

Production Notes for MultiLoft[®] Products

Thank you for trying our family of value added MultiLoft[®] substrates. These substrates can be used to make an exciting selection of double thick, triple thick and quadruple thick cards! Please follow the suggested guidelines to ensure the highest quality final product.

1. As with most printing substrates, we suggest the press operators fluff or prep sheets before running in a press.
2. Ensure the sheets are properly aligned front to back.
3. Place in your trimmer in stacks no larger than 2,5 cm tall.
4. Set your trimmer to a minimum pressure of three (3) tons or 22kg/cm² (300 psi -pounds per square inch).
5. We highly recommend that you affix a piece of chipboard to the bottom of the trimmer clamp to protect the cards from receiving permanent clamp bar impressions during the sealing phase. This may be achieved by simply taping the chipboard to the bottom of the clamp.
6. We recommend double trimming stacks where the second trim will cut off .5 mm or 1/32nd of an inch. This will produce a cleaner edge.
7. Using less than the recommended 22kg/cm² (300psi) may result in improperly sealed cards.

The clamp pressure on the trimmer will activate the glues and seal the substrate as you trim. Please contact us with questions.

Convertible Solutions MultiLoft is the solution for jobs requiring thicker substrates in double, triple, quadruple thicknesses and greater. For a lay-flat book or brochure solution, Convertible Solutions recommends the TRU-Flat system for seamless imaging across the spine, with no visible sign of binding

MultiLoft is a unique, special application substrate, and as such, not subject to the same 1 cm or less sheet curl specification as non-treated sheets. Application of glues and/or coatings **may** lead to curling in excess of 1 cm, requiring the operator to apply back-curling massage of the stack prior to running through the press or printer.

Product Handling

Convertible Solutions pre-converted paper uses cohesive and re-moistenable glue technology on many products. Additionally, several products include scores, perforations, attached cards, peel-off labels and other features that are pre-applied to the paper stock prior to printing on your press. Understanding the glue characteristics as well as a few other nuances involved with running pre-converted paper stock will help in the printing, folding, bonding and performance of Convertible pre-converted products.

Paper Storage:

Products using cohesive and re-moistenable adhesives must be stored in a temperature range of 50 degrees to 86 degrees Fahrenheit. Extreme heat, cold or humidity could render the adhesives ineffective. Product must be kept in its original sealed wrapper to ensure consistent moisture content of the paper is maintained. Normal shelf-life of product utilizing adhesives is one year, assuming proper packaging and storage of the product. Pre-converted paper utilizing adhesives that are left exposed to light and air will deteriorate the performance of the adhesives.

Paper Handling and Printing:

Unused sheets of pre-converted paper should not be left exposed to air and light. Place any unused sheets back inside their original packaging until their next use. All paper products should be acclimated to the press room environment twenty four hours prior to printing. The recommended press room environment should be 40% to 60% relative humidity and a temperature of 70 degrees Fahrenheit. We also recommend to carefully fan the paper before running on the press.

Perforations:

When overprinting perforations on some digital presses (e.g. HP Indigo) a perforation image may transfer to other locations on subsequent sheets. To prevent this from occurring, we suggest not printing on the perforations or to print 4/0, simplex on both sides.

Activating the Cohesive:

After printing, trimming (if necessary), and folding, pressure must be applied to any adhesives in order to activate the bond. Cohesive glue is dry to the touch and bonds only to itself when adequate pressure is applied. The minimum amount of pressure required to seal is 22kg/cm² (300psi -pounds per square inch). To activate adhesives using a Flat Bed Cutter clamp, you'll need a minimum of 3 tons of clamp bar pressure. Place the stack under the clamp bar and simulate a cut thus activating the clamp bar (do not trim unless necessary).

Recommended Pressing Method

A clicker type press is recommended to provide uniform pressure over the entire paper surface to activate the cohesive glue. An Atom Clicker, 20 ton press, is one example of a press providing quick cycle time and sufficient force. Ensure the sheets are properly aligned in a stack and the stack is no more than one inch high. Cycle the stack through the press. Rotate the stack 180 degrees and cycle again.

NEVER OVERPRINT OR SEAL COAT THE ADHESIVES: Cohesive and re-moist glues must not be over-printed or coated with any treatment including UV coating. Any coating or ink/toner applied to the cohesive or re-moistenable glue will impact their adhesive properties and may render them completely ineffective. Please consult your sales representative for more information.

Exposure to Light: Exposing adhesives to an intense UV light source, such as the type used to cure UV coatings, will render them completely ineffective almost immediately. Furthermore, unsealed adhesive exposure to any type of light, over an extended period of time (weeks or months), will generally degrade their performance. It is for this reason we recommend covered or boxed storage of our products. Please consult your sales representative for more information.

For presses that utilize Fuser Oil:

The glue performance is impacted by fuser oil flood-coating the entire sheet while printing. Therefore, it is necessary that customers with presses utilizing fuser oil wait at least five (5) hours after printing to allow time for the fuser oils to dissipate before applying pressure to activate the adhesives. We recommend running a confirmation test in this regard to confirm performance before running actual production.

Disclaimer:

These product handling instructions are general recommendations based on Convertible's experience and typical customer usage of the products. The Buyer shall be solely responsible for the implementation of its own operations and practices. Convertible disclaims any knowledge or responsibility for Buyer's operations and practices. Furthermore, Convertible assumes no obligation or liability for any advice or recommended operating practices given to Buyer that are in addition to or different than anything set forth in these product handling instructions or for any results obtained by Buyer based on such advice or recommendations. Any liability in product performance is limited to the replacement of the Convertible Solutions product.