



Cyrel® Packaging Graphics Products

How do I print Process?

If you are relatively new to process printing or find that you have a variety of different press set-ups in your plant, you may well ask yourself “How should I set up the press to print process?” The following are some basic guidelines designed to help you in that process. Although we recognize that these are only guidelines and may require some fine-tuning in your operation, they are based on industry standard practices and specifications, and provide a good place to start.

Inks (based on FIRST)

The inks used should be mono pigmented process inks systems. The table below identifies the recommended pigments.

Color	Light Fastness	Solvent	Pigment	Color	Light Fastness	Solvent	Pigment
Yellow	Moderate	Solvent	Yellow 14	Cyan	NA	Solvent	Blue 15:4
	Enhanced	Solvent	Yellow 74			UV	Blue 15:4
						Water	Blue 15:3
	Moderate	Water	Yellow 14	Black	NA	Solvent	Black 7
Enhanced	Water	Yellow 74	UV			Black 7	
			Water			Black 7	
Magenta	Moderate	Solvent	Red 57				
	Enhanced	Solvent	Red 184				
	Moderate	Water	Red 57				
	Enhanced	Water	Red 184				

Solvent-based ink viscosities should be run between 28 and 32 seconds in a number two Zahn cup. Solid ink densities are listed in the following table.

	<u>Wide Web</u>		<u>Narrow Web</u>		Tolerance
	Paper	Film	Paper	Film	
Cyan	1.35	1.25	1.35	1.25	+/-0.07
Magenta	1.25	1.20	1.25	1.20	+/-0.07
Yellow	1.00	1.00	1.00	1.00	+/-0.05
Black	1.50	1.40	1.50	1.40	+/-0.07

Anilox

The most straightforward anilox specification is “use the highest line screen anilox possible which allows you to achieve the desired solid ink density specification”. Some typical anilox lines screen and volumes are listed in the table below.

	<u>Line Count</u>	<u>Volume</u>
Narrow Web	800-900	1.2-1.5 bcm
Wide Web	650-800	1.5-2.0 bcm
Preprint Liner	600-800	1.5-2.0 bcm
Post Print	550	2.0-2.5 bcm

Tape

For process printing a cushioned tape is recommended. There is a wide range of cushioned tapes available, ranging from hard to soft. Caution; a very soft tape will frequently result in pin-holes on non absorbent materials such as poly and hard tapes may result in excessive highlight dot gain.