



## CLASSIC COLUMNS® PAPERS PRODUCTION TIPS

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**CLASSIC COLUMNS® 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 with uncoated paper, 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 320%.

**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 to 7 density points.

**Varnish:** Low solvent (0–5%) varnish can be used as a surface protector; it will not alter nor enhance the appearance of CLASSIC COLUMNS® Papers.

**Aqueous Coating:** Aqueous coating can be used as a surface protector; it will not alter nor enhance the appearance of CLASSIC COLUMNS® Papers. Most printers will only use aqueous coating on heavier weight stocks and only with a special formulation for uncoated papers to avoid possible paper curl. Pretesting is necessary.

**Web Offset:** CLASSIC COLUMNS® Papers requires no special considerations when printing heat-set web.

**Embossing:** CLASSIC COLUMNS® Papers, Text and Cover, embosses and debosses beautifully on all weights. The die's impression will smooth the laid finish, resulting in a dramatic contrast between the two.

**Engraving:** Engraving inks need no special treatment. Best results come with a female plate of .064 gauge copper and handcut male counter plate of 24-ply counter board applied with 2,000–4,000 pounds of pressure. Pressure range is dependent upon complexity of copy. Precision when cutting a counter requires less pressure and enhances the image.

**Foil Stamping:** Foil stamping on CLASSIC COLUMNS® Papers yields striking results. We recommend the use of wax-free litho inks when combining offset lithography and foil stamping to ensure the best results and the maximum adhesion of foil to ink. For best results, stamp directly onto CLASSIC COLUMNS® Papers using new foils.

**Thermography:** CLASSIC COLUMNS® Papers accepts thermography beautifully. No special considerations are needed.



## CLASSIC COLUMNS® PAPERS PRODUCTION TIPS (Continued)

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**Non-Impact Printing:** CLASSIC COLUMNS® Papers Writing is guaranteed for laser and ink jet printing.

**Digital Printing:** Our Universal Digital Finish is compatible with all digital presses. For more information on digital printing and presses visit: [neenahpaper.com/digital](https://neenahpaper.com/digital)

**Folding/Scoring:** A letterpress channel score parallel to the grain direction is recommended to ensure a smooth crease. A rounded 3 point rule with matching matrix of a minimum width of 2.5 times the caliper of the stock to be scored is recommended. Consider lighter screen tints or eliminate ink coverage over score areas to minimize highlighting of paper fibers along the fold, especially when scoring against the grain. This is particularly important to consider on cover, duplex cover and double thick cover papers. Always pretest, to achieve desired results.

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

**Binding:** CLASSIC COLUMNS® Papers accepts all types of commercial binding beautifully. Binding should be parallel to the grain direction to prevent moisture buckling and minimize wear on the crease.

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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.*