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## Astrobrights Textures™ Hot Emboss Color Changing Paper Printing and Handling Hints

**Astrobrights Textures™ printing papers are easy to print on when following these simple guidelines. It is recommended to test all printing processes prior to press time to ensure the desired results are achieved.**

**Offset Inks:** Use low solvent (0-5%), oil-based inks. Higher than recommended solvent content inks will cause ink set difficulties. Inks should be formulated to dry purely through oxidation. Inks formulated for synthetic papers like Tyvek® and Syntape® will work well. Silk screen inks should also be synthetic inks, as they provide good coverage, adhesion and drying. In-plant ink formulation is not recommended. Ask your ink manufacturer about Astrobrights Textures products specifically. Pre-test any unfamiliar procedures and ensure that proper ink formulations are utilized.

**Handling:** Keep Astrobrights Textures products wrapped until the moment of printing. It is essential to let the paper acclimate, for a minimum of 24 hours – longer during cold weather – in the press room while still wrapped in mill packaging. Keep Astrobrights Textures products covered during drying, between passes, and prior to any finishing work. Pressroom conditions should be as close as possible to 68 degrees, and 45-60% relative humidity. Should you experience a curl problem, this is most likely temperature – or humidity – related. Print in small lifts. Frequent airing of lifts is also recommended. Astrobrights Textures products should be covered before and after printing, and through bindery operations. If the bindery has a different climate than the pressroom, allow the paper to acclimate to those conditions.

**Fountain solution:** The ink-water balance should be run at an ABSOLUTE MINIMUM. The pH should not be below 4.0. Given the non-porous property of Astrobrights Textures products, excess water will NOT be absorbed or removed from the blanket. Any excess water will slow drying. Solid or multiple color bars can be used to assist in removing water and aid in set time.

**Offset spray:** If the job requires offset spray, use coated spray of normal fineness.

**Varnish:** Pre-test Astrobrights Textures products for compatibility. Apply 100% VOC free varnish after the underlying ink is dry. Consult your varnish supplier and pre-test.

**Folding and scoring:** Always fold, score and bind with the grain direction. Use a 2 or 3 point rounded channel score to prevent cracking. For the matrix channel use a minimum width of 2.5 times the caliper of the sheet to be scored, plus 28/1000. Do not use sharp tools when folding and scoring. Always pre-test any procedures prior to production.

**Hot Embossing:** Astrobrights Textures will uniformly change color when hot embossed at 320 degrees Fahrenheit.

**Ink Jet and Laser Printing:** Both technologies are a challenge with Astrobrights Textures due to the heavy basis weight and poor absorption properties. We recommend that you pretest paper in your equipment before committing to either method.

Hints by [thepapermillstore.com](http://thepapermillstore.com), verified by Wausau Paper technical.

Note: The above recommendations are "hints" based on our knowledge and experience.

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