



These guidelines are intended to help the printing machine operators to improve the printability and performance of the material. Please review these instructions in advance before printing in order to achieve the desired results.

STORAGE GUIDELINES

Store inside at room temperature, from 18° to 27°C with a relative humidity level between 25% and 50%. If the pallets are kept in a cold warehouse, the material should be acclimatized to press room temperature in the sealed original wrap for 24 hours before opening it.

Unwrap **Stafix**® once it has acclimatized to the press room temperature. Let the opened **Stafix**® pallet acclimatize to press room temperature 24 hours prior to running. Sudden changes of temperature and/or humidity may cause the film to wrinkle.

After printing rewrap the remaining, unused material appropriately with plastic foil. Humidity and dust should be avoided to prevent **Stafix**® from wrinkling and losing its static charge.

INK USAGE

Use as little ink as possible. Heavy deposits of ink should be avoided to prevent the film from curling. Total ink coverage (TIC) should not exceed 240% in the color build, a raster of 60-70 l/cm is recommended. When having a combination of two or more solid colors – reduce the ink density on the press. When printing on the transparent material and using a covering white, please rasterize the covering white to 95%.

Recommended inks:

Use inks suitable for printing on thin polypropylene substrates. Avoid inks that contain high amounts of mineral oils. Mineral oil may cause the film to swell. Do not use drying pastes or additives on the inks.

Here are two recommended ink series:

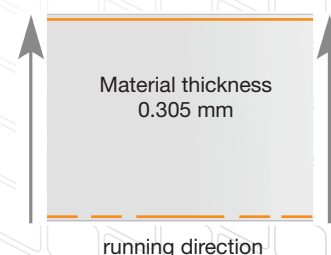
- Flint Group Novaplast
- Sun Chemical Foils 44

STAFIX® SHEETS

The **Stafix**® film is glued on to a cardboard by two glue lines from the long sides of the sheet. One glue line is continuous and the other one has a dotted pattern. The glue is colored red to help to distinguish them. Do not cut the glue lines before printing. It is recommended to leave an unprinted area on the tail of the sheet. The color bar should be placed 2cm from the tail edge of the sheet. The maximum printing area is defined by the sheet's format size.

- 320x450mm sheet's maximum printing area is 300x440mm
- 480x650mm sheet's maximum printing area is 440x640mm
- 707x1000mm sheet's maximum printing area is 640x990mm

The sheet sizes 480x650mm and 707x1000mm have a cardboard margin on the tail edge of the sheet to allow for better feeding.



ON PRESS

Fan the sheets properly prior to loading (*please check the video instructions from our website*). Run in short lifts of 200-250 sheets.

Strong air supply is essential for feeding **Stafix®**. Position feeder air blowers so that the air separates the first 10-15 sheets to minimize blocking.

Use additional side blowers if possible. Position side air-blowers at the front sides of the stack.

Set the feeder settings for printing on thick materials.

Run at max. press speed of 5000-7000 sheets per hour.

Run with low levels of water. **Stafix®** absorbs practically no water and therefore very little water is needed. The plate requires only enough water to keep the surface wet. Keep the alcohol level from 10 to 15%. The Acidity of the dampening should not be set too high, PH value approx. 5.5.

Set the print impression pressure as light as possible in order to avoid stretching of the film.

Static Eliminators

Do not use any antistatic devices including sprays, tinsel, or on-press electronics. These will reduce the static charge loaded in the material.

Coatings

Do not use varnish or aqueous coatings! Coatings will eliminate the static charge and curl the material.

Drying

Do not use IR dryers; the intensity of the IR lamps may cause the film to expand due to excessive heat. Additionally it may extend the drying time.

Use a larger grain powder, 40 - 50 microns to facilitate drying. Larger grain powder allows more air to pass between the sheets and therefore facilitates faster drying.

Dry the sheets in stacks of 200- 250 sheets.

Offsetting can occur if stacks are too large or the powder grain size is too small. Stacks that are too large may also obstruct airflow therefore slowing down drying time significantly.

Plan for 24 - 48 hours of drying time. Make sure the drying room has proper ventilation; this will speed up the drying process.

POST-PRESS

Stafix® can be die-cut and kiss-cut. Please avoid long thin shapes as they might curl away from the surface. Avoid sharp corners because they might cause the film to tear. Perforating and direct mail inserting are also possible. When trimming, use sharp, nick-free blades. Do not cut the glue lines in order to allow auto-feeding.

Please protect the products well from humidity when sending the finished goods to your client.

Avoid packing the material with products that emit VOC's (Volatile Organic Compounds / Solvents) they will reduce the static charge.

Stafix Ltd will not accept any claims or warranty on material that has not been handled according to these instructions.