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## Monadnock Dulcet® Text and Cover Uncoated Paper Printing and Handling Hints

**Dulcet® Papers are easy to print on when following these simple hints. It is recommended to pre-test all printing procedures prior to press time to ensure the desired results are achieved.**

**Offset Inks:** Print Dulcet like any conventional uncoated paper. We recommend heat resistant, wax free ink if you plan to follow lithography with xerographic or laser printing technologies. The very smooth surface might require extra drying times and short lifts are recommended.

**Handling:** Keep Dulcet products wrapped until the moment of printing. It is essential to let the paper acclimatize, for a minimum of 24 hours – longer during cold weather – in the press room while still wrapped in mill packaging. Keep Dulcet 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.

**Varnish:** Varnish is optional as a surface protector and tinted varnish can be used to achieve creative effects. A 50-50 mix of dull and gloss varnish will match the gloss level of most printing inks. Gloss varnish is not recommended as it could result in enhanced mottle or galvanization effects

**Folding and Scoring:** To properly score Dulcet, use a 2 point rounded channel score. For the backing channel, it is recommended to use a minimum width of 2.5 times the caliper of the sheet to be scored, plus 28/1000". Very heavy weights may require a 3 point bullnose channel score. Always pretest any procedures prior to production.

**Binding:** Dulcet is suitable for all standard binding processes. It is important to plan for proper grain direction in all binding applications. Grain direction should run parallel to the spine for optimum results.

**Laser and inkjet guaranteed** on 60 lb. Text through 65 lb. Cover items. The 80 and 100 lb cover will also work, subject to printer restrictions. We recommend pretesting these heavier weights.

Hints by Thepapermillstore.com, verified by Monadnock papers.

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

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