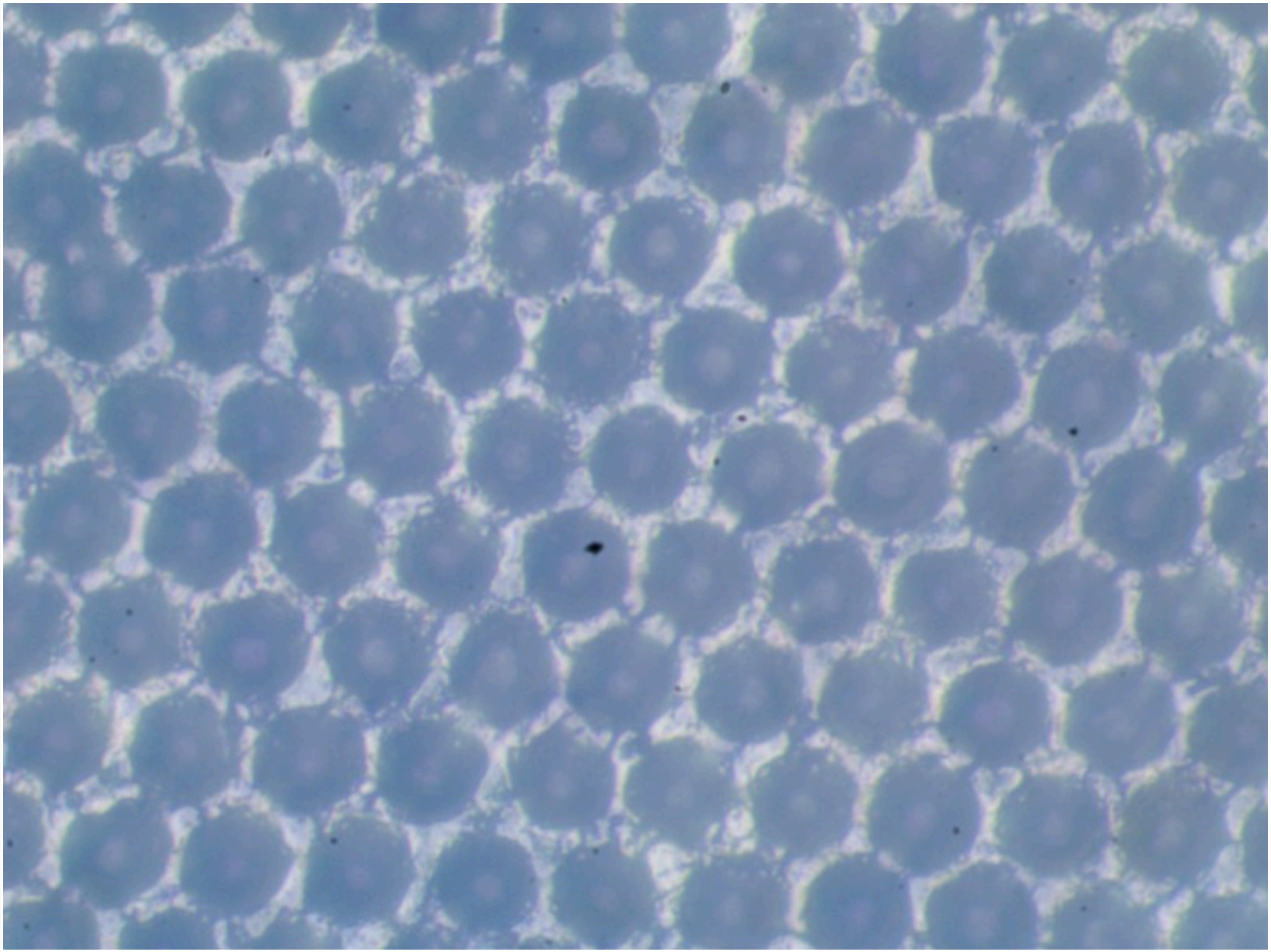
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 7.89%

Bridge / Cell: 1 / 6
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment
spot 1335 chips at edges.
Roll is worn.



Page №159. Roll "h100750-6". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100750-6".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	140	lpcm
Vol	12.5	cm^3/m^2

LEC measurements by Troika:

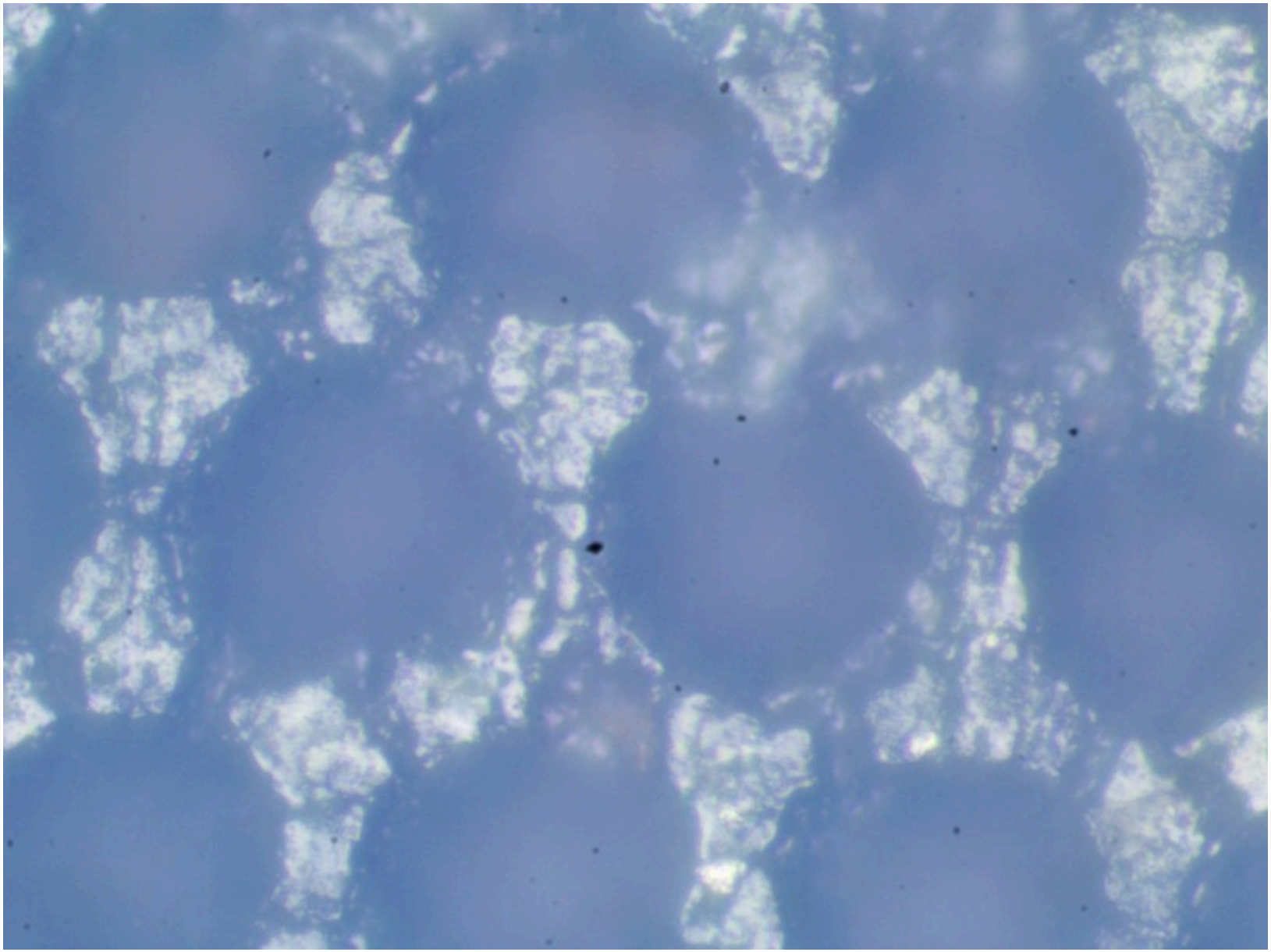
Measured line screen	140	lpcm
Vol	5.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 52.8%

Bridge / Cell: 1 / 3
Depth before / after: 26 / 26 µm
Depth decreased by: 0%

Comment
streaks wear cell walls are missing.

Roll is heavily worn.



Page №160. Roll "046639". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "046639".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	9.9	cm^3/m^2

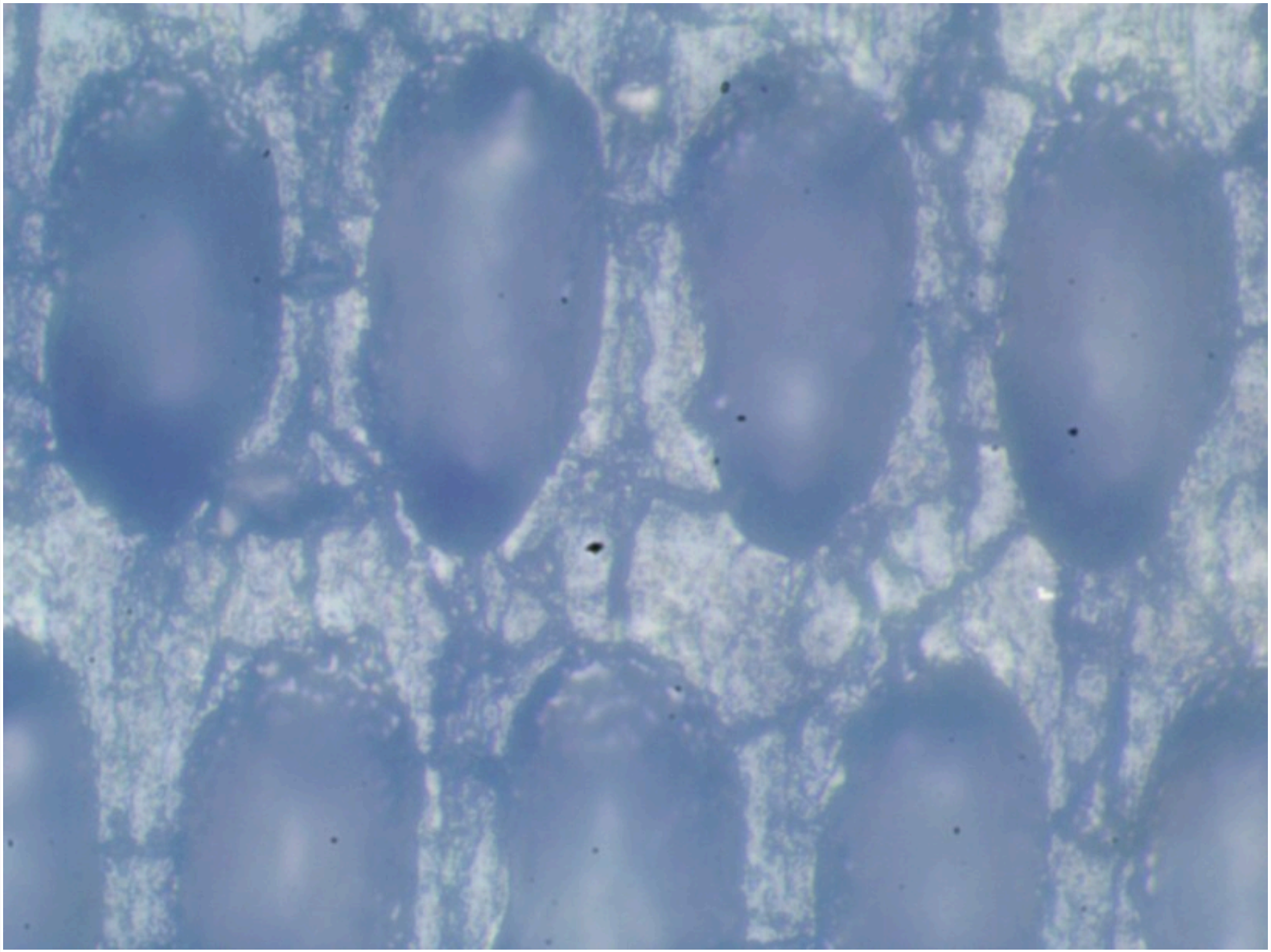
LEC measurements by Troika:

Measured line screen	180	lpcm
Vol	4.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 55.56%

Bridge / Cell: 1 / 3
Depth before / after: 19 / 19 µm
Depth decreased by: 0%

Comment
dent 250 290 scratch 1020
470.
Roll is heavily worn.



Page №161. Roll "sa008590". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008590".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	150	lpcm
Vol	9.0	cm^3/m^2

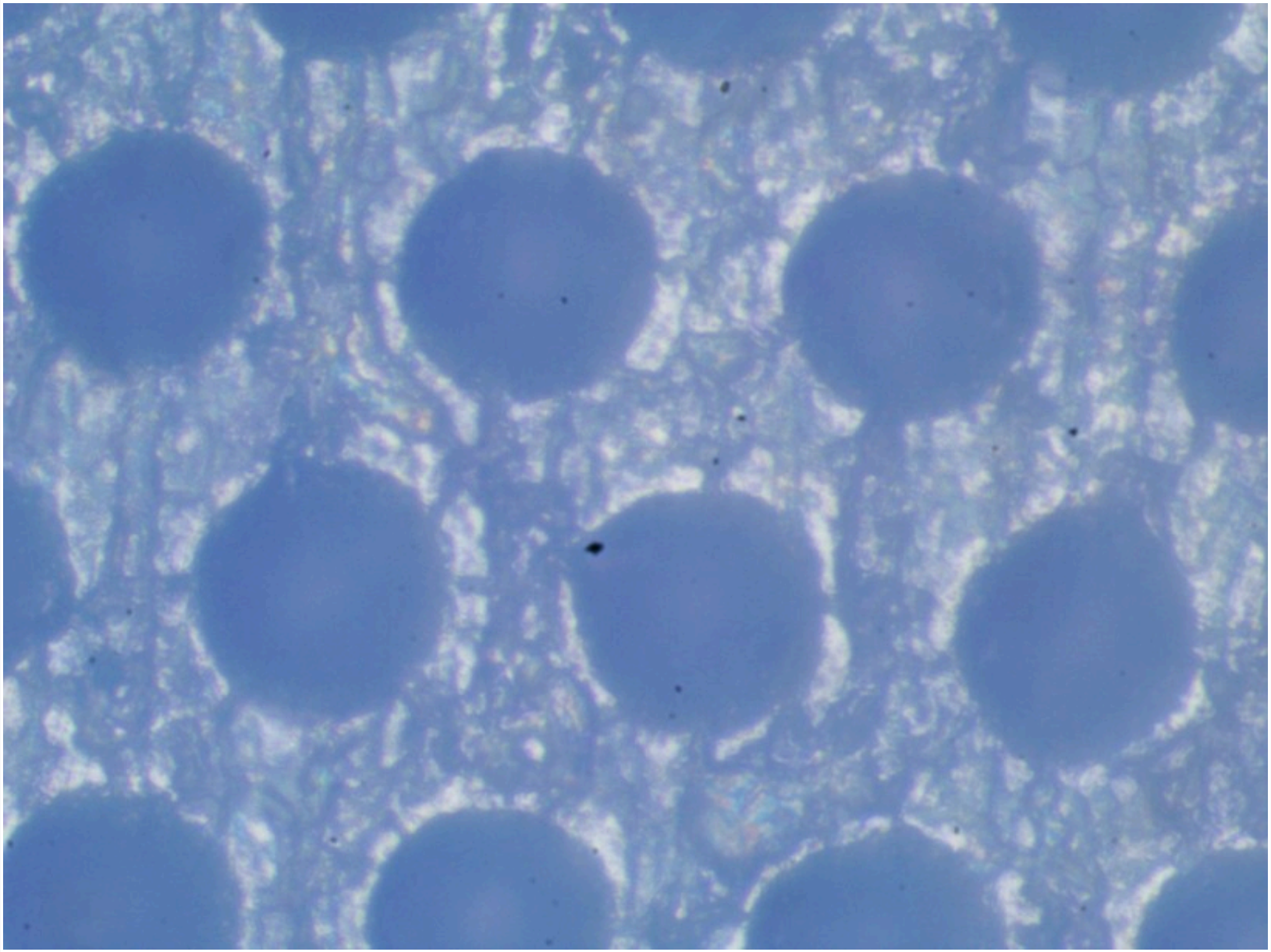
LEC measurements by Troika:

Measured line screen	160	lpcm
Vol	3.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 58.89%

Bridge / Cell: 1 / 3
Depth before / after: 18 / 18 µm
Depth decreased by: 0%

Comment
streak 1070 bumps 300 scrap.
Roll is heavily worn.



Page №162. Roll "z17011032". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011032".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	6.9	cm^3/m^2

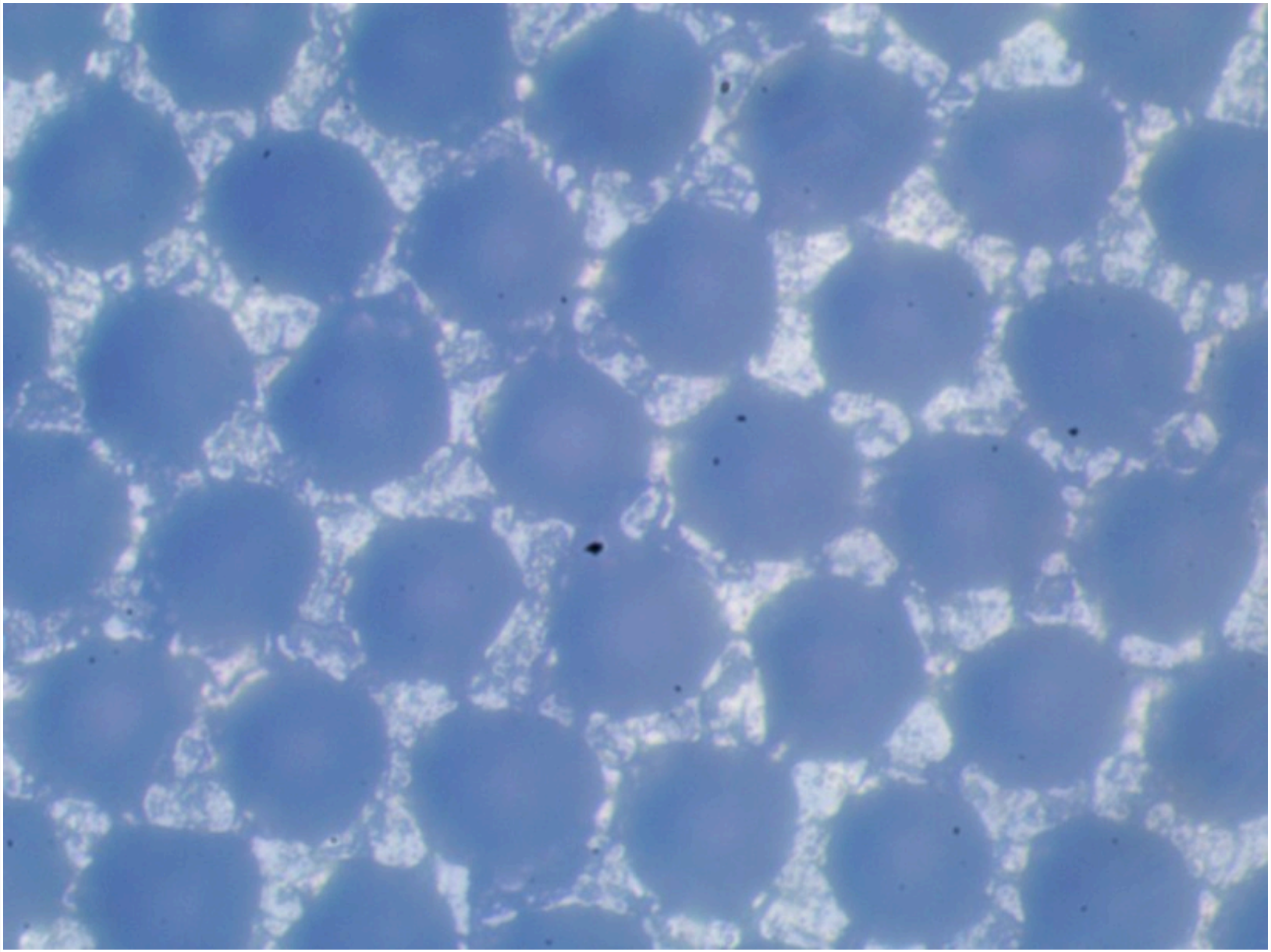
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	6.40	cm^3/m^2

Ink transfer volume decrease from the nominal value: 7.25%

Bridge / Cell: 1 / 6
Depth before / after: 22 / 22 µm
Depth decreased by: 0%

Comment
spot 1260 streaks.
Roll is worn.



Page №163. Roll "z17011020". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011020".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	7.1	cm^3/m^2

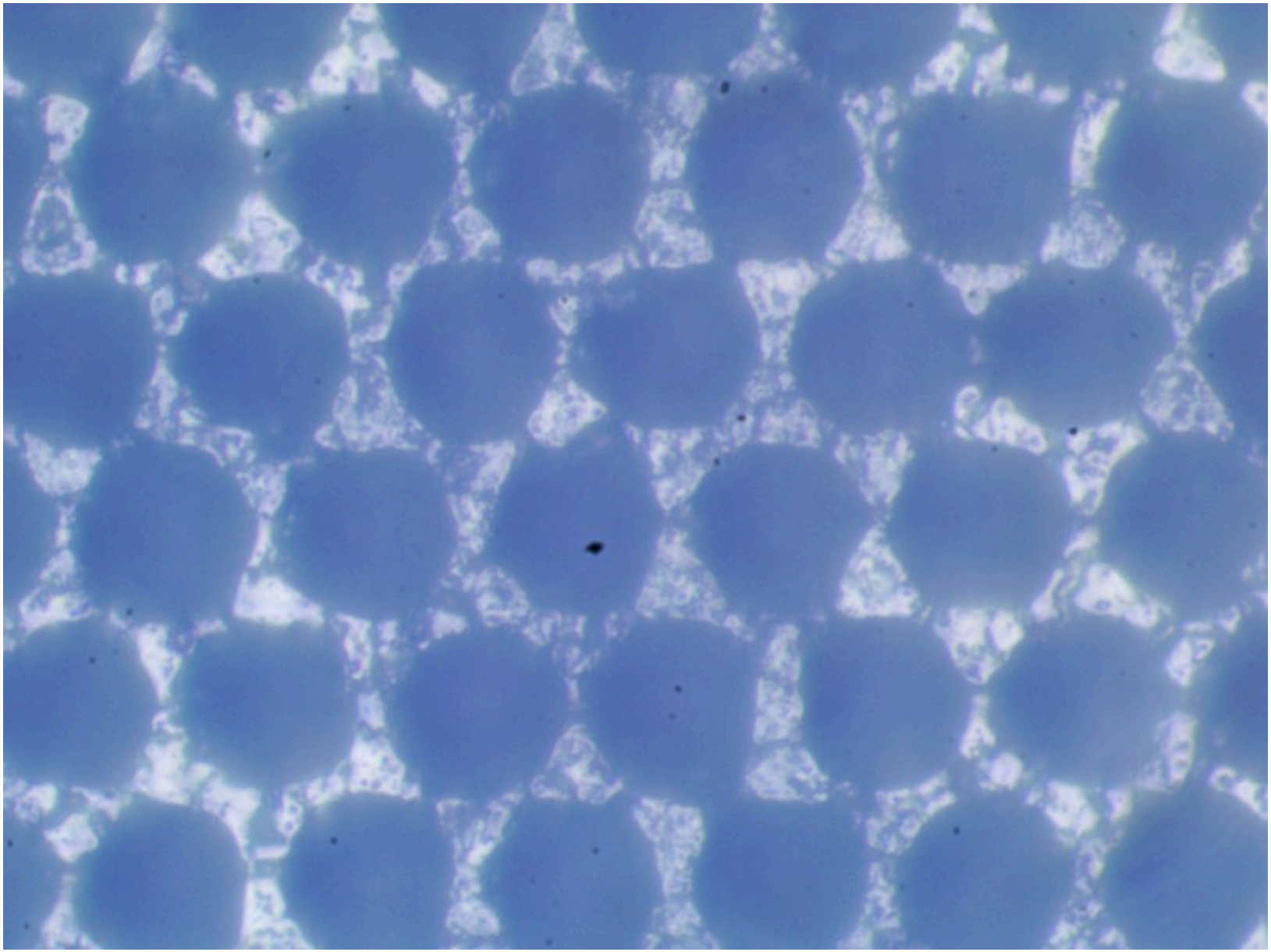
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	6.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 5.63%

Bridge / Cell: 1 / 6
Depth before / after: 23 / 23 µm
Depth decreased by: 0%

Comment
dents 95 114 305 360.
Roll is worn.



Page №164. Roll "a2724009". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "a2724009".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	5.5	cm^3/m^2

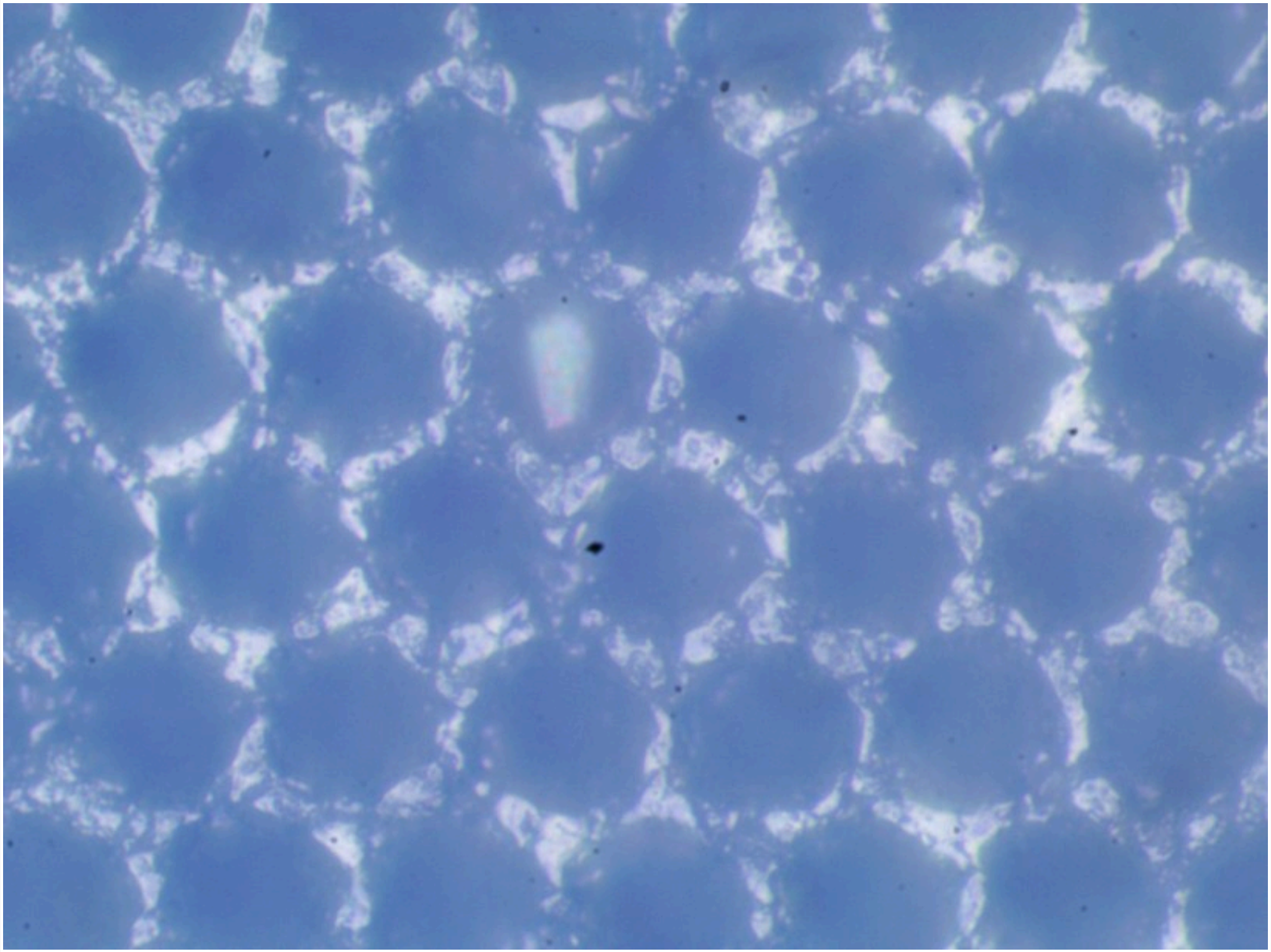
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	4.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 21.82%

Bridge / Cell: 1 / 8
Depth before / after: 14 / 14 µm
Depth decreased by: 0%

Comment
chip 75 streak 385.
Roll is slightly worn.



Page №165. Roll "sa008606". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008606".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

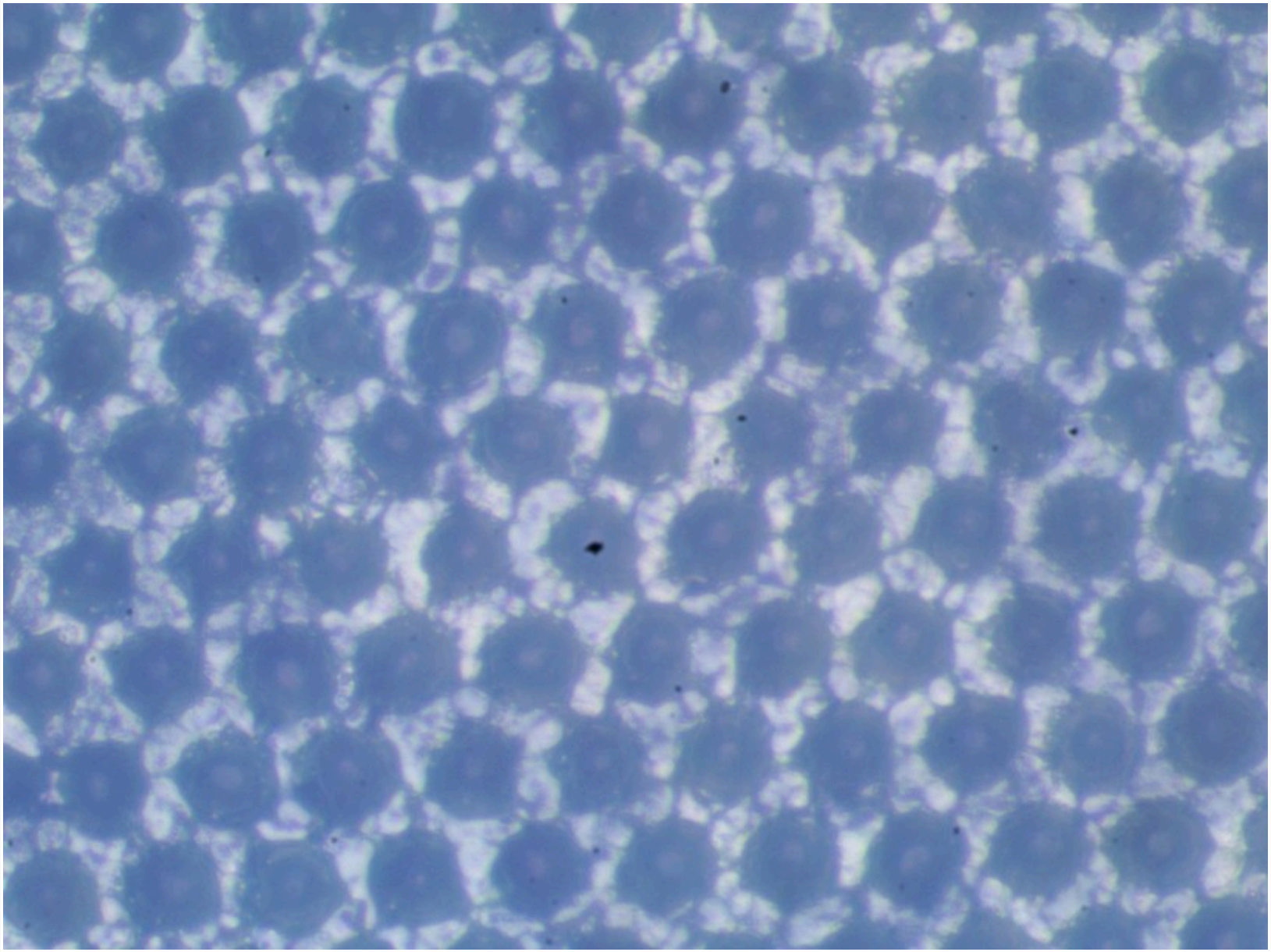
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	2.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 39.47%

Bridge / Cell: 1 / 4
Depth before / after: 9 / 9 µm
Depth decreased by: 0%

Comment
dent 240 285.
Roll is worn.



Page №166. Roll "sa008603". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008603".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

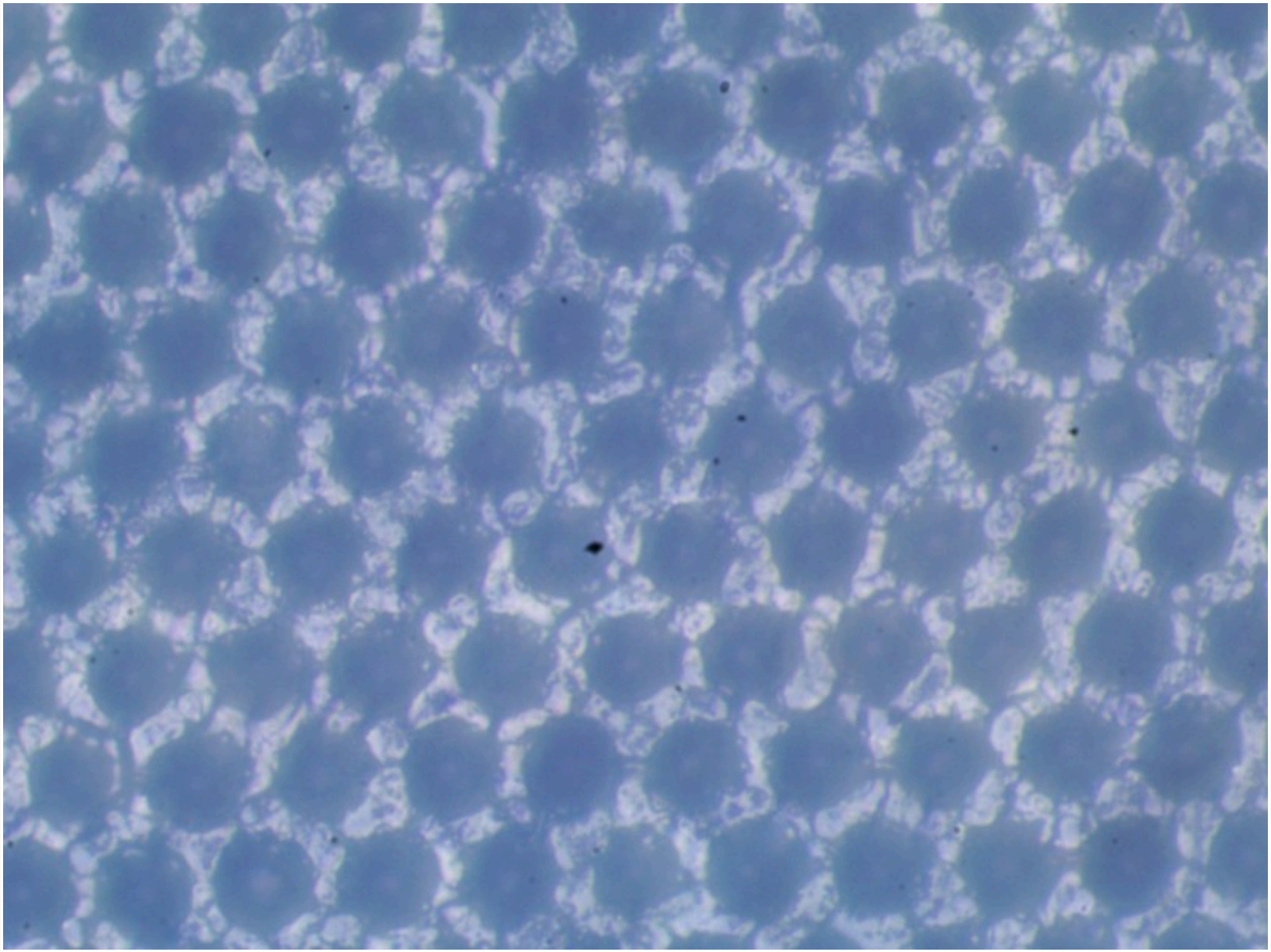
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	2.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 39.47%

Bridge / Cell: 1 / 4
Depth before / after: 9 / 9 µm
Depth decreased by: 0%

Comment
Roll is worn.



Page №167. Roll "sa008597". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008597".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	380	lpcm
Vol	5.0	cm^3/m^2

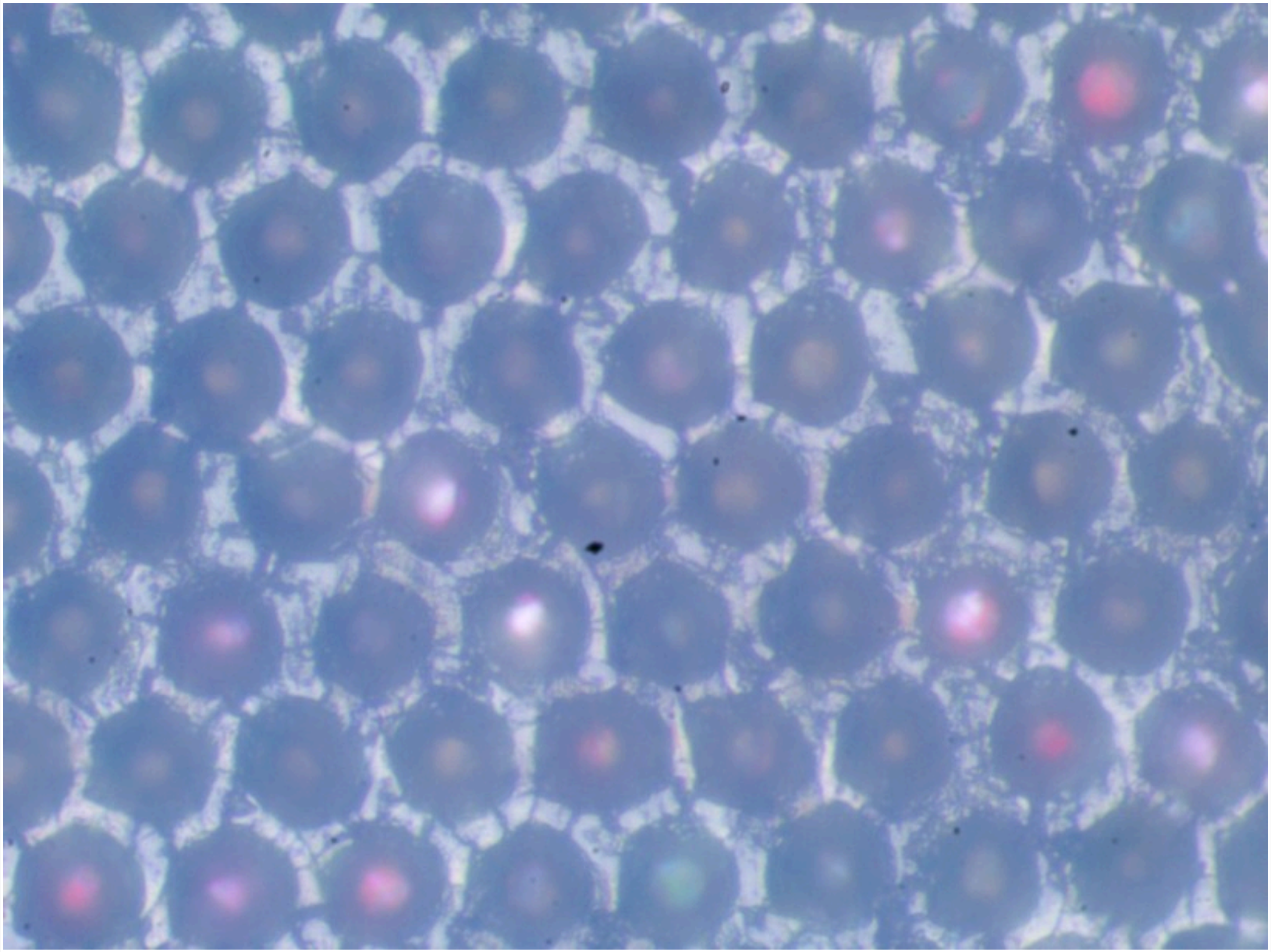
LEC measurements by Troika:

Measured line screen	400	lpcm
Vol	4.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 10%

Bridge / Cell: 1 / 4
Depth before / after: 18 / 18 µm
Depth decreased by: 0%

Comment
dent 1200 1290 streak 1115.
Roll is worn.



Page №168. Roll "sa008595". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008595".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	300	lpcm
Vol	6.0	cm^3/m^2

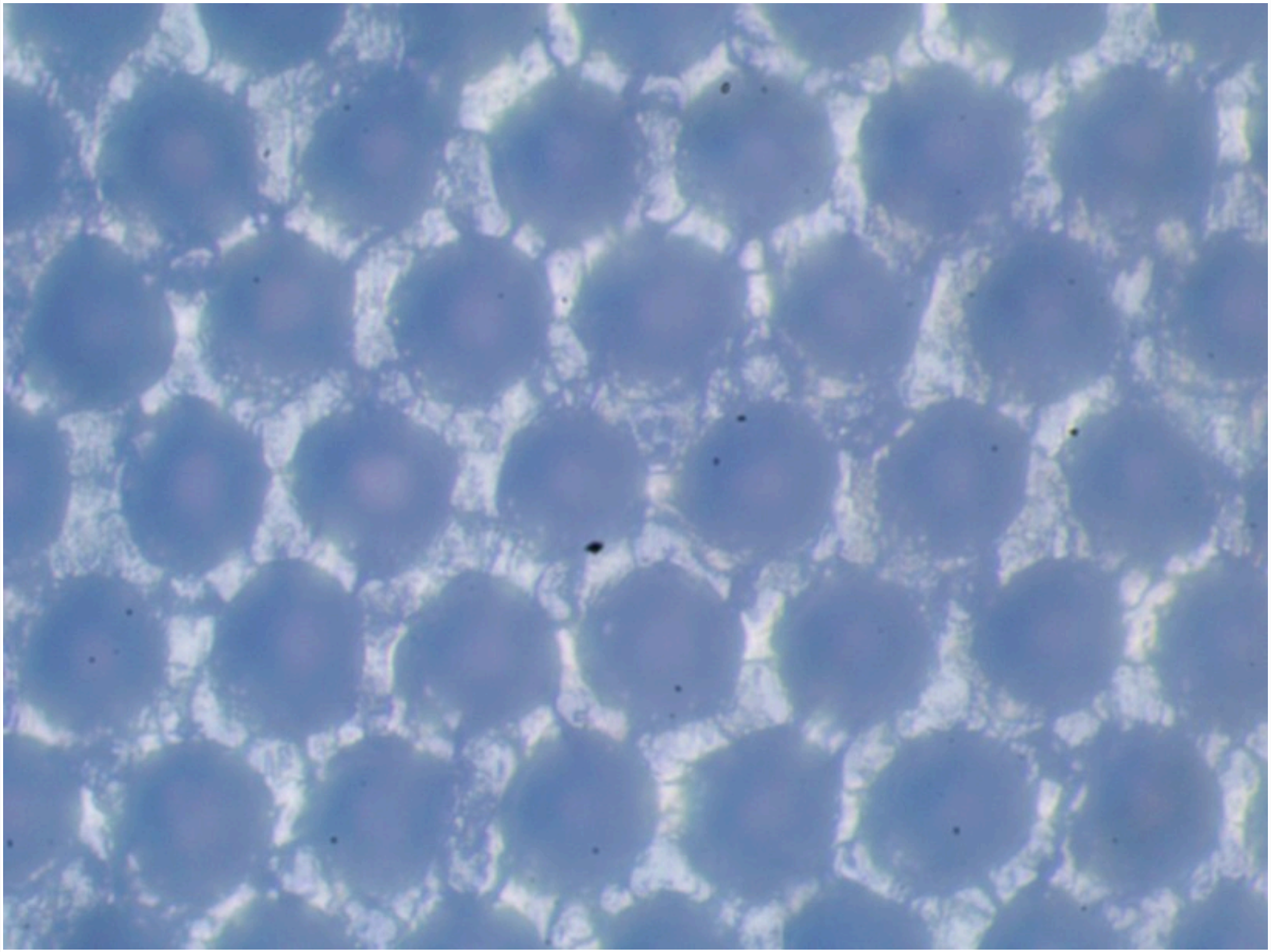
LEC measurements by Troika:

Measured line screen	300	lpcm
Vol	4.70	cm^3/m^2

Ink transfer volume decrease from the nominal value: 21.67%

Bridge / Cell: 1 / 5
Depth before / after: 18 / 18 µm
Depth decreased by: 0%

Comment
streak dent 1235.
Roll is worn.



Page №169. Roll "h100748-4". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100748-4".	Photo of the anilox roll surface

Roll designations:

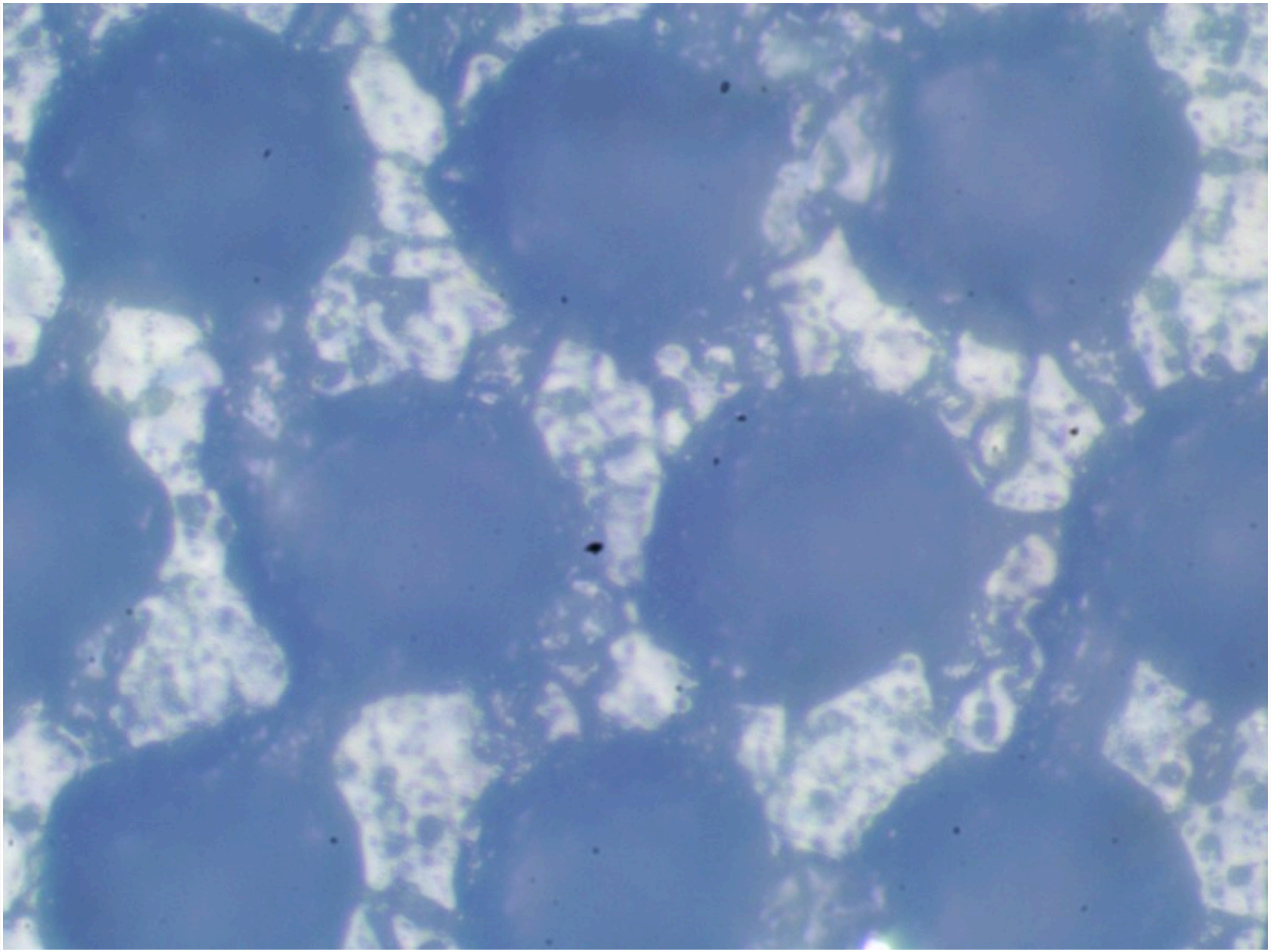
Nominal line screen	140	lpcm
Vol	12.5	cm^3/m^2

LEC measurements by Troika:

Measured line screen	140	lpcm
Vol	5.90	cm^3/m^2

Ink transfer volume decrease from the nominal value: 52.8%

Bridge / Cell: 1 / 3
Depth before / after: 26.5 / 26.5 µm
Depth decreased by: 0%



Comment
worn streaks.
Roll is heavily worn.

Page №170. Roll "z18006928". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18006928".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	6.6	cm^3/m^2

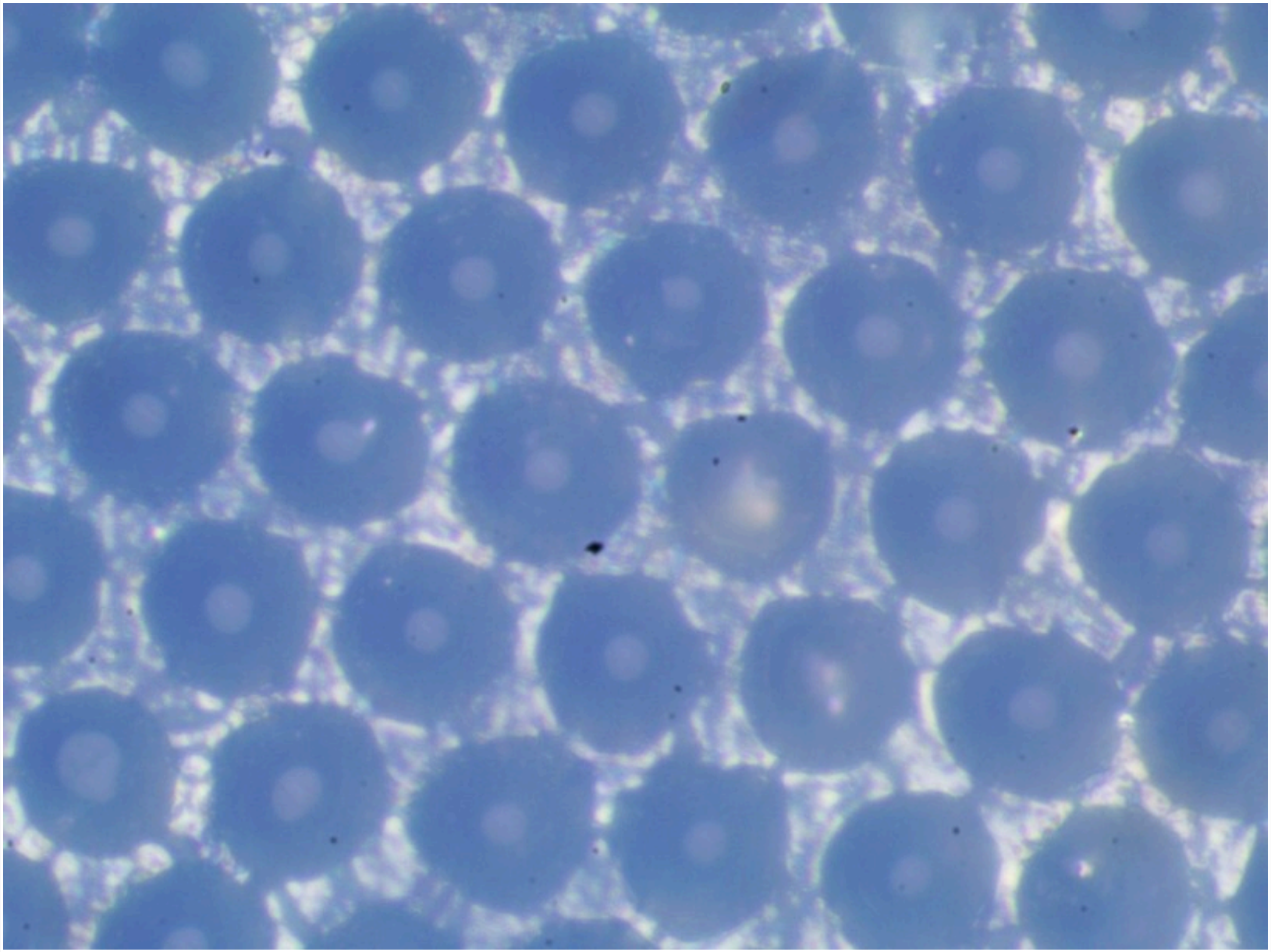
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	5.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 16.67%

Bridge / Cell: 1 / 5
Depth before / after: 20.5 / 20.5 µm
Depth decreased by: 0%

Comment
scratch 1200 chip 1000.
Roll is worn.



Page №171. Roll "h100751-3". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "h100751-3".	Photo of the anilox roll surface

Roll designations:

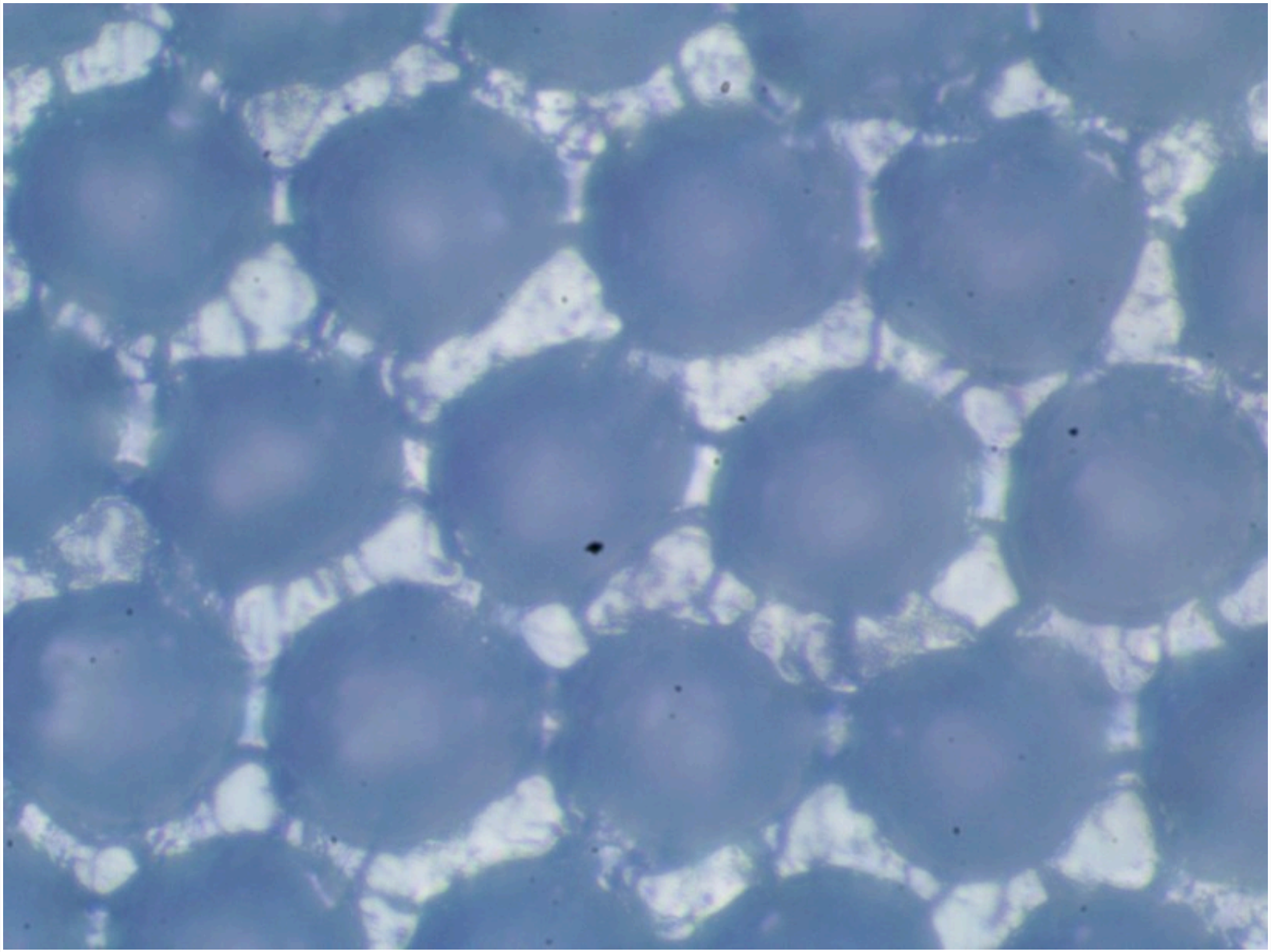
Nominal line screen	200	lpcm
Vol	8.5	cm^3/m^2

LEC measurements by Troika:

Measured line screen	200	lpcm
Vol	7.30	cm^3/m^2

Ink transfer volume decrease from the nominal value: 14.12%

Bridge / Cell: 1 / 6
Depth before / after: 25 / 25 µm
Depth decreased by: 0%



Comment
chip 25 60 scratch 205 240 445 480 520 585.
Roll is worn.

Page №172. Roll "z17011029". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011029".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	180	lpcm
Vol	8.8	cm^3/m^2

LEC measurements by Troika:

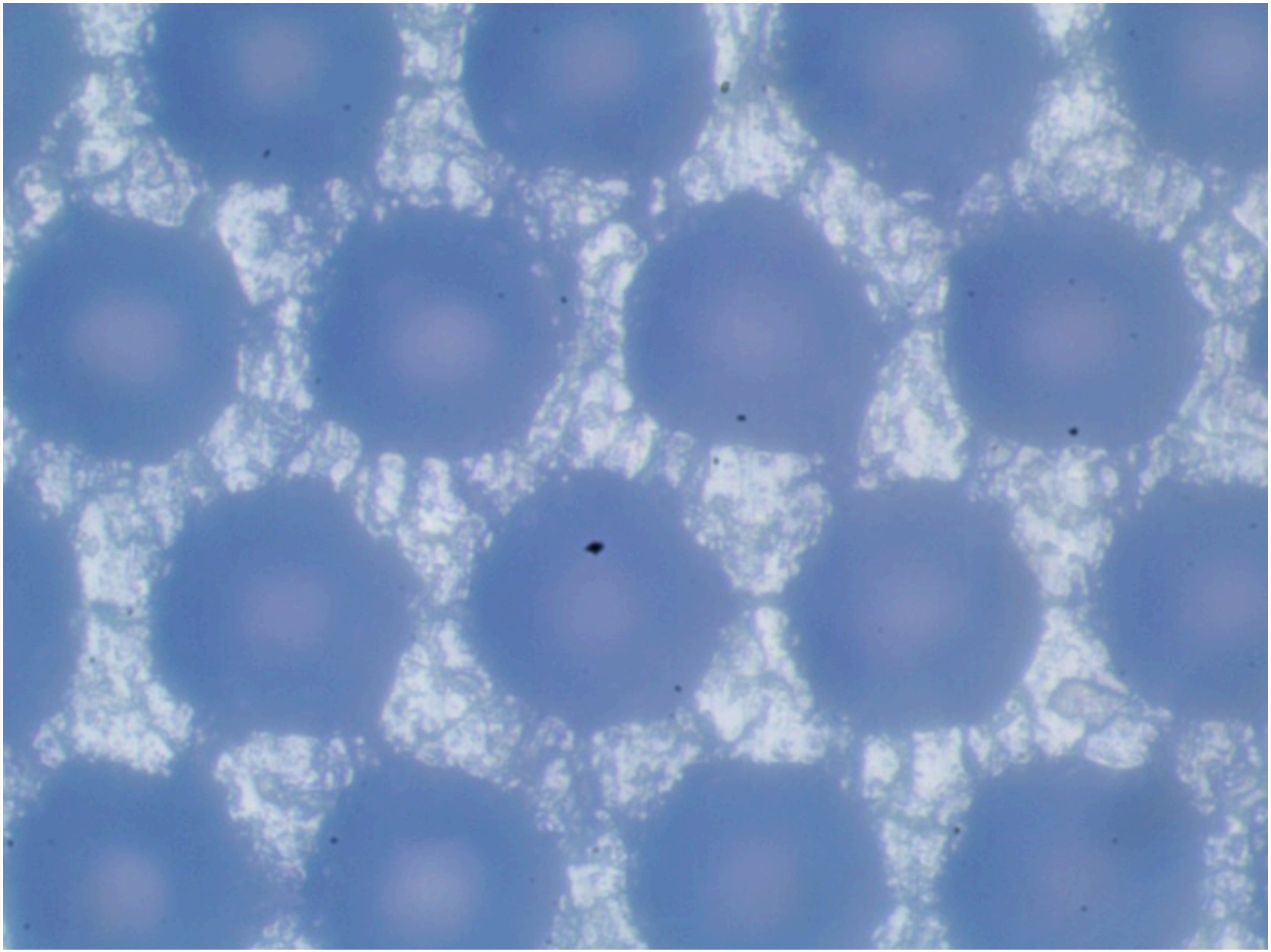
Measured line screen	180	lpcm
Vol	6.20	cm^3/m^2

Ink transfer volume decrease from the nominal value: 29.55%

Bridge / Cell: 1 / 5
Depth before / after: 23.5 / 23.5 µm
Depth decreased by: 0%

Comment
streaks chemical stains chips across edges chip 235.

Roll is worn.



Page №173. Roll "z17011035". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z17011035".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.7	cm^3/m^2

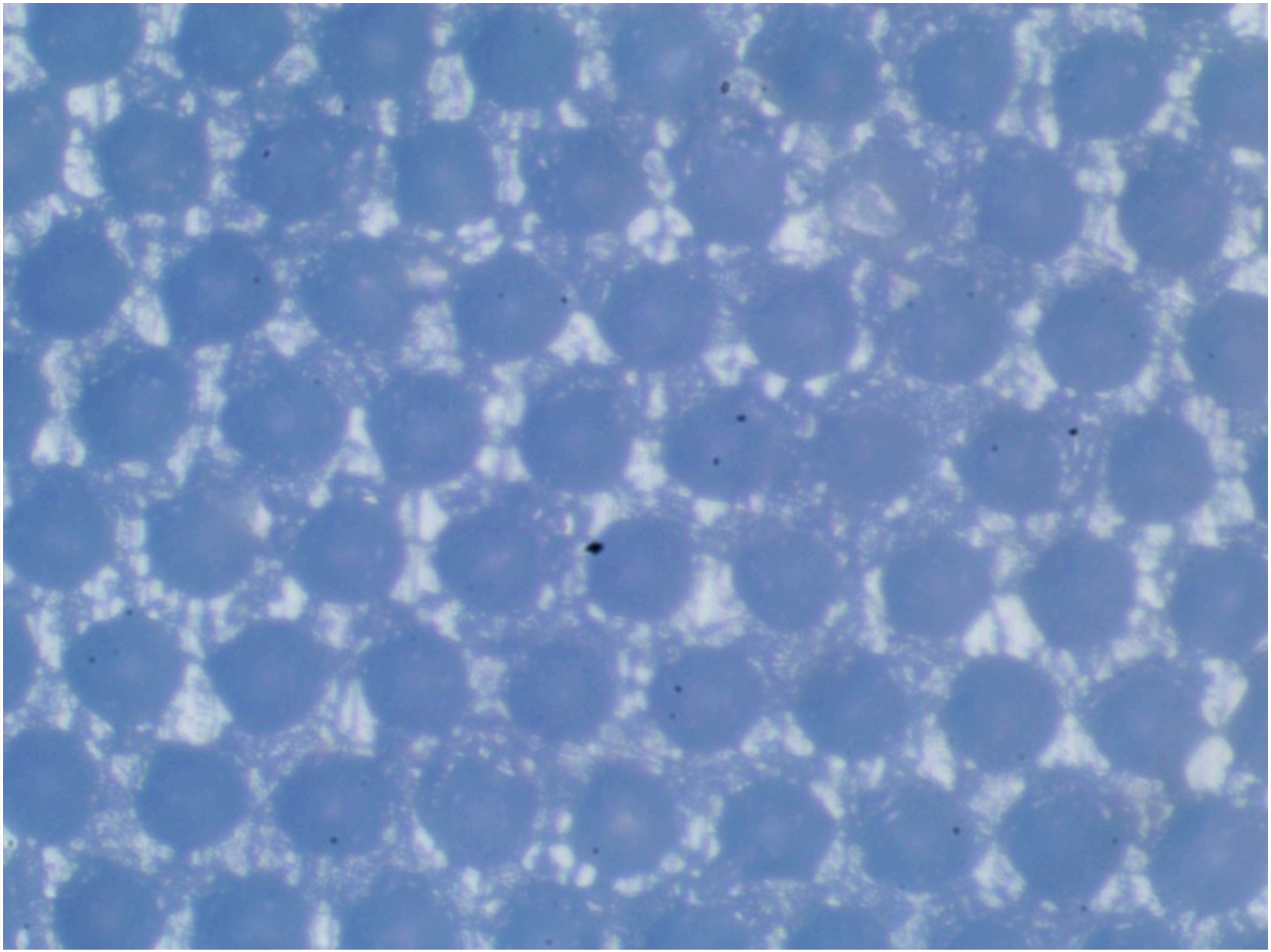
LEC measurements by Troika:

Measured line screen	400	lpcm
Vol	2.00	cm^3/m^2

Ink transfer volume decrease from the nominal value: 45.95%

Bridge / Cell: 1 / 3
Depth before / after: 9 / 9 µm
Depth decreased by: 0%

Comment
streaks scratch 470 chip 1180
1230.
Roll is heavily worn.



Page №174. Roll "z48074". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z48074".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	400	lpcm
Vol	3.8	cm^3/m^2

LEC measurements by Troika:

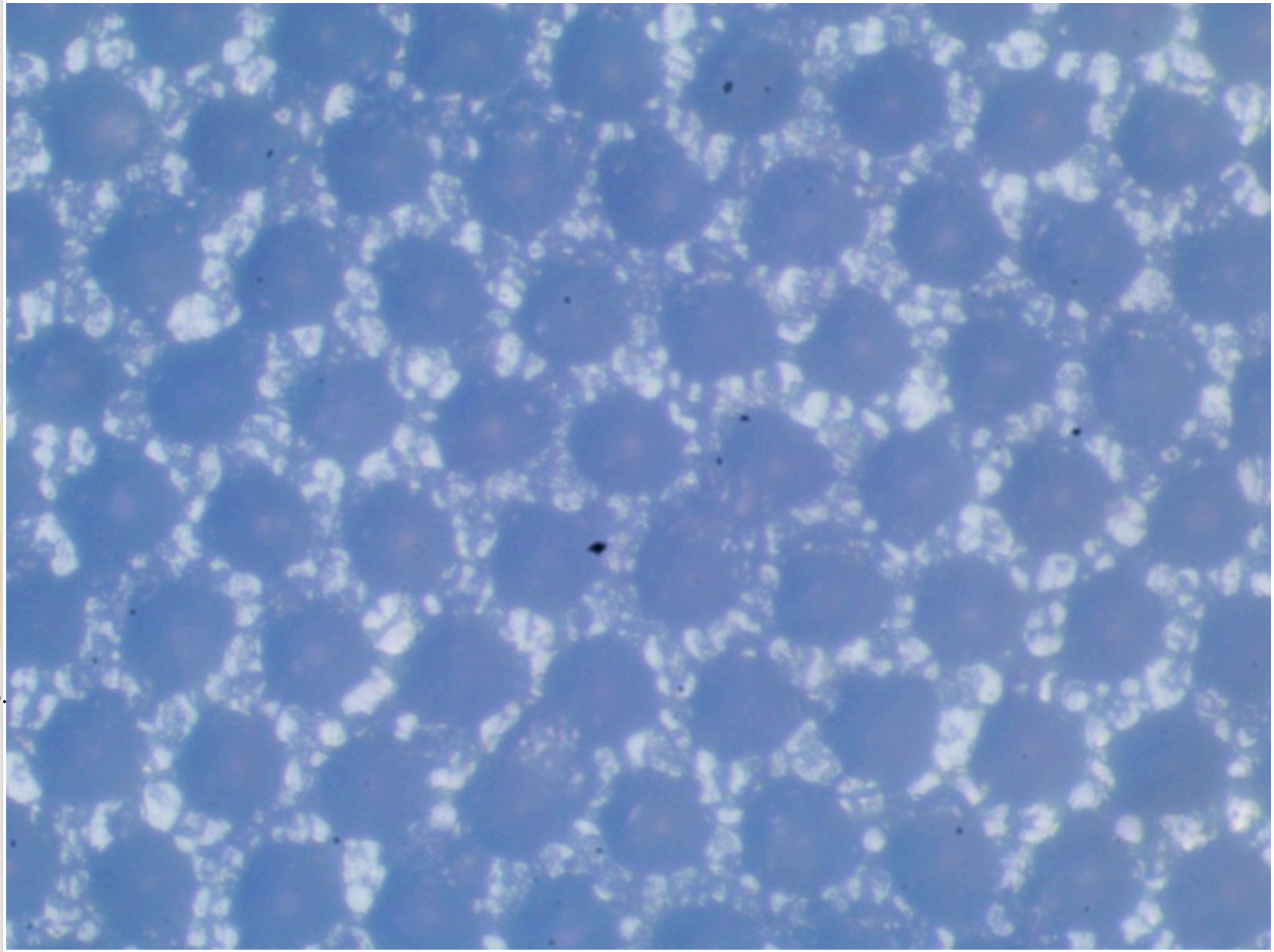
Measured line screen	400	lpcm
Vol	3.00	cm^3/m^2

Ink transfer volume decrease from the nominal value: 21.05%

Bridge / Cell: 1 / 4
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment
streaks chip 1170 1225 1230 spot 205.

Roll is worn.



Page №175. Roll "z18006927". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18006927".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	7.0	cm^3/m^2

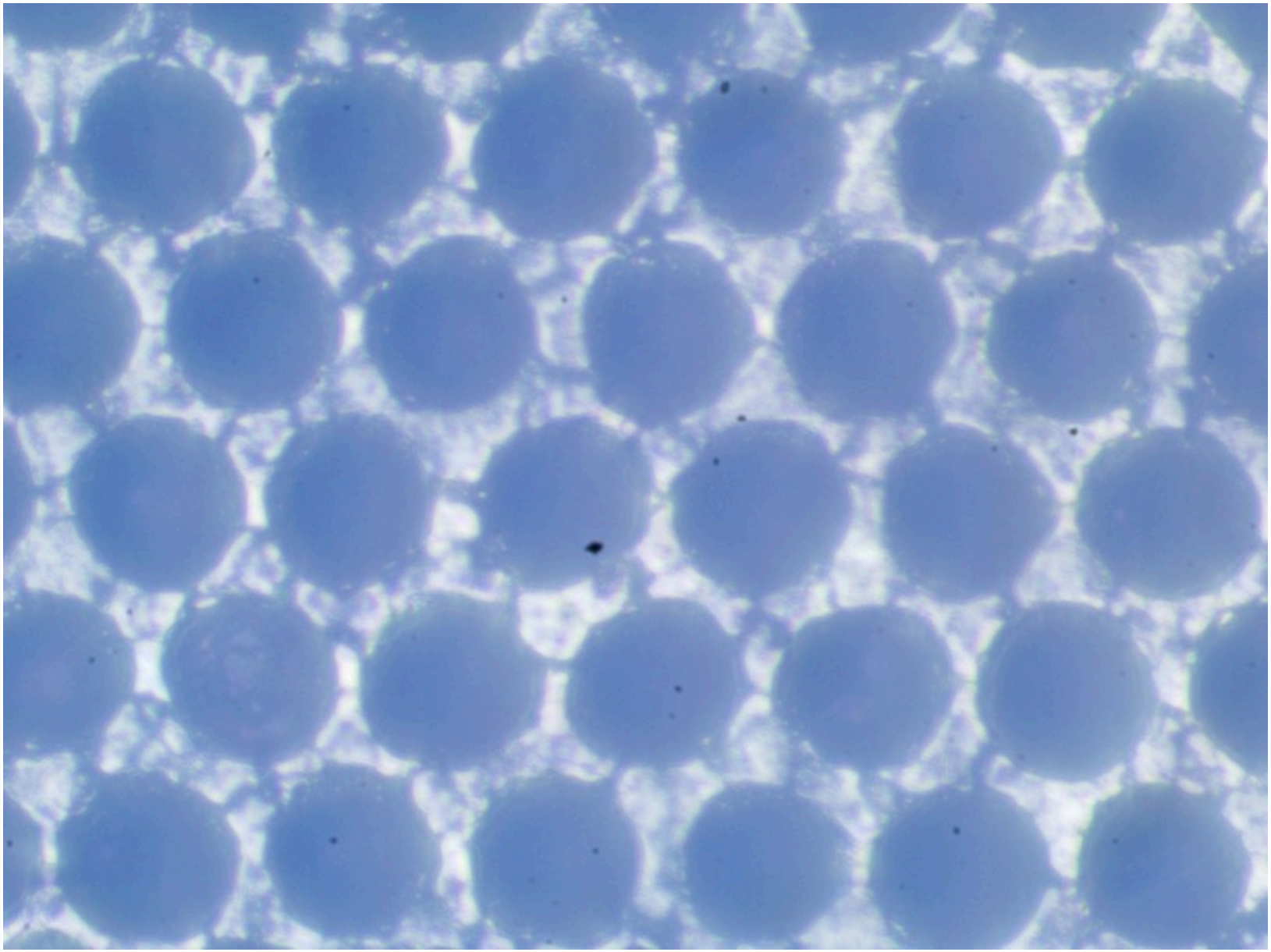
LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	5.50	cm^3/m^2

Ink transfer volume decrease from the nominal value: 21.43%

Bridge / Cell: 1 / 8
Depth before / after: 18 / 18 µm
Depth decreased by: 0%

Comment
chip 1120 1280 1035 1080 1190 1255.
Roll is slightly worn.



Page №176. Roll "sa008610". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008610".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

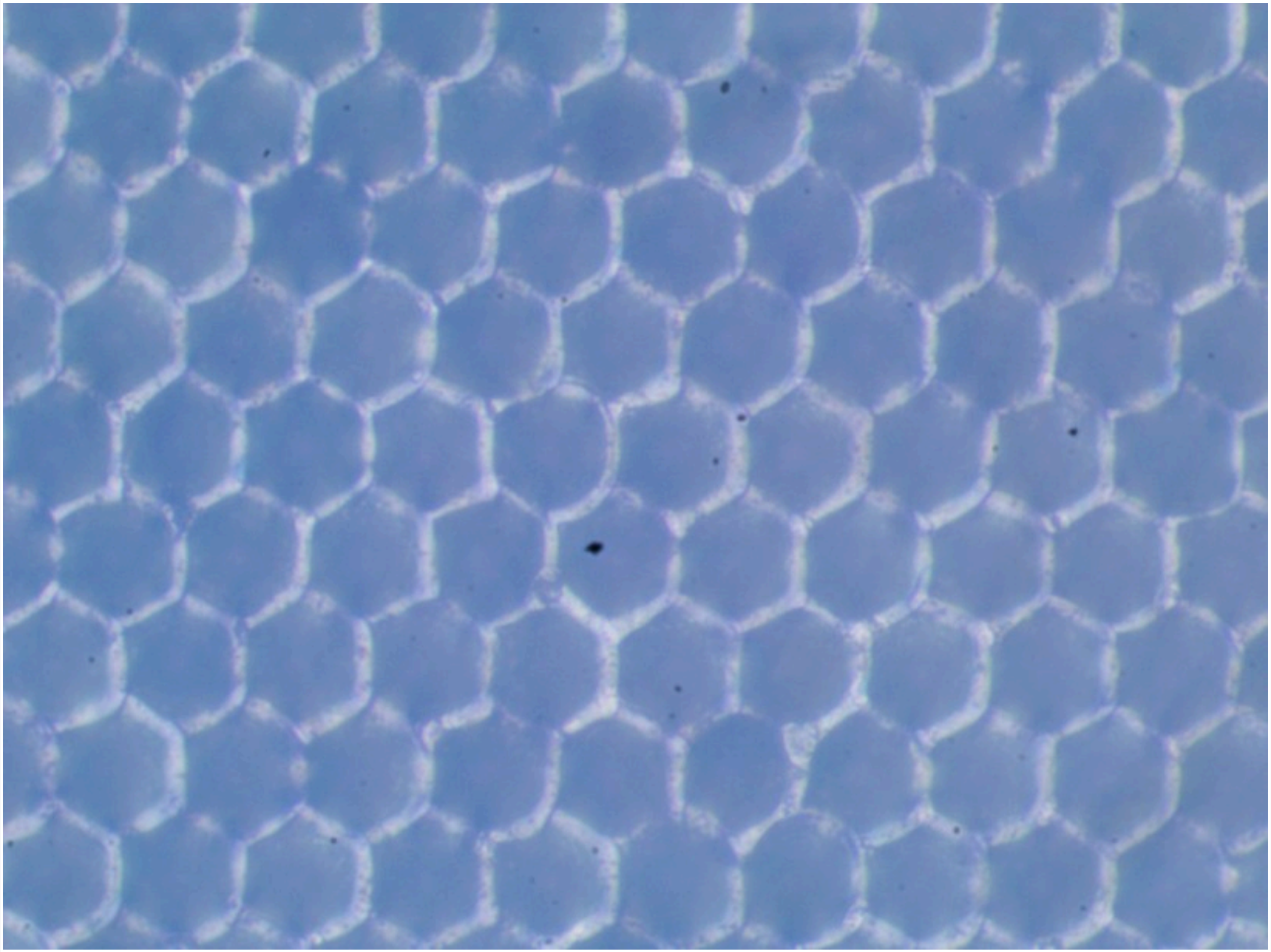
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.80	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 10
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment



Page №177. Roll "sa008614". Length: 870 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "sa008614".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	460	lpcm
Vol	3.8	cm^3/m^2

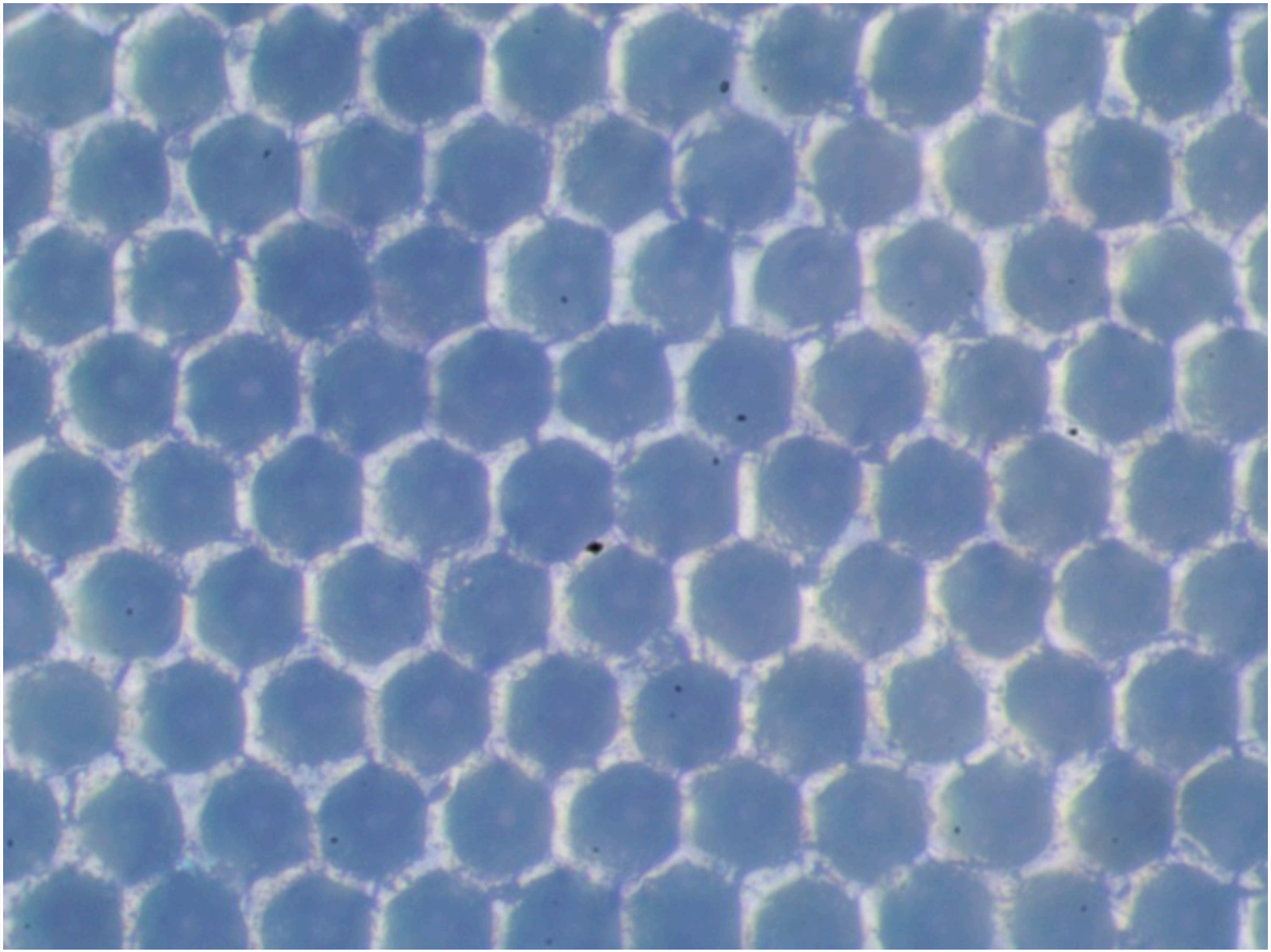
LEC measurements by Troika:

Measured line screen	460	lpcm
Vol	3.80	cm^3/m^2

Ink transfer has not changed

Bridge / Cell: 1 / 10
Depth before / after: 12 / 12 µm
Depth decreased by: 0%

Comment



Page №178. Roll "z18009230". Length: 1300 mm. Photos with magnification: x400. Cleaning passes: 1

Roll "z18009230".	Photo of the anilox roll surface

Roll designations:

Nominal line screen	280	lpcm
Vol	7.0	cm^3/m^2

LEC measurements by Troika:

Measured line screen	280	lpcm
Vol	5.10	cm^3/m^2

Ink transfer volume decrease from the nominal value: 27.14%

Bridge / Cell: 1 / 5
Depth before / after: 19 / 19 µm
Depth decreased by: 0%

Comment
streak 124 335.
Roll is worn.

