

Artwork specifications

In-mould

iPB Printing works with high-quality Flexo printing presses. In order to guarantee a high print quality, this technique requires minor adjustments to a standard print file. In order to be able to make these adjustments quickly and smoothly, we ask you to provide us with easily editable files. This ensures minimum processing times and maximum quality of the end product.

If the delivered files do not meet these guidelines, we trust you will understand that optimising the file will incur unavoidable additional costs.

Here are some general guidelines.

1. File type

■ We prefer to receive PDF files that have been created with the following settings:

- PDF version 1.6 or higher.
- The document is not password-protected.
- Do not downsample images. Alternatively, ensure they have at least 300 PPI.
- Do not compress images. Alternatively, compress them at maximum quality.
- Embed the font completely, do not make a subset.
- Do not use markers or bleeds.
- Do not crop image data into frames,
Do not cut up images into several smaller ones.

■ Open files can be delivered in the following packages, in the latest or preceding version:

- Packz
- ArtPro
- Adobe Illustrator
- Adobe Indesign
- Adobe Photoshop (only for the delivery of images, no fully formatted files)

Remember to supply all used fonts and images separately!

2. Structure of a file

■ Please build up all print files in layers as follows:

- 1 layer containing the die-cut, defined as a spot colour with the name "Stans" or "keyline".
In overprint with a thickness of 0.25 mm or 0.7 pt.
- 1 layer on top of the artwork containing the white form in overprint, defined as a spot colour with the name "white".
Preferably visually represented in light blue.
- 1 layer with the variable data (if applicable), defined as a spot colour with the name "VAR DATA",
in the CMYK colour values to be printed.
- 1 or more layers with the artwork.
- If PMS colours are used, they must be defined with the correct designation. For example, "Pantone 128 C".

3. New die-cut

A new die-cut must always be supplied in the ratio of 1:1 as a PDF (i.e. not scaled). We use the actual measured dimensions and not the dimensions quoted. The dimensions quoted often deviate slightly from the actual measured values. Please note that our production process requires that a die-cut does not have any right-angled corners. If the die drawing does contain right-angled corners, these will be rounded off with a radius of 1 mm as standard.

4. Conical format

Make sure you deliver the artwork conically to the right shape. If you prefer to have straight files conically set by us, a warping charge will apply.

5. Colour reference

■ **The following can be used as a colour reference:**

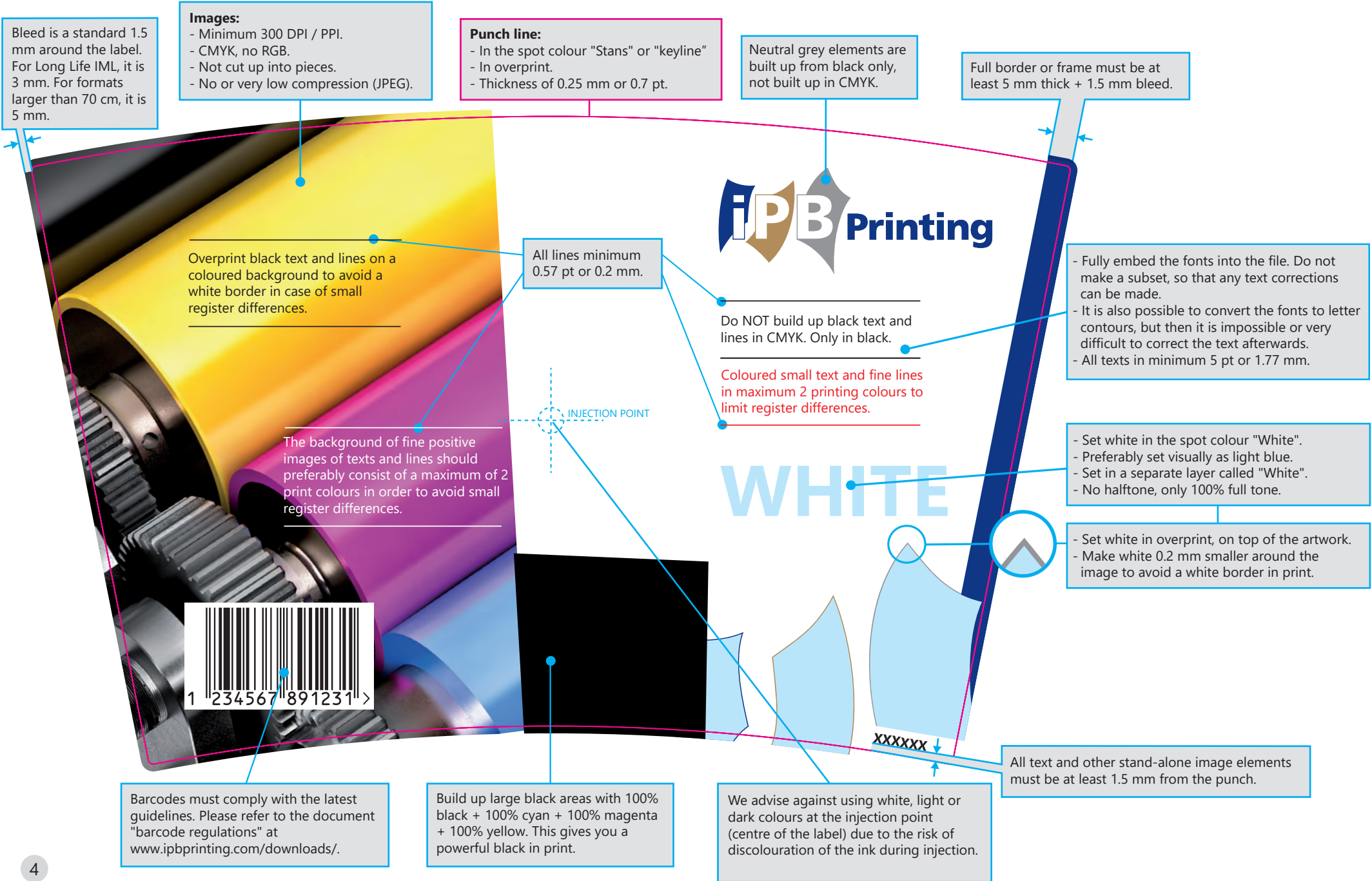
- CMYK
- CMYK + PMS
- PMS
- Customer model. This model must be sent to us in duplicate. This may include:
 - A printed model
 - A finished product
 - A plastic plate
 - A colour sample

We do not work with offset standards. If the colour of your label has to exactly match a colour model or a printed label from another printer, colour corrections will be necessary to avoid deviations. A charge will be made for this unless your prepress or design studio uses our colour profiles. These can be requested from your contact person at iPB Printing.

6. Delivery of the file

You can send your file(s) by e-mail, but for larger file sizes or multiple files, WeTransfer is a better solution. Please ask us for support.

7. General guidelines



Bleed is a standard 1.5 mm around the label. For Long Life IML, it is 3 mm. For formats larger than 70 cm, it is 5 mm.

Images:
 - Minimum 300 DPI / PPI.
 - CMYK, no RGB.
 - Not cut up into pieces.
 - No or very low compression (JPEG).

Punch line:
 - In the spot colour "Stans" or "keyline"
 - In overprint.
 - Thickness of 0.25 mm or 0.7 pt.

Neutral grey elements are built up from black only, not built up in CMYK.

Full border or frame must be at least 5 mm thick + 1.5 mm bleed.

Overprint black text and lines on a coloured background to avoid a white border in case of small register differences.

All lines minimum 0.57 pt or 0.2 mm.



Do NOT build up black text and lines in CMYK. Only in black.

Coloured small text and fine lines in maximum 2 printing colours to limit register differences.

- Fully embed the fonts into the file. Do not make a subset, so that any text corrections can be made.
 - It is also possible to convert the fonts to letter contours, but then it is impossible or very difficult to correct the text afterwards.
 - All texts in minimum 5 pt or 1.77 mm.

The background of fine positive images of texts and lines should preferably consist of a maximum of 2 print colours in order to avoid small register differences.

INJECTION POINT

- Set white in the spot colour "White".
 - Preferably set visually as light blue.
 - Set in a separate layer called "White".
 - No halftone, only 100% full tone.

WHITE

- Set white in overprint, on top of the artwork.
 - Make white 0.2 mm smaller around the image to avoid a white border in print.



Barcodes must comply with the latest guidelines. Please refer to the document "barcode regulations" at www.ipbprinting.com/downloads/.

Build up large black areas with 100% black + 100% cyan + 100% magenta + 100% yellow. This gives you a powerful black in print.

We advise against using white, light or dark colours at the injection point (centre of the label) due to the risk of discolouration of the ink during injection.

All text and other stand-alone image elements must be at least 1.5 mm from the punch.

8. Connecting the image between 2 different labels

If the images of, for example, a long and a short side are to fit nicely, the image must fit at the height of the die-cut and not at the height of the bleed.

