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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 17155-2022

Replacing GB/T 17155-1997

Plates for offset printing - Dimensions

胶印印版 尺寸

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Foreword

This document was issued on 30 December 2022 by the State Administration for Market Regulation; Standardization Administration of the PRC and takes effect on 1 July 2023.

It is a GB/T standard: recommended rather than compulsory, but it is the text a Chinese reviewer applies when assessing a submission.

It is classified under ICS 37.100.10, Chinese classification J87.

It replaces GB/T 17155-1997, which is superseded.

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for Standardization Work Part 1. Structure and Drafting Rules for Standardization Documents" drafting.

This document replaces GB/T 17155-1997 "Offset Printing Plate Dimensions". Compared with GB/T 17155-1997, except for structural adjustment and editing

In addition to editorial changes, the main technical changes are as follows.

a) Add terms and definitions such as cutting burr, edge waviness, edge straightness, and

printing plate base (see 3.1, 3.4, 3.5, 3.6);

b) Deleted the term and definition of plate length (see 2.2 of the.1997 edition);

c) Changed the printing plate size requirements (see 4.2, 3.2.1 of the.1997 edition);

d) Delete the eyelet requirement (see 3.2.2 of the.1997 edition);

e) Requirements for rectangularity, CTP edge waviness, CTP printing plate cutting burr, and CTP edge straightness are added (see

4.3, 4.4, 4.5, 4.6);

f) The nomenclature and marks are deleted (see Chapter 4 and Chapter 5 of the.1997 edition);

g) Deleted the standard measurement environment (see Appendix A of the.1997 edition).

This document is equivalent to ISO 12635:2021 "Printing Technology Offset Printing Plate Dimensions".

The following minimal editorial changes have been made to this document.

--- In order to coordinate with existing standards, change the name of the standard to "Offset printing plate size";

--- Added Appendix NA (informative).

This document is proposed by China Machinery Industry Federation.

This document is under the jurisdiction of the National Printing Machinery Standardization Technical Committee (SAC/TC192).

This document is drafted by. Shenzhen Vocational and Technical College, Shanghai Tobacco Packaging and Printing Co., Ltd., Guangzhou Tiansheng Printing Co., Ltd., Hubei

Jinghua Color Printing Co., Ltd., Agfa (Wuxi) Printing Plate Co., Ltd., Beiren Intelligent Equipment Technology Co., Ltd., Guangzhou Qiancai Paper Printing Co., Ltd.

Co., Ltd., Zhuhai Huijin Quality Standard Technology Co., Ltd., Ruian Chuangbo Machinery Co., Ltd., China Printing Science and Technology Research Institute Co., Ltd.

Division, Beijing Institute of Printing, Beijing Gaoke Printing Machinery Research Institute Co., Ltd.

The main drafters of this document. Zhang Xuliang, Li Gang, Chen Yangyang, Yu Jie, Chen Yongcheng, Hu Chao, Chen Guizhen, Zhang Ming, Xue Zhicheng, Sun Tiejun, Wu Wei,

Feng Xugao, Bi Mingzhu, Li Xia, Zheng Mengjun, He Xiaohui, Pu Jialing, Peng Ming, Yang Qian.

This document was first published in.1997, and this is the first revision.

Introduction

This document specifies the dimensional characteristics of printing plates for offset printing. While not all existing plate sizes conform to this document, the size specifications are intended to

In reducing the number of possible specifications to a reasonable level, thereby simplifying the manufacturing process, and facilitating printing plate, plate making machine and printing press manufacturers and printing presses.

Brush the exchange between enterprises.

In this revision, preferred plate sizes were introduced. Whenever possible, these were chosen to represent the most widely used plate sizes. well known

It is known that other sizes are also required for some printing jobs.

Offset printing plate size

1 Scope

GB/T 17155-2022 covers the dimensions of metal lithographic plates for offset printing - their width, length and thickness - and, for plates imaged on computer-to-plate equipment, the geometry of the plate edge as well: rectangularity, edge waviness, cutting burrs and edge straightness. The requirements are stated together with the measurement conditions under which they hold, and annexes give test methods for waviness, for burr height and for straightness, along with lists of preferred plate sizes and an ordering list. The same requirements apply to plate bases. The sizes are constrained deliberately: cutting the number of formats in circulation down to a workable set is what lets a plate, a platesetter and a press from different suppliers be used together, and lets a printer order a replacement without measuring the one already on the cylinder. The edge tolerances matter for a different reason. A CTP plate is gripped, punched and clamped by machinery along its edges, so a plate that is out of square, wavy at the edge or carrying a burr from the shear feeds badly and registers badly. The fault then surfaces as colour misregistration and spoiled sheets rather than as anything an operator can see on the plate. Written for plate manufacturers, platesetter and press builders, and printers specifying plate supply.

This document specifies the width, length and thickness of metal lithographic printing plates (hereinafter referred to as "plates"). For computer-to-plate

Plates used in (CTP) also specify flatness, edge straightness and burr requirements. These requirements also apply to printing plate bases.

2 Normative references

This document has no normative references.

3 Terms and Definitions

The following terms and definitions apply to this document.

3.1

cutting burr cuttingburr

A protrusion formed by cutting, especially with a dull knife, along the edge of a printing plate.

3.2

Plate width platewidth

The size of the printing plate parallel to the axial direction of the cylinder (plate clamping edge).

3.3

Plate thickness platethickness

Plate thickness after coating.

3.4

edge waviness

The degree to which the edge of the printing plate conforms to the plane of measurement.

3.5

Draw a straight line parallel to the axial direction of the cylinder (plate clamping edge) from the corner of the printing plate, the maximum deviation of the straight line from the edge of the printing plate.

3.6

Printing plates based on unprocessedplates

Plates from the manufacturer.

4 requirements

4.1 Measurement conditions

The measurement shall be carried out when both the measuring instrument and the printing plate have reached a stable temperature of 21°C +/- 1°C.