

1-800-790-TPMS (8767)

## Gmund Bier

### Printing and Finishing Tips

**SCREENS:** For best possible results with offset printing, Gmund typically recommends 130 to 150 line per inch screens. Waterless press printers may elect to run higher line screens according to their particular press characteristics. Gmund recommends proofing on the actual paper stock. If a film laminate is used, then we recommend the use of a matt laminate. Matt laminates are more compatible to the surface appearance of uncoated paper.

**PRINTING:** Bier is suitable for all established printing processes. However, the natural properties of the paper call for special handling when using this material, especially in regard to printing large solids or four-color offset printing. Depending on the printing application, the beer dregs (larger fiber particles) may be picked off by the printing blanket. The occurrence of pick outs during offset printing is high. Artwork should be designed to minimize full-color coverage and incorporate features which are not severely degraded by a few pick outs. Pils, Ale and bock are varnished on one side to reduce picking and increase print fidelity. Prior to printing the alternate side, Gmund strongly recommends flood coating with a single pass of varnish. Allow adequate drying time before over printing the intended image on the newly varnished side. Keeping ink tack level below 10 is suggested. This may result in increased dot gain and decreased resolution. It is highly suggested that printers carefully select inks and be prepared for frequent washing of the blankets and plates. Wash-ups may be required every 500-1000 sheets. The use of high tack inks should be avoided. Color variations in the sheet reflect the natural fiber character of the paper. The high bulk of these papers provide particularly attractive results when blind embossed, foil stamped or letterpress printed. For all other processes, Gmund advises preliminary testing since the results may differ depending on the type of equipment used. Bier Paper scores and folds well.

**NOTE:** For optimal results, Gmund advises against full coverage offset printing. The level of pick outs may be too high to be acceptable.

*Printing hints by Gmund, reviewed by The Paper Mill Store .com.  
For additional technical information, you may contact our tech rep Mel Schinasi at 201 444 8115*