

NEENAH® Box Wrap LACREMA® Papers – Production Considerations

Below is a list of recommended ways to handle, decorate and process LACREMA®. The recommendations can change depending on specific equipment so please test free sample sheets before beginning production.

CALIPER

The compressible nature of LACREMA® results in caliper changes when loaded during processing. The caliper should recover once the load is removed. Consequently, a non-weighted caliper gauge is required to accurately measure thickness.

MATERIAL HANDLING

Rolls

It is recommended that rolls get hung so that there is no pressure being applied to the roll. If that is not feasible, store the roll on end with end cap or in its box to reduce the risk of denting. Do not lean roll against wall or apply uneven pressure on the outside of the roll as this can create temporary dents.

Sheets

It is not recommended that sheets get stacked more than 10" high. The weight of the material can compress the soft nature of the product and cause problems when foil stamping at a later point.

Due to the compressive nature of the sheet, the material may retain compression mark if exposed to a load for an extended period of time. For example, if books are banded and stacked, the edge of the band may compress the material with a certain amount of load. If the load is not removed for a period of time, the compression may become permanent.

PROCESSING

Box Making

This material can be difficult to process on smaller boxes because it is so thick (<2"x2"). Please test the box before beginning production to ensure the box size does not need to be adjusted. The corners of a box can become thick when LACREMA® is folded on top of itself. If this look is not desirable, then use a dye cutter to remove excess material before turning the edges.

Case Making

LACREMA® performs well on various case-makers and book binders. LACREMA® has had no difficulties processing in a Horhauf case maker, and a Kolbus EMP1 case maker. The cases can be made with square corners, rounded edges, flush cut and others.

GLUING

Multiple brands of animal glues and PVA white glues have been tested successfully in case making, book binding, and box wrapping.

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CUTTING AND DIE-CUTTING

LACREMA® die cuts well. It is recommended that cardboard be placed between the clamp and LACREMA® before cutting with a guillotine. This will help reduce the risk of marking or color shifting.

SCORING AND FOLDING

LACREMA® can be scored using lower pressures. Decrease pressure if a line occurs on the face after scoring.

PRINTING

LACREMA® may be Screen Printed. We recommend working with your ink supplier to find the most suitable ink for your specific project although O2 and XL6 series inks from Nor-Coat provided passing results for adhesion with the addition of 1% 800 initiator.

HEAT BURNISHING/BLIND STAMPING

Copper or brass dies are recommended.

Typical temperatures for burnishing or blind stamping should range from 260-280°F. Lower pressures with longer dwell times will provide a more consistent and smooth stamp. Higher temperatures will provide a more drastic color shift. Higher pressures are recommended when using softer backings/boards.

Decrease pressure if burnish looks rough or crushed. If this occurs, you may need to increase temperature / dwell times.

FOIL STAMPING

It is recommended that you work with your foil supplier to determine best foils for your project. High gloss foils and heavy coverage areas (>2"x2") should be thoroughly tested before beginning production. Below are some foil recommendations that have worked on LACREMA® when using a Vertical Kensol with a deep etched brass die.

Foil Stamping Recommendations

Foil	Color	Recommended heat settings (°F)	Dwell (Seconds)	Fine Coverage	Medium Coverage	Heavy Coverage
A100	Matte White	290	0.6	Yes	Yes	Yes
W100	Matte White	285	0.55	Yes	Yes	Yes
A900	Matte Black	285	0.6	Yes	Yes	Yes
W900	Matte Black	285	0.6	Yes	Yes	Yes
900K	Metallic Black	285	0.6	Yes	Yes	Yes
"W" Series	Matte Pigment	275	0.55	Yes	Yes	Yes
S20EC	Metallic Gold	270	0.7-0.9	Yes	Yes	No
B22K1	Metallic Gold	300	0.7	Yes	Yes	No
SD613K	Metallic Gold	300	0.8	Yes	Yes	Yes
SD313	Metallic Gold	300	0.8	Yes	Yes	Yes
S5G	Metallic Silver	300	0.55	Yes	Yes	Yes
AS7H	Metallic Silver	300	0.5	No	No	Yes

NOTE: Foils provided by General Roll Leaf