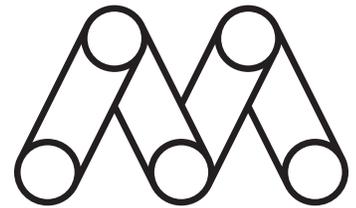


PRINTING ON CHROMOLUX COLOR, PEARL, METALLIC, MAGIC AND ALU



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Chromolux papers have been sealed with a very glossy coating preventing any absorption of ink into the sheet. This is different than the traditional Chromolux surface. It is imperative to follow the suggestions below to achieve optimal performance.

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PAPER HANDLING & STORAGE

The acclimation of Chromolux to press room conditions is recommended for at least 24 hours prior to printing. Keep paper in original packaging until ready to use. Paper should be printed and converted at room temperature (59-77°F, 15-25°C) with relative humidity at 40-60%.

Since these sheets have mirror-like gloss and are ultra smooth, even the slightest surface scratches can be noticeable. Therefore, when printing the back-side either first or last make sure you regularly check the front side for scratches caused by feed belts, guides, leaders, slow down wheels etc. on the press. Great care should also be exercised in finishing operations to avoid marring the surface.

UV INK SYSTEMS

UV inks are highly recommended with inter-station curing which aids in dry ink trap.

This sheet will run in much the same manner as any coated sheet or synthetic substrate.

If post curing and using opaque white as a base for process colors, the white has to be cured first.

OFFSET INKS

Have your ink supplier formulate inks specifically for this sheet. Use inks that dry by oxidation and allow ample time to dry between passes or converting; this can be from 24-48 hours.

Because there is no absorption, wet trapping is more difficult if there is too much under color.

PRESS CONDITIONS

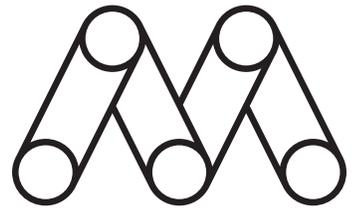
Chromolux is not recommended for use with the waterless printing process.

Keep dampening to a minimum. The sheet will not remove excess fountain solution from the blankets, thus increasing the risk of ink emulsification. Emulsified inks will not give optimum print results and will slow down ink drying even further.

All fountain solution etches are buffered today to a given pH. pH values of 5.0 or greater may aid in reducing ink emulsification properties. Consult with your etch supplier for an etch that is most suited for a non-porous substrate.

In light take-off areas, ink consumption may be insufficient to prevent emulsification. Print color bars or patches in trim areas to move more ink through the ink train.

continued



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Printing on Chromolux, continued

Use small lifts no more than 3-4" high to prevent offsetting. We recommend trayng the job on press.

It is advisable to aqueous coat in-line depending on the amount of under-color. Too much ink under the aqueous coating can cause it to craze or crackle as it dries quickly over the wet ink. If this happens, it is immediate and would mean the coating will need to be done as a second pass.

If not aqueous coating in-line, anti-offset powder must be used. The use of 25-30 micron spray powder is recommended. The volume of spray powder needed and running smaller lifts will depend on the amount of print coverage.

As soon as the ink has set-up sufficiently for sheet handling, we suggest re-piling and winding the loads to speed up the drying process.

Keeping both the feedboard and feed belts clean will reduce marring and scuffing of sheet surface. Additionally, inspection and replacement of any frayed or rough belts prior to running will eliminate this marring/scuffing. Keep the pressure as light as possible on the feedboard wheels, especially the ones in contact with the top when it stops at the head stops and the sheet under it is still moving forward. Slowing the press down can help.

Clean all the feed guides and perhaps use a light coat of wax or silicone where they contact the sheet.

If scuffing or light scratching occurs on the finished job, aqueous or UV coating the sheet will normally clear up any surface blemish.

FINISHING

To avoid marring the surface, exercise great care in handling during finishing. Chromolux is excellent for embossing and foil stamping. Consult with your coating supplier to be sure that the coating you have selected is compatible with finishing processes.

SCORING AND FOLDING

For best results, score before folding; scoring on press is not recommended.

Follow the grain direction for working folds. Stationary folds should run across the grain.

Use a roundnose or bullnose rule that is two times wider than the thickness of the stock. To soften a score, try placing a thin polyester film mylar over the metal score.

To prevent breaking and cracking of the ink along the fold line, avoid scoring or folding over printed areas. Mohawk cannot guarantee that there will be no cracking on a fold placed directly through a solid printed area.

Use a bulking dummy to ensure proper placement of scores for spines and hinges and make sure the spine is the appropriate size for the contents.

It is recommended that a die cut proof be completed before printing the job. The sheet has a film surface and therefore may die cut differently than coated cover stock.

For more information and samples, please call your local merchant or Mohawk at 1 800 the mill.

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