



Durilla™ Durable Papers Printing & Handling Hints

Durilla™ Durable Papers are easy to print when following these simple hints.

We recommend you pre-test all procedures prior to press time to ensure you achieve the desired results.

Inks: UV printing and inks are suitable for all Durilla grades. If subsequent laser printing is anticipated after offset printing we recommend laser safe offset inks and minimizing spray powder which may interfere with laser printing.

Premium Waterproof and Premium Ice Translucent: We recommend inks that dry by oxidation and contain less than 5% VOC (solvents). Use UCR/GCR to minimize ink film thickness. Please consult your ink manufacturer prior to printing.

Premium White, Premium Matte Coated: These can be printed with standard offset inks. The plastic internal structure of the sheet will inhibit air flow and may result in longer drying times. Adequate spray powder and smaller lifts will help minimize offsetting.

Handling: Keep Durilla wrapped in mill packaging until the moment of printing. It is essential to let the paper acclimate in the press room for a minimum of 24 hours — longer during cold weather. Also keep Durilla 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.

Delivery: For optimum results, set jogger pressure to a minimum and lifts at 3 to 5 inches. For 103 lb C Premium Matte Coated and 68 lb C Premium White limit stack height to 2 inches to avoid offsetting on the smooth surfaces.

Cutting: Use care when cutting Durilla. Use a sharp knife with minimum clamp pressure and lifts less than 2 inches high. A clean cut will enhance the tear resistance of the sheet; rough edges may produce tear initiation sites.

Scoring and Folding: To properly score Durilla, start with a 2 point rounded channel score. The matrix channel should be a minimum width of 2.5 times the caliper of the sheet to be scored, plus 0.028" — normally 0.050" for text and 0.060" for cover. Score and fold with the grain for best results, but folds in either direction will work. Leaving 1/8 inch unscored at the edges will minimize tearing.

Binding: Durilla 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.

Foil Stamping: For optimum results with Premium Waterproof and Premium Ice Translucent, use foils suitable for plastic materials. Experiment with foil choice, pressure and temperature to find optimum conditions. Please consult your foil manufacturer.

Laser Printing: Feed paper cross grain to minimize curl. Allow paper to condition in a controlled environment for 24 hours after printing to allow any curl due to heat and dryness to equilibrate. Keep RH above 50% if possible. If paper develops a static electrical charge in areas of low humidity, try fanning the sheet to dissipate the charge. The charge will also dissipate with time.

HP Indigo: Premium Matte Coated is RIT Certified for performance in HP Indigo printing.

Ink Jet: Paper layers are thin and water absorbency will be fairly low. Pretest for ink jet print quality. Premium Waterproof, Premium Ice Translucent and Ultra Polyester Matte Coated are not suitable for inkjet, except for UV inkjet.

Other converting: Durilla may be die-cut, punched, pierced, perforated, drilled, folded and stitched. The sheet can be glued with many adhesives including hot-melts. Please check with your supplier.

Note: The above recommendations are "hints" based on our knowledge and experience. CTI Paper USA and its affiliates do not accept responsibility for omissions or pressroom errors. Email printing@thepapermill.com or call 800-284-7273 for additional assistance.