



## TOUCHÉ® Papers Production Considerations

**Storage/Handling:** TOUCHÉ® is sensitive to humidity and should be stored in a dry place. We do not recommend stacking pallets of this paper. Once opened, rewrap unused product and cover stock between press and subsequent converting operations .

**Prepress:** When printing on TOUCHÉ® 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:** Keep paper wrapped in original cartons a minimum of 24 hours prior to processing and slightly longer during cold weather. Paper should be allowed to acclimate to pressroom conditions of 70-75°F, with a range of 45-55% relative humidity.

Fan paper prior to printing. It is recommended to run in short lifts and stack no higher than 4" after printing. A smaller sheet size of 20" x 26" may be preferable.

UV printing is preferable. UV lamps may heat up the paper surface and cause stickiness. Some infrared press sensors may have trouble detecting Black TOUCHÉ®. Consult your press manufacturer.

**Traditional offset printing:** 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 spray powder for single sided printing. This helps prevent set-off and allows oxygen to enter the stack. Spray nozzles should be tested to ensure even coverage.

**Ink Coverage:** Heavy ink coverage on TOUCHÉ® Papers 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.

**Foil Stamping & Embossing:** When foil stamping, remove any excess foil dust and particles. Slip sheeting the final pieces at every stage is recommended. Copper or brass dies are recommended. Large areas of foil coverage are not recommended. Due to the density of 24pt TOUCHÉ®, 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.

**Varnish:** Low solvent (0-5%) varnish 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. Pretesting is recommended.

**Aqueous Coating:** Aqueous coating will not enhance the appearance of TOUCHÉ® and in some cases it may alter the appearance and the soft touch feel. Pretesting is recommended.

**Digital Printing:** TOUCHÉ® is not recommended for digital printing.

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## TOUCHÉ® Papers Production Considerations (continued)

### **Folding/Scoring:**

#### *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.

The construction of TOUCHÉ® 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 the above considerations to 24pt TOUCHÉ® indicates an "effective board caliper" of 0.031" and 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.

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.

**Binding:** Loose shrink wrap when required, is recommended. Pretest binding glues.

**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.