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## ESSE® Paper PRODUCTION TIPS

The natural characteristics of ESSE® Texture are watermarked into the paper. During this process, the dandy roll action displaces fibers in both machine and cross directions. Therefore, ESSE Texture requires design and production considerations when folding and scoring to minimize the cracking or lifting of the fibers.

ESSE 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 Paper merchants or by contacting our sample department at 800-994-5993.

**Prepress:** Imagery should be adjusted in prepress to compensate for the additional 10-15% tone value increase that will occur. The precise amount of undercolor removal is image-specific. Total dot area should not exceed 320%.

**Inks:** Inks with more tack will provide a firmer dot. The texture finish is more absorbent than smooth, so more ink may be necessary. A spot varnish in-line will eliminate scuffing on heavy coverage.

**On Press:** The cylinder blankets should be packed thicker than usual to ensure smooth ink coverage on Esse Texture. It may also require additional squeezing on press. ESSE'S uniform formation allows for excellent solid ink coverage.

**Ink Drying:** Allow a little extra time. ESSE Papers has sizing added to its surface that offers a barrier to ink penetration. Anticipate a dry-back of 5 to 7 density points.

**Varnish:** A low solvent (0-5%) in-line varnish can be used as a surface protector; it will not alter nor enhance the appearance of the paper.

**Aqueous Coating:** Aqueous coating can be used as a surface protector; it will not alter nor enhance the appearance of the paper. 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.

**Folding/Scoring:** Use a rounded channel score. A minimum width of 2.5 times the caliper of the stock to be scored is recommended. Because of the natural characteristics of ESSE Texture, cracking or lifting of the fibers will occur when scoring and folding. Please note that as the basis weight increases so will the cracking or lifting of the fibers. Avoid printing on the fold, particularly solid ink coverage on the felt (top) side of the sheet as this will visually highlight the cracking of the fibers. If ink coverage on the fold is necessary, printing on the wire (bottom) side of the sheet is recommended. The texture is not as pronounced on this side and therefore cracking will be eliminated.

**Trimming:** Use a sharp knife with minimum clamp pressure. To achieve a clean edge, back trimming is important. Wipe the newly cut edge with a clean, lint-free cloth.

**Binding:** ESSE Papers are suitable for all standard binding processes. Binding should be parallel to the grain direction.