



CTI PAPER USA

## Glama Natural®

### Naturally Translucent Printing Papers

### Printing & Handling Hints

Glama Natural® Translucent Printing 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:** For optimum results, we recommend low-solvent (0-5%), oil-based inks that dry by oxidation. Ink with higher than recommended solvent content may cause ink-set difficulties. In-plant ink formulation is not recommended. Normal heat-set and UV inks have printed successfully on Glama Natural and eliminate drying time. Ask your ink manufacturer about Glama Natural products specifically.

**Handling:** Keep Glama Natural 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 Glama Natural 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 acclimate to those conditions. Should you experience a curl problem it is most likely temperature or humidity related. We recommend printing in small lifts and frequent airing of lifts. Avoid using on-press heat and drying systems.

**Fountain Solution:** Run the ink-water balance at an *absolute minimum*. The pH should not be below 4.0. We suggest adding up to 10% alcohol. Given the non-porous property of Glama Natural, excess water won't be absorbed or removed from the blanket. Any excess water will slow drying time. Solid or multiple color bars can be used to assist in removing water and aid in ink set time.

**Offset Spray:** If the job requires offset spray, use coated spray of normal fineness.

**Varnish:** A clear, overprint varnish can be used to seal the sheet and reduce curling when Glama Natural is used as a cover, wrap, free-hanging application or when very heavy ink coverage is applied to one side of the paper. Apply 100% VOC-free varnish after the underlying ink is dry. Consult your varnish supplier and pre-test for compatibility. Do not use aqueous coatings.

**Cutting:** Do not use a newly sharpened blade when cutting Glama Natural products as it may chip. A slightly dull but clean-edged blade with a 23°-bevel angle is ideal.

**Scoring and Folding:** Always score, fold and bind with the grain direction. 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, plus 0.028", usually 0.040" or 0.050". Do not use sharp tools when folding and scoring.

For foil stamping, embossing and envelope converting hints, visit [thepapermill.com](http://thepapermill.com) or call 800-284-7273.

*Note: The above recommendations are "hints" based on our knowledge and experience.  
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Email [printing@thepapermill.com](mailto:printing@thepapermill.com) or call 800-284-7273 for additional assistance.*