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(54) Title: SYSTEM AND METHOD FOR DIGITAL CREATION OF A PRINT MASTER USING A MULTIPLE PRINthead UNIT

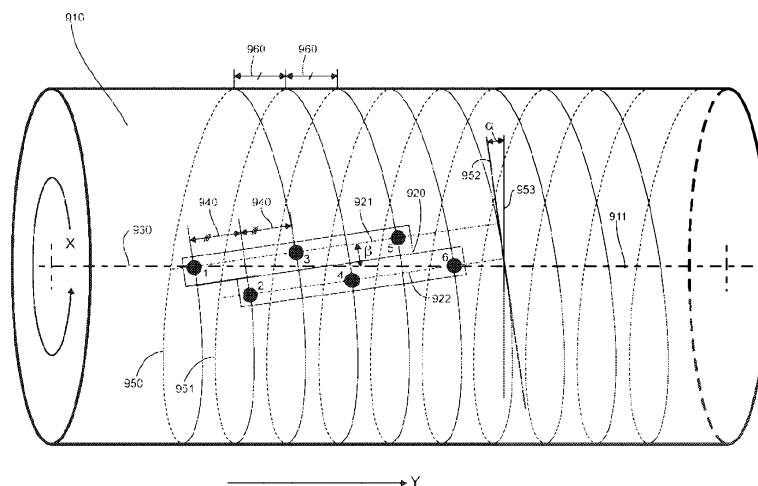


FIG. 9

(57) Abstract: A relief print master is created by means of a printhead that jets droplets of a polymerisable liquid on a cylindrical sleeve. The droplets follow a spiral path on the cylindrical sleeve. In a multiple printhead unit, there are different spiral paths associated with the different constituting printheads. The distance between these spiral paths is not even in a prior art system. By rotating the printhead under a specific angle, the distance between these spiral paths becomes even. The invention can also be used for the creation of other types of print plates, such as for example offset print plates.

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System and method for digital creation of a print master using a multiple printhead unit.

FIELD OF THE INVENTION

- 5 The invention deals with the field of creating print masters, and more specifically with digital methods and systems for creating a digital flexographic print master on a drum by means of a fluid depositing printhead.
- 10 The invention reduces a problem that may result when a printhead unit is used that comprises more than one nozzle row.

BACKGROUND OF THE INVENTION

- 15 In flexographic printing or flexography a flexible cylindrical relief print master is used for transferring a fast drying ink from an anilox roller to a printable substrate. The print master can be a flexible plate that is mounted on a cylinder, or it can be a cylindrical sleeve.
- 20 The raised portions of the relief print master define the image features that are to be printed.

- Because the flexographic print master has elastic properties, the process is particularly suitable for printing on a wide range of printable substrates including
25 for example, corrugated fiberboard, plastic films, or even metal sheets.

- A traditional method for creating a print master uses a light sensitive polymerisable sheet that is exposed by a UV radiation source through a negative film or a negative mask layer ("LAMS"-system) that defines the image
30 features. Under the influence of the UV radiation, the sheet will polymerize underneath the transparent portions of the film. The remaining portions are removed, and what remains is a positive relief printing plate.

- In the applications EP08172281.1 and EP08172280.3, (now published as
35 EP2199066 and EP2199065, respectively) both assigned to Agfa Graphics NV and having a priority date of 2008-12-19, a digital solution is presented for creating a relief print master using a fluid droplet depositing printhead.

- The application EP08172280.3 teaches that a relief print master can be digitally
40 represented by a stack of two-dimensional layers and discloses a method for calculating these two-dimensional layers.

- The application EP08172281.1 teaches a method for spatially diffusing nozzle related artifacts in the three dimensions of the stack of two-dimensional layers.
45

Both applications also teach a composition of a fluid that can be used for printing a relief print master, and a method and apparatus for printing such a relief print master.

FIG. 1 shows an embodiment of such an apparatus 100. 140 is a rotating drum that is driven by a motor 110. A printhead 160 moves in a slow scan direction Y parallel with the axis of the drum at a linear velocity that is coupled to the rotational speed X of the drum. The printhead jets droplets of a polymerisable fluid onto a removable sleeve 130 that is mounted on the drum 140. These droplets are gradually cured by a curing source 150 that moves along with the printhead and provides local curing. When the relief print master 130 has been printed, the curing source 170 provides an optional and final curing step that determines the final physical characteristics of the relief print master 120.

An example of a printhead is shown in FIG. 3. The printhead 300 has nozzles 310 that are arranged on a single axis 320 and that have a periodic nozzle pitch 330. The orifices of the nozzles are located in a nozzle plate that is substantially planar.

FIG. 2 demonstrates that, as the printhead moves from left to right in the direction Y, droplets 250 are jetted onto the sleeve 240, whereby the "leading" part 211 of the printhead 210 prints droplets that belong to a lower layer 220, whereas the "trailing" part 212 of the printhead 210 prints droplets of an upper layer 230.

Because in the apparatus in FIG. 1 and 2 the linear velocity of the printhead in the direction Y is locked with the rotational speed X of the cylindrical sleeve 130, 240, each nozzle of the printhead jets fluid along a spiral path on the rotating drum. This is illustrated in FIG. 5, where it is shown that fluid droplets ejected by nozzle 1 describe a spiral path 520 that has a pitch 510.

In FIG. 5, the pitch 510 of the spiral path 520 was selected to be exactly double the length of the nozzle pitch 530 of the printhead 540. The effect of this is that all the droplets of nozzles 1, 3, 5 having an odd index number fall on the first spiral path 520, whereas the droplets ejected by nozzles 2, 4, 6 having an even index number fall on the second spiral path 550. Both spiral paths 520 550 are interlaced and spaced at an even distance 560 that corresponds with the nozzle pitch 530.

The lowest value of the nozzle pitch 330 in FIG. 3 is constrained by technical limitations in the production of a printhead. One solution to overcome this constraint is to use a multiple printhead unit.

The concept of a multiple printhead unit is explained by means of FIG. 4. As the figure shows, two printheads 401 and 402 are mounted to form a multiple printhead unit 400. The nozzle rows 420 and 421 are substantially parallel. By staggering the position of the nozzles 410 on the axis 420 of head 401 and the nozzles 411 on axis 421 of printhead 402 over a distance of half a nozzle pitch, the effective nozzle pitch 431 of the multiple printhead unit is half the nozzle pitch of each constituting printhead 401, 402 and the effective printing resolution is doubled.

The use of a multiple printhead unit in an apparatus as shown in FIG. 1 or FIG. 2 for the purpose of printing a relief print master introduces an unexpected and undesirable side effect.

- 5 FIG. 6. shows a first spiral path 610 on which fluid droplets from the nozzles having an odd index number 1, 3 and 5 land and a second spiral path 611 on which the fluid droplets of the nozzles having an even index number 2, 4 and 6 land.

- 10 The nozzles with an odd index number are located on a first axis 620 and the nozzles having an even index number are located on a second axis 621, parallel with the first axis 620.

- Because these two axes 620 and 621 of the nozzle rows in the multiple printhead unit are not congruent, the spiral paths 610 and 611 are not evenly spaced with regard to
15 each other. For example, in FIG. 6 the distance 640 is different from the distance 641.

- The uneven spacing of the spiral paths 610 and 611 causes an uneven distribution of the fluid droplets along the Y direction when they are jetted onto the sleeve and this negatively affects the quality of the print master that is printed.

- 20 Any discussion of the prior art throughout the specification should in no way be considered as an admission that such prior art is widely known or forms part of common general knowledge in the field.

- 25 It is an object of the present invention to overcome or ameliorate at least one of the disadvantages of the prior art, or to provide a useful alternative.

- An object of a preferred form of the invention is to improve the evenness of the distribution of the spiral paths on which the fluid droplets are jetted by a printhead unit
30 that comprises multiple printheads.

SUMMARY OF THE INVENTION

- According to a first aspect, the present invention provides a system for preparing a print
35 master by means of a marking engine, the system comprising:

- a cylindrical support having a central axis;

- a marking head unit for marking at least one layer of marks on the cylindrical support,
 - o whereby the cylindrical support rotates around its central axis relative to the marking head unit at a first speed, said rotation defining a first speed vector that is tangential to the cylindrical support;
 - o whereby the marking head unit moves along a slow scan direction parallel with the central axis at a second speed that is locked to the first speed, said motion defining a second speed vector;
 - o whereby the angle between the first speed vector and the sum of the first and the second speed vectors has a value α ;
 - o whereby the marking head unit comprises at least two parallel rows of marking elements that can create marks along interlaced spiral paths around the central axis, the distance between the parallel rows of marking elements introducing uneven spacing between the spiral paths;

wherein:

- the rows of marking elements are rotated by an angle β in a plane that is parallel with the first and second speed vectors, whereby the rotation takes place in a direction that is orthogonal with the tangent of the spiral paths so that the uneven spacing between the spiral paths is reduced or eliminated.

According to a second aspect, the present invention provides a method for preparing a print master by means of a marking engine that comprises a marking head unit, the method comprising the steps of:

- marking with the marking head unit at least one layer of marks on a cylindrical support, the cylindrical support having a central axis,
- rotating the cylindrical support around the central axis relative to the marking head unit at a first speed, said rotation defining a first speed vector that is tangential to the cylindrical support;
- moving the marking head unit at a second speed in a slow scan direction that is parallel to the central axis and that is locked to the first speed, said moving defining a second speed vector;
- whereby the angle between the first speed vector and the sum of the first and second speed vectors has a value α ;
- whereby the marking head unit comprises at least two parallel rows of marking elements that can create marks along interlaced spiral paths around the central

axis, the distance between the parallel rows of marking elements introducing uneven spacing between the spiral paths;

wherein the method comprises an additional step of:

- 5 - rotating the rows of the marking elements by an angle β in a plane that is parallel with the first and second vectors, whereby the rotation takes place in a direction that is orthogonal with the tangent of the spiral paths so that the unevenness of the spacing between the spiral paths is reduced or eliminated.

10 According to a third aspect, the present invention provides a print master when prepared by a method according to the second aspect.

Unless the context clearly requires otherwise, throughout the description and the claims, the words "comprise", "comprising", and the like are to be construed in an inclusive sense as opposed to an exclusive or exhaustive sense; that is to say, in the
15 sense of "including, but not limited to".

The invention is realized by means of a system and a method as described in the independent claims.

20 By rotating the multiple printhead unit in the plane that is perpendicular with the jetting direction of the nozzles, the unevenness of the distances between the interlaced spiral paths can be reduced or even eliminated.

Various embodiments are found in the dependent claims.
25

DRAWINGS

FIG. 1 shows an embodiment of an apparatus for printing a relief print master on a sleeve.
30

FIG. 2 shows a different view of an embodiment of an apparatus for printing a relief print master on a sleeve.

FIG. 3 shows a printhead with a single row of nozzles.
35

FIG. 4 shows a multiple printhead unit with two rows of nozzles.

FIG. 5 shows two spiral paths on which the fluid droplets ejected by the nozzles of a printhead as in FIG. 3 land.

FIG. 6 shows two spiral paths on which the fluid droplets land that are ejected by the nozzles of a multiple printhead unit as the one shown in FIG. 4.

FIG. 7 describes in detail the geometrical interactions between the movements of the printhead and the cylindrical sleeve, and the distance between the spiral paths when the nozzle rows of the printhead are parallel with the axis of the cylindrical sleeve.

FIG. 8 describes in detail the geometrical interactions between the movements of the printhead and the cylindrical sleeve, and the distance between the spiral paths when the nozzle rows of the printhead are rotated in a plane that is orthogonal to the jetting direction of the nozzles.

FIG. 9 shows a preferred embodiment according to the current invention in which the nozzle rows are rotated so that the distances between the spiral paths on which the nozzles eject droplets becomes more even.

DESCRIPTION

In FIG. 6 a rotating sleeve 600 or support that has a diameter 601 represented by the variable **SleeveDiameter**.

The circumference of the sleeve is represented by the variable **SleeveCircumference** and has a value equal to:

$$\text{SleeveCircumference} = \text{PI} * \text{SleeveDiameter}$$

The sleeve rotates in the X direction at a frequency that is represented by the variable **NumberofRevolutionsperSecond**. The direction and magnitude of this rotation with regard to the printhead defines a first speed vector 670 that is tangential to the cylindrical sleeve and perpendicular to its central axis.

The time of one revolution is represented by the variable **RevolutionPeriod**. It is equal to:

$$\text{RevolutionPeriod} = 1 / \text{NumberofRevolutionsperSecond}.$$

The circumferential speed of the sleeve has a value represented by the variable **CircumferentialSpeed** and is equal to:

$$\text{CircumferentialSpeed} = \text{SleeveCircumference} * \text{NumberofRevolutionsperSecond}$$

The distance between two adjacent nozzles along the Y-dimension in the multiple printhead unit in FIG. 6 is the nozzle pitch 630 and is represented by a variable **P**.

The movement of the printhead in the Y direction is locked to the rotation of the sleeve by means of a mechanical coupling (for example by means of a worm and gear) or by means of an electronic gear (electronically coupled servomotors). During a single revolution of the sleeve, the printhead moves over a distance 650 that is represented by a variable **PrintheadPitch**. The value of this distance 650 should be an integer multiple of the nozzle pitch 630 and this multiple is represented by a variable **IntegerMultiplier**:

$$\text{PrintheadPitch} = \text{IntegerMultiplier} * P$$

In FIG. 6 the value of **IntegerMultiplier** is equal to 2.

The speed at which the printhead moves in the Y direction is represented by the variable **PrintheadSpeed**. Its value is equal to:

$$\text{PrintheadSpeed} = \text{PrintheadPitch} / \text{RevolutionPeriod}$$

The speed and magnitude of the printhead defines a second speed vector 671.

The sum of the first speed vector 670 and the second speed vector 671 defines a third speed vector 672. This speed vector 672 is tangential to the spiral path on which the liquid droplets are jetted. The angle α between the first speed vector 670 and the sum 672 of the first and second speed vectors is expressed by the following formula's:

$$\tan(\alpha) = \text{PrintheadSpeed} / \text{CircumferentialSpeed}$$

$$\alpha = \text{atan}(\text{PrintheadSpeed} / \text{CircumferentialSpeed})$$

The distance 660 between the two nozzle rows 620 and 621 in FIG. 6 is represented by the variable **D**.

Unlike in the case shown in FIG. 5 where a printhead has only one row of nozzles, the two spiral paths 610, 611 in FIG. 6 on which droplets land that are ejected from two different nozzle rows are *not* evenly spaced along the Y direction. More specifically, the distance 640 in FIG. 6 is shorter than the distance 641. This effect is the result of the distance **D** 660 between the two nozzle rows 620, 621.

FIG. 7 shows a detail of FIG. 6 that is used for geometrically describing the difference between the distance 640 and the distance 641 in FIG. 6.

In the analysis that follows, it is assumed that the length of the distance **D** is negligible with regard to the length of the **Circumference**. In that case the cylindrical surface of the sleeve can be locally approximated by a plane so that conventional (two-dimensional) trigonometry can be used to describe the geometrical relationships between the different variables.

In FIG 7:

- the distance **P** corresponds with the nozzle pitch 630 in FIG. 6;
- the distance **D** corresponds with the distance 660 between two nozzle rows in FIG. 6;
- 5 - the distance **A** corresponds with the distance 640 between two spiral paths in FIG. 6;
- the distance **B** corresponds with the distance 641 between two spiral paths in FIG. 6.

10 The distance **dY** corresponds with the amount that the distance **A** is shorter than the nozzle pitch **P**, and the amount that the distance **B** is longer than the distance **P**. This is mathematically expressed as follows:

$$\begin{aligned} \mathbf{A} &= \mathbf{P} - \mathbf{dY} \\ \mathbf{B} &= \mathbf{P} + \mathbf{dY} \\ \mathbf{A} + \mathbf{B} &= 2 * \mathbf{P} \end{aligned}$$

The value of **dY** can be directly expressed as a function the angle α and the nozzle row distance **D**:

$$\begin{aligned} \tan(\alpha) &= \mathbf{dY} / \mathbf{D} \\ \mathbf{dY} &= \mathbf{D} * \tan(\alpha) \end{aligned}$$

And hence:

$$\mathbf{A} = \mathbf{P} - \mathbf{D} * \tan(\alpha)$$

The above expression teaches that:

$$\mathbf{A} = \mathbf{P}$$

under the following two conditions:

1. **D = 0** (this is essentially the situation that is shown in FIG. 5)
- 35 2. $\alpha = 0$ (this situation is only approximated when the **PrintheadPitch** is very small with respect to the **CircumferentialSpeed**, which is the case in many practical situations)

The above expression also teaches that **dY** becomes larger when the distance **D** between the nozzle rows increases or when the ratio of the **PrintheadSpeed** over the **CircumferentialSpeed** increases.

We will now describe by means FIG. 8 that it is possible to reduce **dY**, or even to make **dY** equal to zero and hence to make:

$$\mathbf{A} = \mathbf{B} = \mathbf{P}$$

without setting $\alpha = 0$ or setting **D = 0**, but *instead* by rotating the printhead in a plane that is orthogonal to the jetting direction of the nozzles and under a specific angle β . Such a plane is parallel with the

In FIG. 8, the following expression is derived for **dY**:

$$\tan(\alpha - \beta) = dY / D$$

$$dY = D * \tan(\alpha - \beta)$$

By setting:

$$\beta = \alpha$$

it is obtained that:

$$A = P = B$$

In other words, by rotating the printhead over an angle β in a plane that is orthogonal to the jetting direction of the nozzles, whereby the angle β is equal to the angle α , it is obtained that these interlaced paths become equidistant and become spaced at a distance equal to the nozzle pitch.

FIG. 9 gives a further illustration of the invention. By rotating the printhead under an angle β in the plane defined by the two nozzle rows, whereby the angle β corresponds with the angle α , it is possible to equalize the distance 960 between the spiral paths 950 and 951 and to make them equal to the nozzle pitch 940.

The above description provides an exemplary embodiment of the current invention on which a number of variations exist.

In the first place it is not required that the value of **IntegerMultiplier** is equal to 2 as in FIG. 5, 6 or 9. In principle any integer number **N** can be used such as 2, 3, 4 or more. From the above explanation it should be clear to a person skilled in the art that a value of **N** for the variable **IntegerMultiplier** will also result in **N** interleaved spiral paths.

In the second place it is not always required that the angle α and angle β are exactly equal to each other. It was already demonstrated by means of FIG. 7 that if the distance **D** between the nozzle rows is small compared to the circumference of the cylindrical sleeve, that the deviation **dY** is small compared to the distance **P** of the nozzle pitch. In that case a rotation β of the printhead that is less than α provides already a sufficient improvement of the evenness of the distances **A** and **B** between the spiral paths.

Preferably:

$$|\alpha - \beta| < 0.5 * |\alpha|$$

Even more preferably

$$|\alpha - \beta| < 0.1 * |\alpha|$$

And even more preferably:

5 $|\alpha - \beta| < 0.01 * |\alpha|$

10 In the third place, the invention is not limited to a multiple printhead unit that comprises only two rows of nozzles. The number of rows of nozzles can, in principle, be any integer number M (such as 2, 3, 4 or more). In the case that more than two nozzle rows are present, the rotation of each one of the constituting printheads takes preferably place in a plane that is orthogonal to the direction in which the droplets are ejected by each printhead.

15 Whereas the invention has been described in the context of an apparatus for creating a flexographic print master using a printhead that comprises fluid ejecting nozzles, it can just as well be used for other external drum based recording systems that use parallel rows of marking elements.

20 A first example of an alternative recording system is a laser imaging system that uses a laserhead with rows of laser elements as marking elements.

25 A second example of an alternative recording system uses a spatial light modulator with rows of light valves as marking elements. Examples of spatial light modulators are digital micro mirror devices, grating light valves and liquid crystal devices.

30 All these systems can be used for creating a print master. For example, a laser based marking system, a light valve marking system or a digital micro mirror device marking system can be used to expose an offset print master precursor.

35 The invention is advantageously used for creating a relief print master by building up the relief layer by layer using a system such as the one that is shown in FIG. 1 or FIG. 2. A relief print master, however, can also be obtained for example using one of the following embodiments.

40 In a first embodiment an imaging system according to the current invention is used for imagewise exposing a mask so that that it comprises transparent and non transparent portions. The mask is then put on top of a flexible, photopolymerizable layer and exposed by a curing source. The areas that exposed through transparent portions of the mask harden out and define the features of the print master that are in relief. The unexposed areas are removed and define the recessed portions of the relief print master.

45 In a second embodiment, the imaging system according to the current invention selectively exposes a flexible, elastomeric layer, whereby the energy of the exposure directly removes material from the flexible layer upon impingement. In this case the unexposed areas of the flexible layer define the relief features of the print master.

50

CLAIMS

1. A system for preparing a print master by means of a marking engine, the system comprising:
- 5 - a cylindrical support having a central axis;
- a marking head unit for marking at least one layer of marks on the cylindrical support,
- whereby the cylindrical support rotates around its central axis relative to the marking head unit at a first speed, said rotation defining a first speed vector that is tangential to the cylindrical support;
- 10 ○ whereby the marking head unit moves along a slow scan direction parallel with the central axis at a second speed that is locked to the first speed, said motion defining a second speed vector;
- whereby the angle between the first speed vector and the sum of the first and the second speed vectors has a value α ;
- 15 ○ whereby the marking head unit comprises at least two parallel rows of marking elements that can create marks along interlaced spiral paths around the central axis, the distance between the parallel rows of marking elements introducing uneven spacing between the spiral paths;
- 20 wherein:
- the rows of marking elements are rotated by an angle β in a plane that is parallel with the first and second speed vectors, whereby the rotation takes place in a direction that is orthogonal with the tangent of the spiral paths so that the uneven spacing between the spiral paths is reduced or eliminated.
- 25 2. A system according to claim 1, wherein the marking head unit is an inkjet printhead and the marking elements are inkjet nozzles.
3. A system according to claim 1, wherein the marking head unit is a laserhead and the marking elements are laser elements.
4. A system according to claim 1, wherein the marking head unit is a spatial light modulator, and wherein the marking elements are light valves.
- 30 5. A system according to claim 4, wherein the marking head unit is a digital mirror device, and wherein the marking elements are micro mirrors.

6. A system according to any one of the claims 1 to 5, wherein $|\alpha - \beta| < 0.5 * |\alpha|$.
7. A system according to claim 6 wherein $|\alpha - \beta| < 0.1 * |\alpha|$
8. A system according to claim 7 wherein $|\alpha - \beta| < 0.01 * |\alpha|$
9. A system according to any one of the claims 1 to 8, wherein the print master is a
5 relief printmaster.
10. A method for preparing a print master by means of a marking engine that
comprises a marking head unit,
the method comprising the steps of:
 - marking with the marking head unit at least one layer of marks on a cylindrical
10 support, the cylindrical support having a central axis,
 - rotating the cylindrical support around the central axis relative to the marking
head unit at a first speed, said rotation defining a first speed vector that is
tangential to the cylindrical support;
 - moving the marking head unit at a second speed in a slow scan direction that is
15 parallel to the central axis and that is locked to the first speed, said moving
defining a second speed vector;
 - whereby the angle between the first speed vector and the sum of the first and
second speed vectors has a value α ;
 - whereby the marking head unit comprises at least two parallel rows of marking
20 elements that can create marks along interlaced spiral paths around the central
axis, the distance between the parallel rows of marking elements introducing
uneven spacing between the spiral paths;
 wherein the method comprises an additional step of:
 - rotating the rows of the marking elements by an angle β in a plane that is
25 parallel with the first and second vectors, whereby the rotation takes place in a
direction that is orthogonal with the tangent of the spiral paths so that the
unevenness of the spacing between the spiral paths is reduced or eliminated.
11. A method according to claim 10, wherein the marking head unit is an inkjet
printhead the marking elements are inkjet nozzles.

12. A method according to claim 10, wherein the marking head unit is a laserhead and the marking elements are laser elements.
13. A method according to claim 10, wherein the marking head unit is a spatial light modulator and the marking elements are light valves.
- 5 14. A method according to claim 13, wherein the marking head unit is a digital micro mirror device and wherein the marking elements are micro mirrors.
15. A method according to any one of the claims 10 to 14 wherein $|\alpha - \beta| < 0.5 * |\alpha|$.
16. A method according to claim 15 wherein $|\alpha - \beta| < 0.1 * |\alpha|$
- 10 17. A method according to claim 16 wherein $|\alpha - \beta| < 0.01 * |\alpha|$
18. A method according to any one of the claims 10 to 17, wherein the print master is a relief print master.
19. A print master when prepared by a method according to any one of claims 10 to 18.
- 15 20. A system for preparing a print master, a method for preparing a print master or a print master when prepared by the method substantially as herein described with reference to any one of the embodiments of the invention illustrated in the accompanying drawings and/or examples.

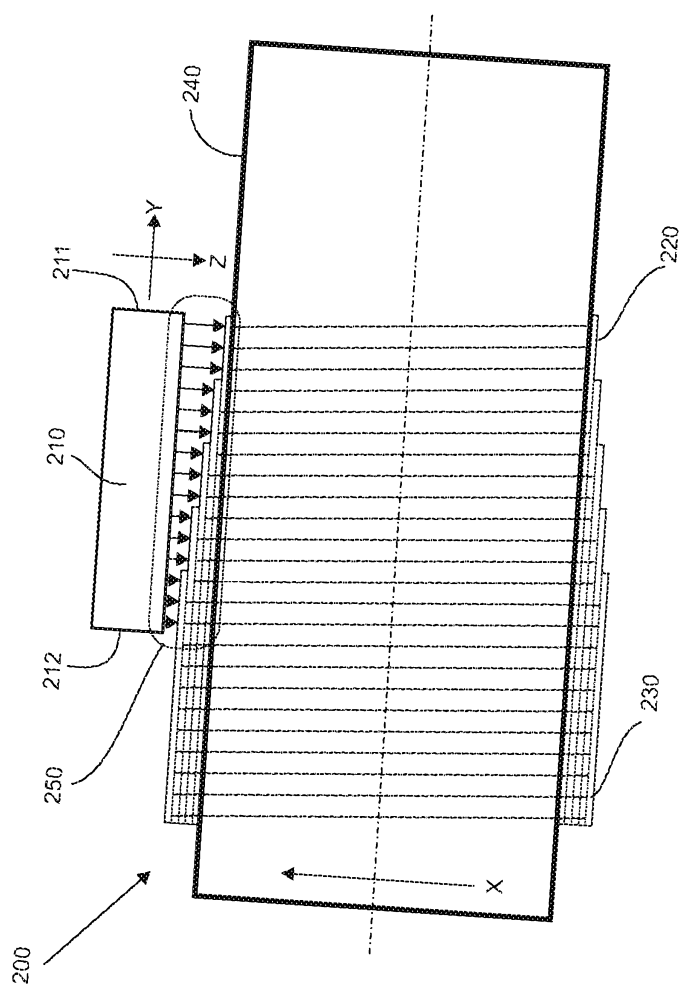


FIG. 2

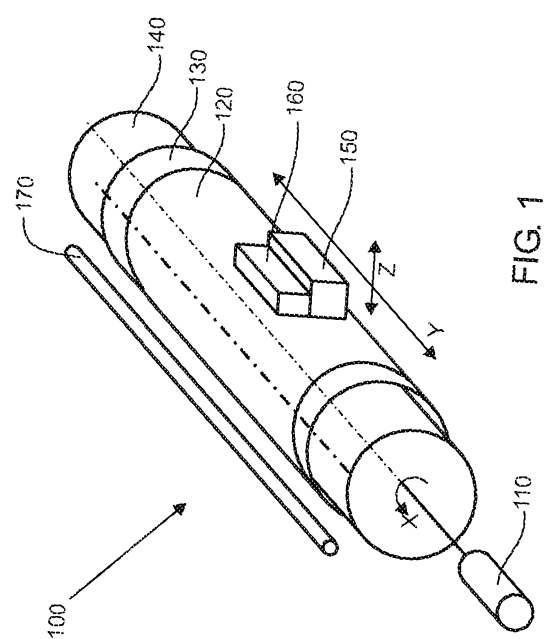


FIG. 1

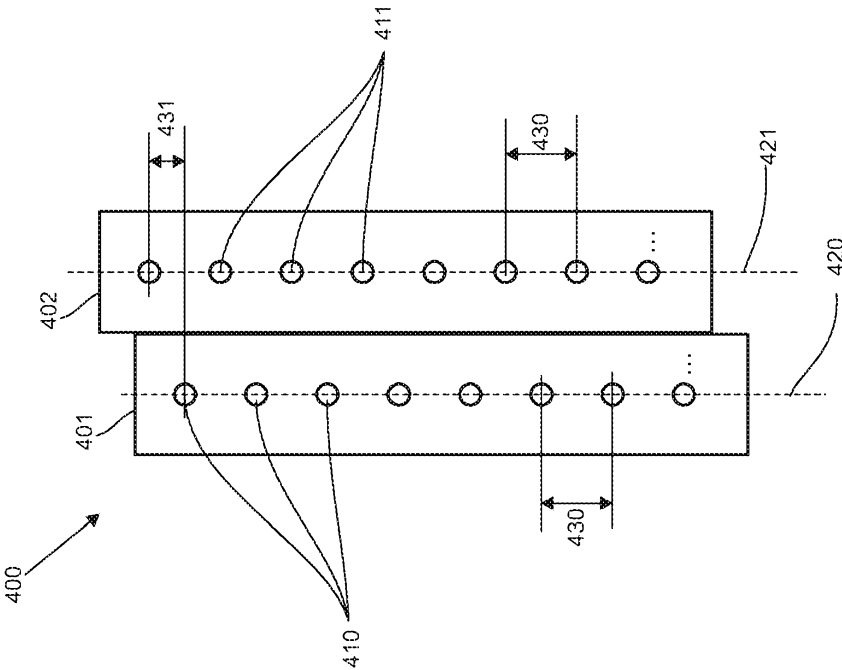


FIG. 4

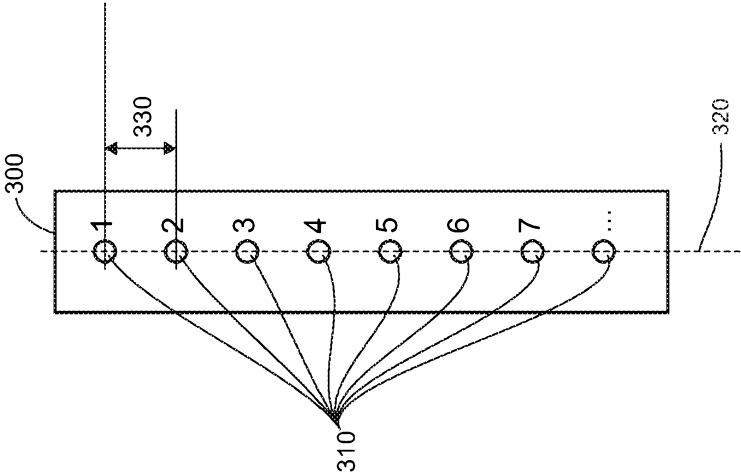


FIG. 3

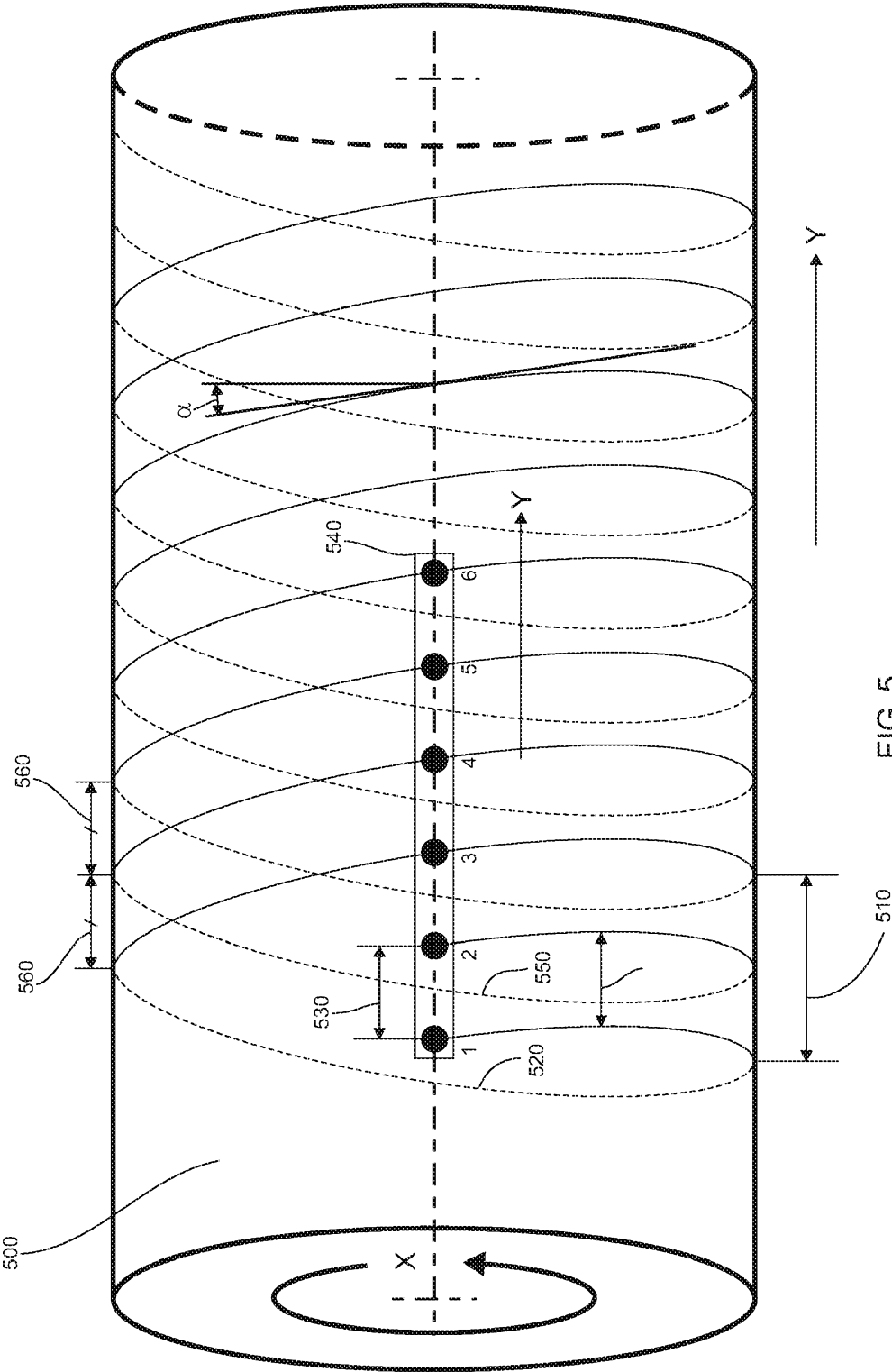
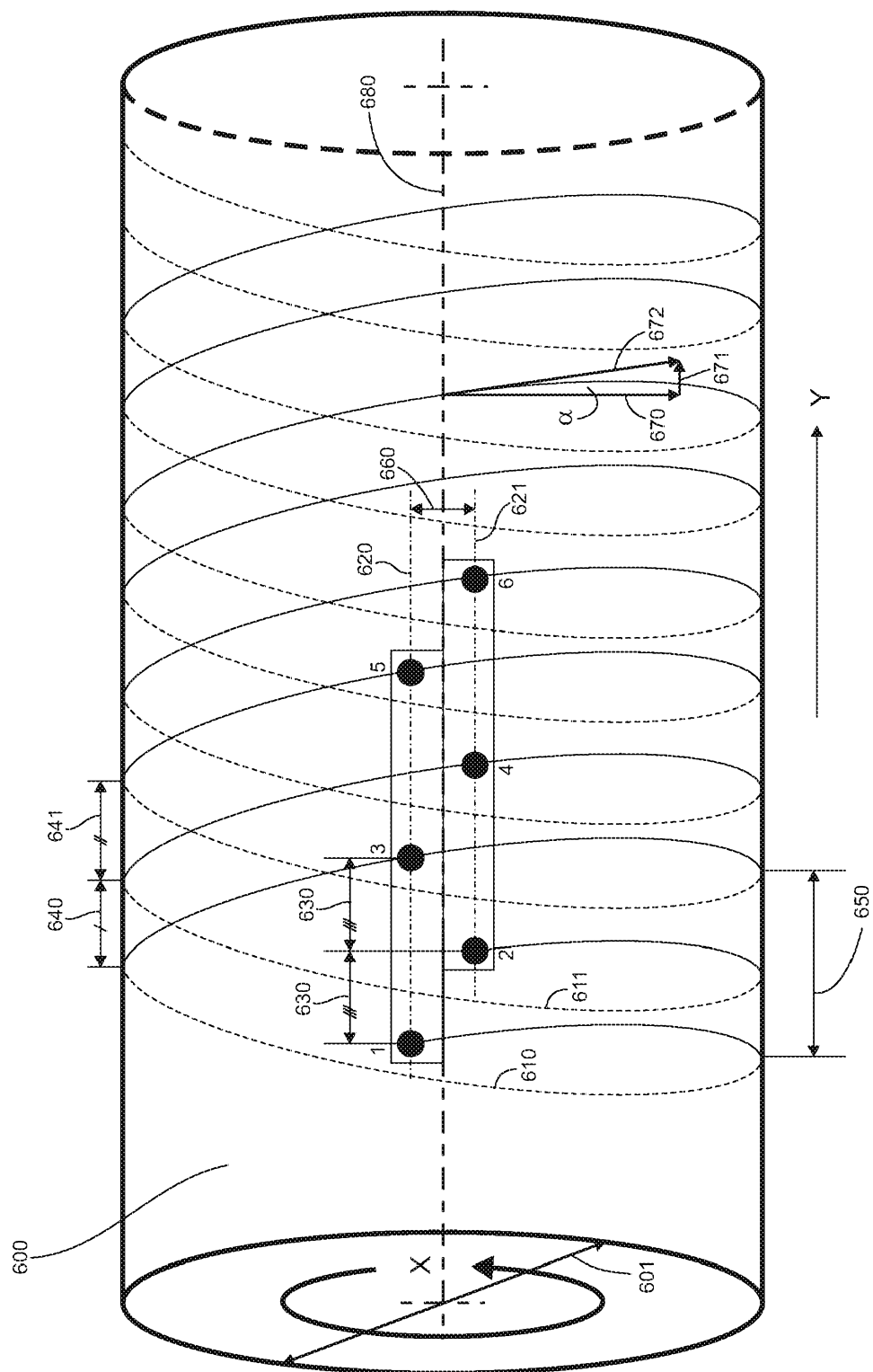
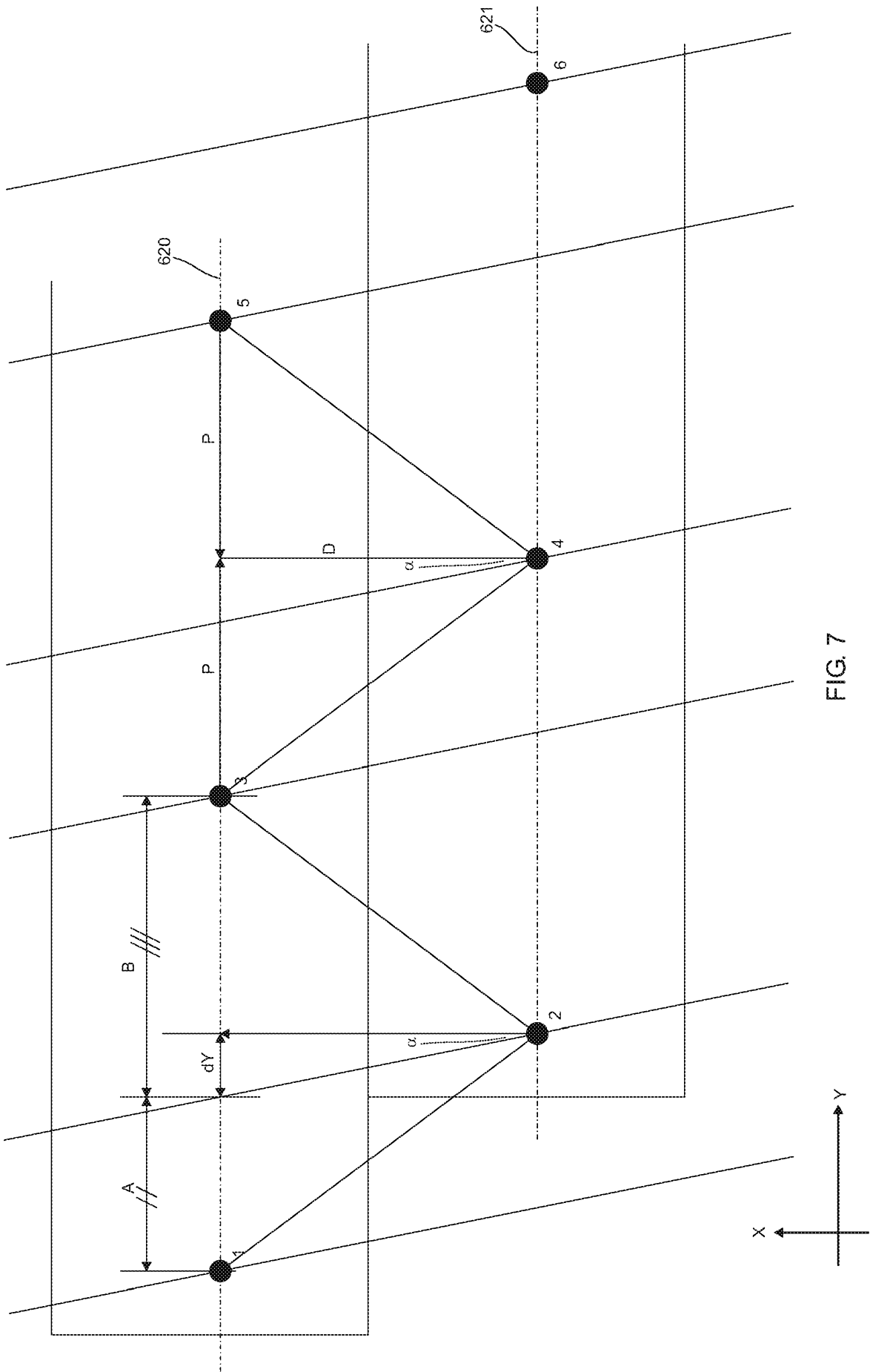


FIG. 5



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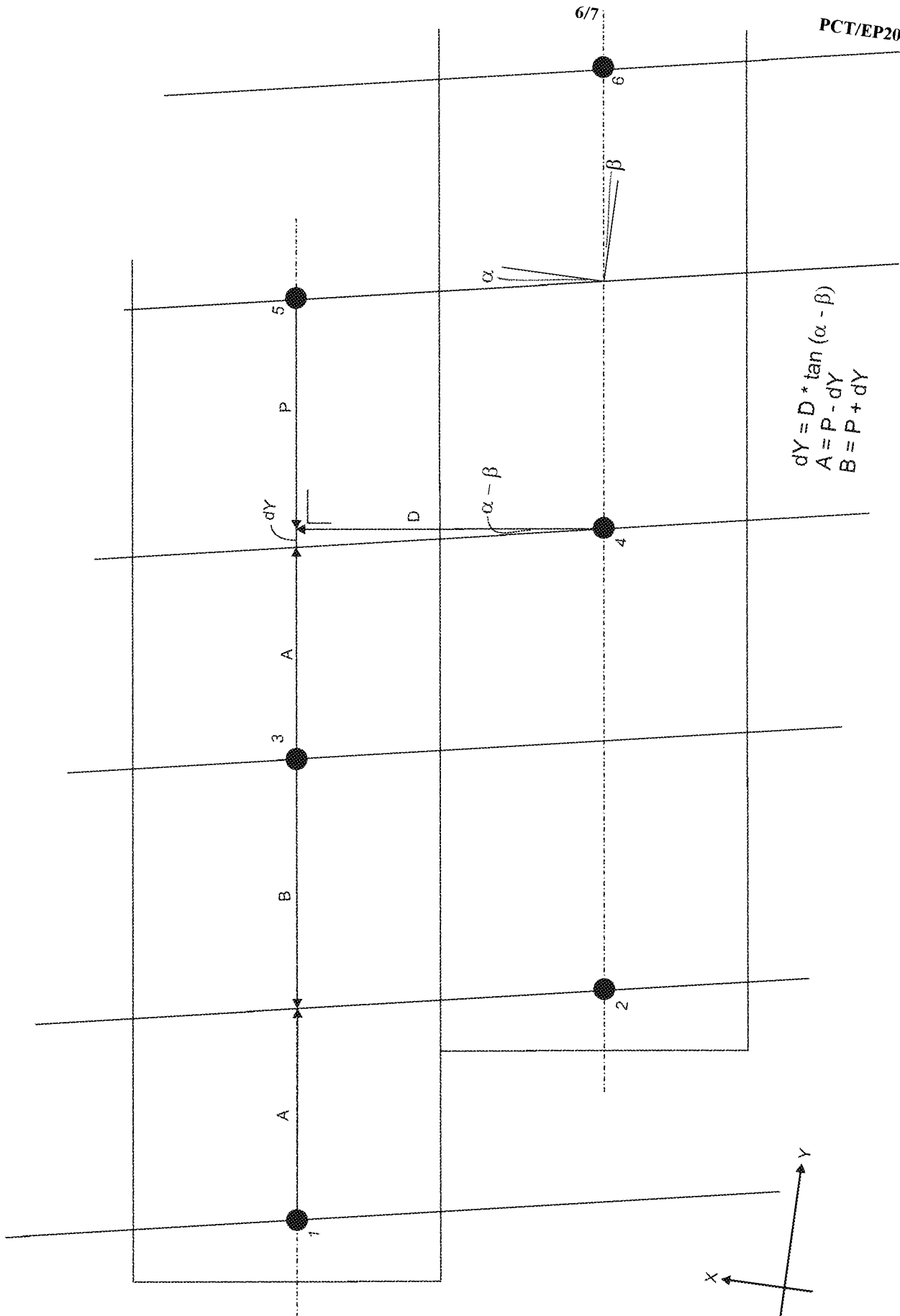


FIG. 8

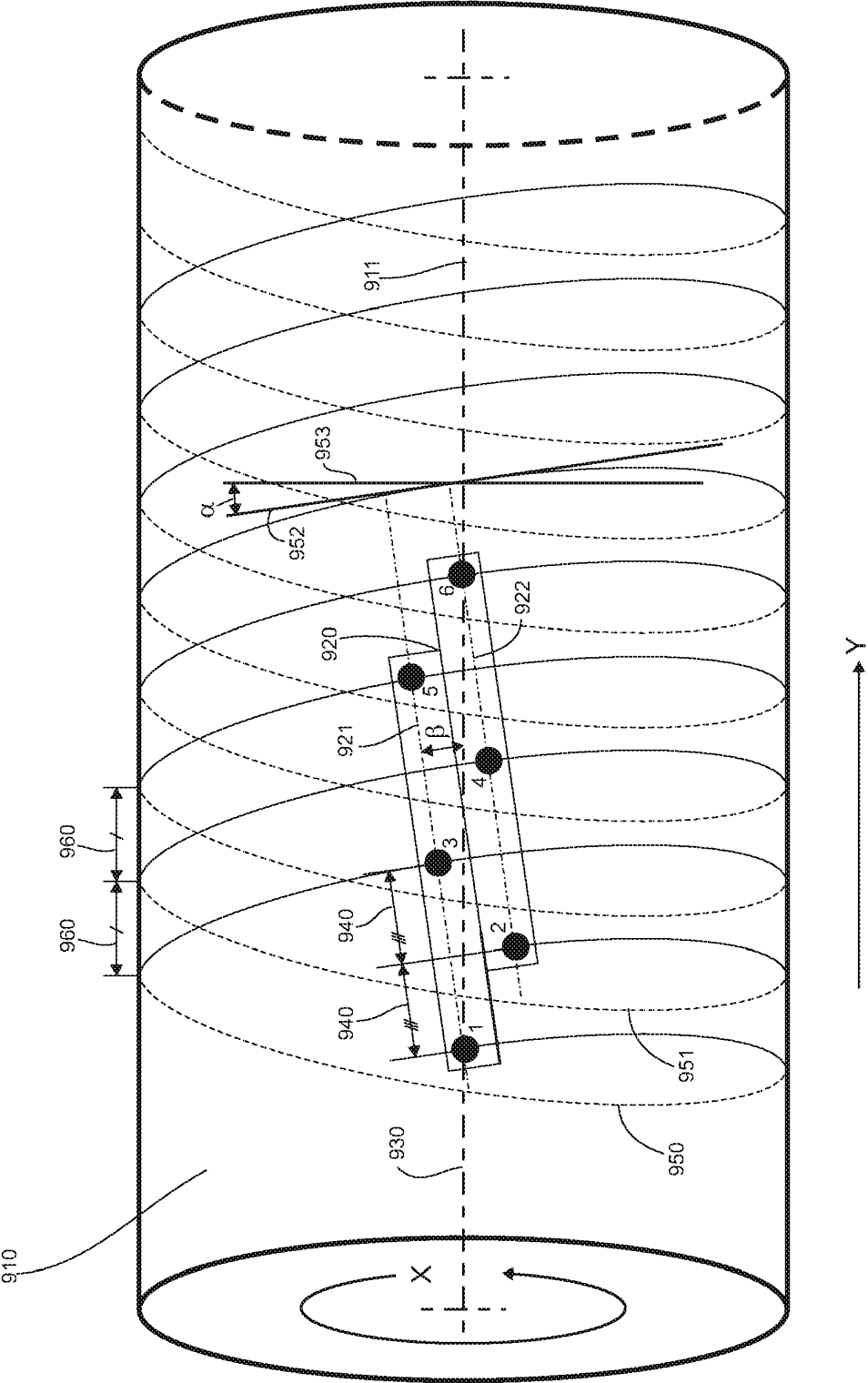


FIG. 9