



ROYAL SUNDANCE® PAPERS PRODUCTION TIPS

ROYAL SUNDANCE® 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 inline 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 ROYAL SUNDANCE® Papers.

Aqueous Coating: Aqueous coating can be used as a surface protector; it will not alter nor enhance the appearance of ROYAL SUNDANCE® 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: ROYAL SUNDANCE® Papers requires no special considerations when printing heat-set web.

Embossing: ROYAL SUNDANCE® Papers emboss and deboss beautifully on all weights and finishes. The uniform formation lends itself to perfectly registered embossing.

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 ROYAL SUNDANCE® 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 the papers using new foils.

Thermography: ROYAL SUNDANCE® Papers accepts thermography beautifully. No special considerations are needed.

Non-Impact Printing: ROYAL SUNDANCE® Writing and Text in all finishes are guaranteed for laser and ink jet printing.



ROYAL SUNDANCE® PAPERS PRODUCTION TIPS (Continued)

Digital Printing: Our Universal Digital Finish is compatible with all digital presses. For more information on digital printing and presses, visit 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. Always pretest, especially with heavier weight covers. When using a heavier textured finish such as Laid, consider lighter screen tints or eliminating ink coverage over score areas to minimize highlighting of paper fibers along the fold.

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

Binding: ROYAL SUNDANCE® 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.

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.*