

Specs sheet for **direct board printing - trimming/custom-cutting along the outline**

To enable us to integrate your data into our workflow as quickly as possible, we request you to follow these instructions when creating your printing data:

File characteristics

In principle, we request you to send us print optimized PDF/X4 files. If mutually agreed, you may send us open files, but make sure that all relevant fonts and images are also sent. Nevertheless, we request you to **call us in any case** to avoid incurring additional costs. We use the latest version of the CS series of Adobe®. We may consider other programs only on request.

- Scale 1:1 (max. 5.0 m) otherwise 1:10
- Please take note of the bleed margin specification given under "Machine features"
- Do not place any crop or register marks or other print information
- Fonts must be embedded
- Basically, create data in CMYK mode (final output conditions for this ISO Coated V2 of the ECI)
- Always ensure compression for EPS or TIFF files (TIFF → LZW, EPS → JPEG compression at max. quality)
- Files with vector and image linking must be created in the same color space (CMYK)
- Use short, explicative file names, e.g.: Department_Name_Width x Height in mm
- The production format must be contained in the file name (mm)
- Your overprint settings will be retained by us unchanged. If the print result proves to be faulty due to an incorrect presetting, we can not assume liability in this case.

Cutting contour

Contours for cutting or shaping must be set to overprint as closed vector path in a special color "CutContour", "Cut" or "Decoupe". Permitted special color names for creasing are "Crease" or "Rainage". Cutting contours created as a surface cannot be taken into account.

Color conversion

In digital printing, special colors such as HKS, Pantone or RAL cannot be reproduced as special colors. The colors are mixed from among the available CMYK color space and reproduced thus approximately corresponding to the specification in printing. If you use Pantone or HKS shades, leave them as full tone. Our printing software will calculate the optimal color value for printing based on corresponding conversion tables.

Quality Assurance

To check if the position of the layout is correct, we request you to provide us with an exactly positioned print-out or a read-only PDF file. If special attention needs to be paid to the chromaticity of the original (if technically possible), please include a color-consistent proof. We also offer you the option of producing a press-proof on original material on payment.

Data storage media

Possible data media are CD, DVD, USB stick, SD card, or external USB hard disks. We are not liable for data storage media delivered. We will enable access to our FTP server on request.

Machine specific features

Print format

The maximum print width for rotary print material is 1520 mm. The maximum print format for direct printed sheets on rigid materials is 3100 x 1600 mm. If the working width exceeds the limits, please specify the desired division.

Bleed margin

The bleed margin should be uniformly circumferentially at least 5 mm for the output size. If double-side printed productions are in question, then, at least 10 mm.

File sizes for pixel data in the scale of 1:1

- Up to A0 format 150 dpi
- From 1 m² approx. 120 dpi scanning resolution approx. 80 MB/m²
- From 4 m² approx. 50 dpi scanning resolution approx. 15 MB/m²
- **Do not** scale up or down the scanned files (e.g. 3 MB → 30 MB)

Punching and creasing data

For the folding display and package printing, please create their punching and creasing data on different levels. Punching and creasing paths must necessarily be assigned to different special color channels.

If different creasing tools are needed on one form they must also be clearly separated from each other. Please consider that only paperboards (e.g. display cartons or double corrugated, micro-corrugated cartons) can be created. DiBond boards used for making displays, boxes or similar shapes receive a V shaped trimming on the back where a folding can be made; for this, we need yet a separate level.

Creating data for den spot coated printing

To use the partial spot coating option, create the data that is intended to render a glossy effect on an extra level and leave out the image portions lying below. This results in 2 print forms which will also be printed in 2 print sequences. All other fine text and geometrical figures will only be printed in matt print mode; the partial spot coating surfaces must contain image data or color surface and no white since only color data can be printed in gloss finish.

Creating multiple-up sheet

In the case of formats below A2, you need to create multiple-up in full sheet format, and for this, the sheet format must be coordinated with the production depending on the material. The multiple-up sheet is created with intercut, the distance between the customization paths should be at least 10 mm as much as possible. For creating the data for customization, please see the attached information sheet and the sample layout.

