

# so...silk® Papers Production Considerations

## **STORAGE / HANDLING**

Papers need to acclimate to pressroom conditions at least 24 hours before opening. Pressroom humidity should be in a range of 45%–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**

Requires fully oxidizing inks and a drying agent is recommended. Run water at a minimum, with a pH of 5-6. Use a 20/30 micron spray powder for two sided printing and 40/50 micron powder spray for single sided printing. This prevents set-off and allows oxygen to enter the stack.

## **VARNISH**

Low solvent (0-5%) varnish can be used as a surface protector. However, it will not enhance the appearance of SO...SILK and in some cases it may alter the appearance. Pretesting is recommended.

## **AQUEOUS COATING**

Aqueous coating may alter the visual effect of the SO...SILK appearance. Pretesting is recommended.

## **EMBOSSING**

Text and Cover weights, in all finishes emboss and deboss beautifully.

## **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**

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 paper.

## **THERMOGRAPHY**

No special considerations are needed.

## **FOLDING / SCORING**

A letterpress channel score parallel to the grain direction is recommended to ensure a smooth crease. Always pretest with heavier weight covers and double thick covers.

## **TRIMMING / DIE-CUTTING**

A sharp blade will ensure a clean cut through the stock; a dull blade could tear the stock.

## **BINDING**

Binding should be parallel to the grain direction to prevent moisture buckling and minimize wear on the crease.

**View additional printing information at [www.neenahpaper.com/printingtips](http://www.neenahpaper.com/printingtips)**