



**CTI PAPER USA**

**Currency®  
Metallic Papers  
Printing & Handling Hints**

**Currency® Metallic Papers are easy to print on when following these simple hints.  
We recommend you pre-test all procedures prior to press time to ensure you achieve the desired results.**

**Inks:** Currency has a totally non-absorbent surface on the metallic side. For optimum results, we recommend inks that dry by oxidation and are 100% VOC free. Please consult your ink manufacturer prior to printing. To achieve dark, heavy solids, two hits of ink or a base of opaque white produces may improve results. Process inks should be kept below 275% total (<70% per color on 4 colors). We recommend slip sheets if overprinting a solid black. If used, metallic inks should be aluminum-based or mica-based, not brass or bronze.

**Handling:** Keep Currency wrapped in mill packaging until the moment of printing. It is essential to let the paper acclimatize in the press room for a minimum of 24 hours — longer during cold weather. Also keep Currency 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. If the bindery has a different climate than the pressroom, allow the paper to acclimatize to those conditions.

**Reverse:** Currency is lightly sized on the back side, which creates a print surface that performs similarly to uncoated paper. Conventional inks may be used on the white side, but due to absorption by the sheet, more ink may be required than on conventional coated sheets to achieve desired density. We recommend pretesting to evaluate print quality.

**Delivery:** For optimum results, set jogger pressure to a minimum and lifts at 3 to 5 inches.

**Varnish:** Low solvent (0-5%) varnish is optional as a surface protector or to achieve design effects. Pre-test all varnishes for compatibility. Varnish can be wet or dry trapped, but we recommend dry trapping over heavy ink coverage.

**Scoring and Folding:** To properly score Currency, use a relatively light, 2 point rounded channel score to avoid rupturing the coating. The matrix channel should be a minimum width of 2.5 times the caliper of the sheet to be scored, plus 0.028".

**Binding:** Currency papers are 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.

**Foil Stamping:** We recommend using foils coated with low-temperature adhesives and keeping the size below 1.5 square inches. Low heat is necessary to avoid vaporizing moisture in the stock.

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