



## Touché® Papers Production Considerations

**Storage/Handling:** Touché needs to acclimate at least 24 hours before opening. Pressroom humidity should be in a range of 45-55%. Paper should be fanned when loading into the press. Once opened, rewrap unused product. Stock must be covered between press and bindery operations.

**Prepress:** 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 280% and not cover more than 50% coverage of the entire sheet. Limit three quarter tone imagery.

**Ink/Printing:** Touché needs to acclimate 24 hours in the pressroom before opening. Pressroom humidity should be in a range of 45-55%. Paper should be fanned when loading into the press. Heavy ink coverage on Touché is not recommended. The soft touch feel of the product will be compromised in these areas. In addition to compromising the feel, heavier ink coverage will require longer dry times that can lead to problems with ink set off. Avoid large black solids as it may be more susceptible to ink set off.

Touché is non-porous, and therefore non-absorbent thus running the water on press to the minimal setting is recommended. The use of fully oxidizing inks are necessary. Lift size should be 4" or smaller, to alleviate set off.

Drying compounds may shorten dry times and should be used with caution as overuse may cause a staining or ghosting effect to occur on Touché. A spray powder of 52 micron size, silicone based, is recommended. When printing on 24pt Touché', a smaller sheet size of 20" x 26" is recommended.

Metallic inks achieve great results on Touché. Touché can be printed UV offset. Some infrared press sensors may have trouble detecting Black Touché. Consult with your press manufacturer.

**Varnish/Aqueous Coating:** A low solvent (0-5%) varnish or an aqueous coating can be used as a surface protector; however it will not enhance the appearance of Touché and in some cases it may alter the appearance and the soft touch feel. Pretest for optimum results.

**Digital Printing:** Touché is not guaranteed for laser, ink jet or digital printing.

**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 & Embossing:** Copper or brass dies are recommended. Large areas of foil coverage are not recommended. Due to the density of 24pt Touché, simple, single-level dies are better suited for foil embossing and blind embossing. A two-step process (stamp, then emboss) will yield best results for foil embossing on the 24pt sheet. Pretesting is recommended.

**Screen Printing:** Touché yields excellent results with screen printing. Solvent or water-based inks are suggested.

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**Gluing:** For pocket folder or portfolio applications, 3M 924 and 926 transfer tapes have worked well with 13pt Touché, 3M 969 is recommended for use with the 24pt for automated systems, HB Fuller HL3363 has worked well. For automatic perfect binding applications, PUR adhesive (National Starch or Henkel brand) is recommended, as well as US Adhesives HM-661 (white) and HM-426 (clear). Consult your printer and/or bindery. Alternatively, the spine area can be sanded or scuffed before applying standard hot melt or cold liquid glue. Pretest binding glues.

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

**Folding/Scoring:** Touché scores and folds well and has good hinge/fold characteristics. The best results are achieved when the fold and grain are parallel.

### *Scoring Rule Selection:*

Two major considerations define the conditions that direct the choice of scoring rules for a job. First, the female channel width should be slightly  $<$  or  $=$  to twice the board caliper plus the thickness of the rule. Second, female channel width must be between 3.5 and 4 times the board caliper for CD scores, and about 3.5 times the caliper for MD scores.

Touché is 20-30% denser than traditional boxboard, and its construction gives it greater plybond than equal caliper boards of lower density. Therefore, the board needs to be treated as if it were higher in caliper than it actually is.

Application of the above considerations indicates the use of a 2-point rule for the 13pt sheet (0.028" rule thickness). The male rule depth of penetration can be adjusted between 0.004" and 0.010" to achieve a sufficient score.

Application of this density factor to 24pt Touché, indicates an "effective board caliper" of 0.031". Application of the above considerations indicates the use of a 4-point (0.056" rule thickness). The male rule depth of penetration can be varied between 0.010" and 0.024" to achieve sufficient delamination of the ply's.

For decorative packaging applications using 24pt Touché, while a 4-point rule is sufficient for fixed scores on box corners, a larger score is necessary to handle the additional stress demands of a box hinge where the score line may be folded 90° the opposite way. Packages designed in this manner would require a 6-point rule for such hinges. Channel width for these scores should be about 0.172" for CD scores and 0.162" for MD scores. Depth of penetration of the male rule should be in the same range as the 4-point.