

## Technical Bulletin - Instructions

### Achilles Special-Gloss®-Film

<b>Backing material:</b>	Sheet lamination: <ul style="list-style-type: none"><li>– paper 115 g/m<sup>2</sup> to card 450 g/m<sup>2</sup></li><li>– gloss- or silk-coated printing substrates</li><li>– uncoated qualities only after consultation</li><li>– relative paper moisture approx. 50 %</li></ul> Composite lamination: <ul style="list-style-type: none"><li>– here nearly any paper quality is possible (max. 380 g/m<sup>2</sup>) depending on the intended purpose</li><li>– hologram paper from 78 g/m<sup>2</sup></li></ul>
<b>Composite surface:</b>	Scratch resistant glossy side outside
<b>Visual appearance:</b>	<ul style="list-style-type: none"><li>– glossy</li><li>– it is always the non-scratch resistant glossy side which is laminated as backing material. The scratch-resistant glossy surface is always outside.</li></ul>
<b>Formats:</b>	<ul style="list-style-type: none"><li>– max. sheet width 1010 mm</li><li>– optimum sheet widths = 100 cm und 70 cm</li><li>– please ask about other widths</li></ul>
<b>Printing Recommendation:</b>	Do not use the grid further 100 lines/cm (possible formation of a moiré between print and film).
<b>Printing inks:</b>	Inks must be suitable for lamination: consult ink manufacturer if necessary; the inks must be dried through completely and resistant to solvents and alkaline solutions as per DIN 16524. Surface tension should be >35mN/m. Possible changes in ink must be taken into account in the prepress or printing phase; sample lamination is advisable. Metal pigment inks must be coordinated in particular to the lamination process; consult the ink manufacturer.
<b>Printing aids:</b>	Only little powder, remove powder preferably before finishing. Use starch powder with adapted grain size as powder. Do not add scouring protection paste, wax and silicone to the inks. Minimise moisture level in neutral range. Primers must withstand sellotape and be migration-proof, dried through and suitable for gluing; apply with minimum force. Primers are not suitable for subsequent fold enamelling and HF drying.
<b>Positioning and production edges:</b>	10 mm trimming edge all round, unprinted and unvarnished. Please enclose dummy sheet indicating details of the finished format and trimming.
<b>Processing:</b>	<ul style="list-style-type: none"><li>– varnishing using the screen printing method</li><li>– structure embossing</li><li>– punching, creasing, folding, grooving</li><li>– gluing (job-oriented test absolutely necessarily)</li><li>– applying stickers (resistant to sellotape)</li><li>– bookbinding cover production</li></ul> <p>– The processing method (e.g. creasing, grooving, folding) is to be taken into account when selecting the backing material.</p> <p>– We generally recommend a processing test with a printer sheet!</p>
<b>not possible:</b>	<ul style="list-style-type: none"><li>– heat-sealing with foil (e.g. pocket sealing)</li></ul>
<b>Advice for shipping:</b>	<ul style="list-style-type: none"><li>– Please make sure that products used with ASG films are not open to vibration or movement whilst being shipped or transported.</li></ul>
<b>Attention!</b>	<ul style="list-style-type: none"><li>– ASG film gives a higher level of scratch resistance compared with normal Gloss films, however ASG film is not resistant to Mechanical load!</li></ul>

#### Please...

...send a detailed specification with your order together with a dummy sheet indicating the scope of our work. Please also inform us about subsequent processing steps so that we can use the right materials for your purpose. It is also important to inform us of the required delivery address if this is not the same as the purchaser's address. Please inform us in advance if the processed quantity differs from the quantity supplied to us, as otherwise all supplied sheets will be processed and charged. Compliance with these points will result in swift, uncomplicated processing of your order without the need for any queries. Coordination of all production processes and materials guarantees optimum production results. Profit from our experience, know-how and possibilities. Ask and inform us in plenty of time, we will be glad to advise you.

The details contained in this bulletin comply with the current state of our know-how; they do not constitute any extension of the guaranteed services stipulated in our delivery conditions and are in particular no warranted properties. This information bulletin can only provide unbinding advice with regard to differences in printing substrates and working conditions. Before circulation printing begins, it is important for the printers to check by suitable means whether the materials are appropriate for the intended purpose.