

Flexographic Print Guidelines



Presses

- Ten-color PCMC (Paper Converting Machine Company)
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Type and line size

- Minimum type size (in comparison to Helvetica typeface)
 1. Positive: 4 point Regular [.005"] (minimize horizontal scaling and condensed type)
 2. Reverse: 6 point Bold [.012"] (no condensed or horizontally scaled type)
- Minimum line size
 1. Positive: .005 inch (.3603 point)
 2. Reverse: with machine direction: .0139 inch (1 point)
against machine direction: .01695 inch (1.25 point)

Please do not reverse type out of process areas without a minimum .0139 inch (1 point) outline. A minimum of .01695 inch (1.25 pt.) is recommended for drop shadows. If any thinner, then the probability of misregistration will increase.

For reversed or small sized type: a non-condensed, sans-serif typeface is recommended. Serif, compressed, condensed, or horizontally scaled typefaces may necessitate the need for larger size type. Positive type can overprint process areas if there is sufficient contrast (ex. black, dark blue, dark green).

Trap size

- Standard color to color trap size: .0156 inch (1/64" or 1.1232 point) [minimum trap size: .010"]
- Minimum key line (holding line): .0139 inch (1 point)
(When using the minimum key line [holding line] of 1pt., the chance of misregistration is greater.)

Vignette range

- 1% - solid @ 120 - 175 lpi screen (based on web width and graphic requirements)
- Glenroy recommends using digital photopolymer plates for better print quality of screens.

Printed Codes

- Recommended minimum Universal Product Code (UPC) print size
 1. 90% size, if non-truncated
 2. 100% size, if truncated
- Position- In order to minimize bar code scanning problems, position the bars running with the direction of the printed web, not perpendicular to it.
- Color- The optimum combination is black on a white background. Do not print symbol bars in red or any color that is predominantly red. Dark blue, dark green, and dark brown bars on a white background are other options.
- Other codes (Data Matrix, RSS)- please call to discuss.

Color Matching

- Spot- Glenroy will use a customer approved ink sample as a guide for printing.
- Process- Glenroy will use a customer signed off contract proof as a guide for printing.

Please take into account the substrate tint and its effect on ink color matching.

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Proofs

- Line and simple screen art- Multiple layer (color key) proofs or single layer (HP inkjet) proofs will be produced. Glenroy will need to receive a customer signed off proof before printing. These proofs are meant for viewing copy, color breaks, sizing, and positioning. They are not accurate for color.
- Process art and vignetted spot colors- Analog or digital contract proofs approximating our press gain in screened areas will be produced. These proofs cannot show press gain in type, line, or reversed areas. They are not an exact representation of final color but will be used as a guide along with the approved ink samples. Glenroy will need to receive a customer approved contract proof before printing.

Please be aware that proofing systems reproduce artwork in a different manner than flexographic printing and therefore will not be an absolute match with the printed product.

Plate Break

- Manufactured plate break- When flat flexographic plates are wrapped around the print cylinder, there is a naturally occurring plate break where the two ends join together. On a full bleed image, the minimum manufactured plate break is .0625" (1/16"). If needed, a cover plate can be printed over the plate break. This cover plate will have to run on a separate print station.
- Seamless plates- If there needs to be no plate break appearing on the print web, Glenroy can use a specially prepared seamless photopolymer print sleeve. This type of sleeve does add to the time and cost of the plates and does not have the same specification parameters as a flat plate. In some instances, graphic elements may limit the use of a seamless sleeve.

Electronic Art Guidelines

Macintosh application programs

- Adobe Illustrator
- Adobe Photoshop
- Adobe InDesign
- QuarkXPress

FreeHand and PageMaker files can be worked with as well. PC files can be accepted, however they will potentially add to the production time of our prepress/plate suppliers. Please convert type to outlines (paths), and include the original PC fonts on your disk.

Items that need to be supplied

- Color hard copy proof from the file (or a PDF when e-mailing).
(100% size, with notes indicating screen values and colors, identify FPO's)
- ALL screen and printer fonts used in the design (including EPS files)*
(avoid True Type if possible and avoid setting type in Photoshop)
- ALL EPS, TIFF, or linked files including low res TIFF files-FPO's*
(For hi-res scans use a minimum of 240 ppi [120 lpi screen used on plate]. Please do not embed files.)
- ALL third-party Quark XTensions used*.
- Package layout of how graphics will be utilized:
(positioning, size, bleeds, die lines, eye spots, etc.)
- List of application programs and versions used in creating artwork.
- If sending a previously trapped file, please include a copy of the original, untrapped file.
- Sending a print sample along can help with understanding print expectations.

* Not including these items may make the job unworkable until they are received.

Please send copies, do not send the original files.

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Sending files

- Compact Disks- Please label disks with company name, contact, project name, and date.
- E-mailed attachments (GraphicsMail@glenroy.com)
We recommend compressing the files (with StuffIt, ZipIt) prior to sending. When sending a file via e-mail, please include an Adobe Acrobat PDF file in lieu of a hard copy proof.
- We can retrieve art posted to an FTP site. Please e-mail appropriate information (address, user name, password) and include a PDF file.

Questions

- If there are any questions regarding these specifications, please contact Glenroy Graphics Engineering or Customer Service at **800-824-1482**