

## PRINTING TIPS

ASTROKING is suitable for most popular printing and finishing techniques: offset with traditional inks; offset with UV inks; letterpress; blind embossing; foil blocking; thermography and silk screen printing.

The optimum printing technique applicable for ASTROKING is offset with UV inks. In the case of traditional offset printing, it is advisable to use specialised oxidizing inks for plastic substrates, which will allow quick drying.

It is necessary to control all variables of the printing process especially at the font. The buffer solution should have a PH value between 4.8 and 5.5 and a conductivity value between 800 and 1200 ms.

It is important to achieve a good balance between the font and the ink delivery system, reducing the wetting to a minimum to avoid emulsion with the ink. This will give optimal results in terms of drying and anchoring of the ink.

It is advisable to apply an in-line UV matt varnish. Low output stacks are necessary. Drying times may vary depending on ink density and compliance with process variables.

Foil blocking is generally applicable. Occasionally the negative interaction between specific types of foil and deep coloured papers may cause foil oxidation. This can be avoided by:

- Coating with an acrylic primer
- Coating with a UV primer
- Double foil blocking, with application of a transparent film in the first pass

It is advisable to carry out tests on the use of glues, preferably using polyurethane glues.

Good results are obtained with most important converting processes: cutting; creasing; die cutting; folding; gluing and lamination.

Lamination is possible: it is advisable to carry out tests to verify the good adhesion of the film to the paper.

To guarantee optimal yield when utilising special processing and elaborate finishing, it is possible to request ASTROKING samples to be used for printing tests.