



## NEENAH® FOLDING BOARD PAPERS PRODUCTION TIPS

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**NEENAH® Folding Board Papers** are easy to print on when following these simple tips. It is recommended to pretest all printing procedures prior to press time to ensure the desired results are achieved. Sample sheets are available through authorized Neenah merchants or by contacting our sample department at 800-994-5993.

**Storage/Handling:** Papers need to acclimate to pressroom conditions at least 24 hours before opening. Pressroom humidity should be in a range of 40-55% at 70-75 F. Once open, rewrap unused product.

**Prepress:** As a general rule, imagery should be adjusted in prepress to compensate for the additional 5-15% tone value increase that will occur. The precise amount of undercolor removal is image-specific. Total area coverage should not exceed 300%. When printing on NEENAH® Folding Board Pearlized Papers, the total coverage should be kept under the 260% range. For Soft Touch finish the total coverage should not exceed 280% and not cover more than 50% of the entire sheet. Limit three quarter tone imagery.

**Ink/Printing:** The use of opaque light inks on dark stocks may require an in-line double pass. Metallic inks work well and deliver successful results. Anticipate a dry-back of 5-7 density points. Printing on Pearlized and Soft Touch Papers requires fully oxidizing inks and a drying agent is recommended. Run water at a minimum, with a pH of 5-6. Use a 20/30 micron spray powder for two sided printing and 40/50 micron spray powder for single sided printing. This prevents set-off and allows oxygen to enter the stack. Small lifts (not to exceed 4" in height), and additional drying time are necessary prior to other converting steps. When printing on Soft Touch finish it is recommended to fan paper prior to printing. It is normal for a minimal amount of pearlized surface coating particles to transfer to the printing blankets. However, they should not impede the print production and are cleaned effectively with typical blanket washing devices. The unique pearlized surface will be visible through the printed image. Visible pearlized particles may contrast with heavy dark solid areas. Pretesting is recommended to achieve desired results.

**Varnish:** Low solvent (0-5%) varnish can be used as a surface protector. It will not alter nor enhance the appearance of NEENAH® Folding Board. Your ink supplier is the best resource. If using NEENAH® Folding Board Pearlized and Soft Touch Papers an off-line fully oxidizing varnish is recommended. It will not enhance the appearance and in some cases may alter the pearlized and soft touch effect. Pretesting is recommended to achieve desired results.

**Aqueous Coating:** Aqueous coating can be used as a surface protector. It will not alter nor enhance the appearance of NEENAH® Folding Board. When used, aqueous coating should be applied to both sides of the sheet to prevent curl. Aqueous coating may lessen the visual effect for Pearlized and Soft Touch Papers. Pretesting is necessary. Your ink supplier is the best resource.

**Embossing:** NEENAH® Folding Board embosses and debosses beautifully.



## NEENAH® FOLDING BOARD PAPERS PRODUCTION TIPS (Continued)

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**Foil Stamping:** We recommend the use of wax-free litho inks when combining offset lithography and foil stamping to ensure the best results and the maximum adhesions of foil to ink. When utilizing pearlized papers, foils compatible with non-porous substrates are recommended. Pretest to determine the proper foil, heat conditions, and pressure required for the best results. When utilizing Soft Touch, slip sheeting the final pieces at every stage is recommended. Copper or brass dies are recommended. Large areas of foil coverage are not recommended. Due to the density of 24pt, single-level dies are better suited for foil embossing and blind embossing. A two-step process (stamp, then emboss) will yield best results for foil embossing on the 24pt sheet. Pretesting is recommended.

**Folding/Scoring:** A letterpress channel score parallel to the grain direction is recommended to ensure a smooth crease.

- 16pt** score/fold recommendation – 2pt rule with a matrix or counter channel .047" wide x .02" deep
- 18pt** score/fold recommendation – 2pt rule with a matrix or counter channel .064" wide x .022" deep
- 24pt** score/fold recommendation – 3pt rule with a matrix or counter channel .092" wide x .028" deep

**Digital Printing:** Our Universal Digital Finish is compatible with all digital presses. NEENAH® Folding Board Soft Touch is not recommended for digital printing. For more information on digital printing and presses visit: [neenahpaper.com/digital](https://neenahpaper.com/digital)

**Trimming/Die-Cutting:** A sharp blade will ensure a clean cut through the stock; a dull blade could tear the stock.

**Binding:** Binding should be parallel to the grain to prevent moisture buckling and minimize wear on the crease. For Pearlized Papers PUR adhesives may be required. Pretest for best results.

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**Note:** *These production tips should be used as general guidelines and are not inclusive of all printing and finishing methods. Neenah recommends always pretesting for desired results prior to full production.*