CLEARFOLD® Translucent Paper PRODUCTION CONSIDERATIONS

Storage
On-machine transparentized papers are extremely sensitive to humidity and must remain covered with plastic at all times and throughout all stages of a job to avoid curl and dimensional instability. CLEARFOLD® Paper must be stored unopened in the original packaging away from possible exposure to humidity or excessive hot or cold temperatures.

Preparation
To insure ideal results allow CLEARFOLD Paper to acclimate to press room temperatures, unopened in the original packaging for a minimum 24 hours prior to printing (longer when exposed to colder conditions). The press room must between 40% and 60% RH and the temperature between 60° and 70°F. Cartons and reams should be unwrapped immediately prior to printing, and not any earlier. Curl may result in the event that temperature or humidity conditions changed significantly in the last 24 hours. In such case, this paper must stay covered and be allowed to acclimate again to the changes. Paper must remain wrapped or covered in plastic between all press and bindery steps.

Prepress
Imagery should be adjusted in prepress to compensate for the additional 5 – 15% tone value increase that will occur. The precise amount of under color removal is image specific. Total area coverage should not exceed 320%.

Printing
Use fully oxidizing inks and minimal water with the water-ink balance as excess water will not be absorbed or removed from the blankets. Your ink supplier is the best information resource. Use coated spray powder of normal fineness (if needed). CLEARFOLD Paper is non-porous, therefore non-absorbent. Small lifts and additional drying time are necessary prior to other converting steps. Fully oxidizing inks will dry at a faster rate than conventional inks. Maintain fountain solution pH balance between 4 and 6. If optimal ink lay is not achieved, consider a minimal reduction of ink tack. Dry trapping and back side registered printing are not recommended as registration may be an issue.

Varnish
An in-line varnish can be used to seal the sheet. This will help off-set potential scuffing and curling when CLEARFOLD Paper is used in a cover, or wrap application. If off-line varnishing is used, the ink must be completely dry. Varnish should be pretested. Do not use aqueous coatings.

Heat Set Web
CLEARFOLD Paper is guaranteed for heat set web application when storage, preparation, and printing tips are followed. Oven temperatures and speed must be controlled to avoid blistering and excessive curl. Pretesting is recommended.

Embossing
Avoid using sharp tools. Simplified embossing patterns work best. A whiter more opaque area will appear along the edges of the embossed area. Pretesting is recommended to achieve desired effects.

Envelopes
CLEARFOLD Paper, 30# is recommended for envelopes. Use dull scoring blades and minimal heat for adhesive drying when converting. Adhering a piece of Teflon tape to top and bottom score blade has proven to be successful to eliminate cracking on the fold. Folding techniques and glues used in envelope conversion must be pretested.

Foil Stamping
Foils compatible with non-porous substrates are recommended.

Thermography
CLEARFOLD Paper accepts thermography well. Pretesting is recommended.

Laser Printing
Toner adheres well to CLEARFOLD Paper. Consideration must be given to equipment paper weight restrictions and heat conditions. Monochrome ink jet printing is acceptable.

Scoring & Folding
CLEARFOLD Paper is ideal for scoring and folding. A rounded channel score parallel to the grain with a minimum width of 2.5 times the caliper of the stock to be scored plus 8/1000" is recommended. Do not use sharp tools when scoring and folding. Folding away from the "bead" (opposite the traditional way) is recommended.

Trimming & Die-Cutting
A dull trimmer blade should be used. A newly sharpened blade will chip. CLEARFOLD Paper die-cuts beautifully on all four weights.

Binding
CLEARFOLD Paper can be saddle stitched, stapled, spiral bound or perfect bound. Binding should be parallel to the grain direction. Glues and bindery processes should always be pretested. Hot melt adhesives are recommended. Finished pieces should be wrapped completely in plastic or waterproof packaging to reduce the effects of humidity.