



NEENAH® PEARL PAPERS PRODUCTION TIPS

NEENAH® Pearl Papers are easy to print on when following these simple tips. It is recommended to pretest all printing procedures prior to press time to ensure the desired results are achieved. Sample sheets are available through authorized Neenah merchants or by contacting our sample department at 800-994-5993.

Storage/Handling: Papers need to acclimate to pressroom conditions at least 24 hours before opening. Pressroom humidity should be in a range of 40-55% at 70-75°F. Once open, rewrap unused product.

Prepress: When printing on NEENAH® Pearl Papers total area coverage should be kept under the 260% range. If heavy black or blue areas are desired, undercolor removal is recommended to alleviate long drying times.

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 spray powder for single sided printing. This prevents set-off and allows oxygen to enter the stack. Drying times may be slightly longer. Printing UV inks are acceptable. Small lifts (not to exceed 4" in height and may require less pile height depending on ink coverage), and additional drying time are necessary prior to other converting steps. It is normal for a minimal amount of surface debris particles to transfer to the printing blankets. This should not impede print production and are cleaned effectively with typical blanket washing devices.

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

Aqueous Coating: Aqueous coating may alter the visual effect of the pearlized appearance. Pretesting is recommended.

Embossing: Text and Cover weights 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: When utilizing NEENAH® Pearl Papers, foils compatible with non-porous substrates are recommended. Pretest to determine the proper foil, heat conditions, and pressure required for the best results.

Thermography: No special considerations are needed.

Non-Impact Printing: NEENAH® Pearl Papers are suitable for laser and monochrome ink jet printing. Consideration should be given to equipment paper weight restrictions and heat conditions. Pretesting is recommended for optimal print results.



NEENAH® PEARL PAPERS PRODUCTION TIPS (Continued)

Digital Printing: The NEENAH® Pearl surface on ALL items has been engineered for compatibility with offset, dry toner and liquid ink digital presses. For more information on digital printing and presses, visit neenahpaper.com/digital

Folding/Scoring: A letterpress channel score parallel to the grain direction is recommended to ensure a smooth crease. Always pretest with heavier weight 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.

Shade: Some variation in shade from run to run is normal.

Note: *These production tips should be used as general guidelines and are not inclusive of all printing and finishing methods. Neenah recommends always pretesting for desired results prior to full production.*