

These guidelines are intended to help the designers and the prepress department to improve the printability and performance as well as for machine operators to improve the printability and performance of the STAFIX®STATIC -products.

DESIGN GUIDELINES

Avoid Total Ink Coverage (TIC) greater than 240%. Use Under Colour Removal (UCR) and Grey Component Replacement (GCR) when possible. Heavy deposits of ink should be avoided, especially near the edges of the artwork, to prevent the film from curling or rippling. Leave an unprinted border at the edges of the artwork if possible. Avoid overlapping a combination of two or more solid colours. Heavy layers of ink may cause the film to swell.

	SHEET SIZE	MAXIMUM PRINTABLE AREA
OFFSET	320 x 450 mm	300 x 440 mm
OFFSET	480 x 650 mm	440 x 640 mm
OFFSET	707 x 1000 mm	640 x 990 mm
INDIGO	320 x 460 mm	310 x 450 mm
UV-INKJET (sheets)	707 x 1000 mm	700 x 1000 mm
UV-INKJET (rolls)	700 mm x 50 / 100 m	700 mm

Please consult your printing house for more detailed information. A raster of 60 - 70 l/cm is recommended. Make sure that black text consists of only 100% black for better registration.

STORAGE GUIDELINES

Store the material at room temperature. STAFIX®STATIC should have the same temperature as the print-room before being unwrapped. The material should remain sealed in the original wrap until the STAFIX®STATIC material has warmed up to press temperature. The recommended relative humidity is 50% to 60% and the temperature 20°C to 27°C. The warming-up time depends on the pallet weight and the temperature difference between the warehouse and the print-room.

PACKAGING		WEIGHT	TEMPERATURE DIFFERENCE (°C)								HOURS
FORMAT		KG (APPROX)	5°	10°	15°	20°	25°	30°	35°	40°	
OFFSET sheets, 320 x 450 mm	Full pallet (2000 sheets)	80 KG	4	12	18	24	30	34	38	40	
OFFSET sheets, 480 x 650 mm	Full pallet (2000 sheets)	160 KG	8	24	36	48	60	68	76	80	
OFFSET sheets, 707 x 1000 mm	Full pallet (2000 sheets)	380 KG	14	33	47	61	75	84	94	98	
INDIGO sheets, 320 x 460 mm	One box (100 sheets)	5 KG	1	1	1	2	2	2	2	3	
UV-INKJET rolls, 700mm x 50m	One box (1 roll)	12 KG	1	2	3	4	5	5	6	6	
UV-INKJET rolls, 700mm x 100m	One box (1 roll)	22 KG	1	3	5	7	8	9	10	11	
UV-INKJET sheets, 707 x 1000mm	One box (50 sheets)	10 KG	1	3	5	7	8	9	10	11	

Once the STAFIX®STATIC -products have reached the same temperature as the print room you can unwrap the pallet. It is recommended to let the material acclimatize without the wrap / plastic bag for 2 hours prior to printing for better runnability. After use reseal the remaining, unused material in the original package. Sudden changes of temperature and/or humidity could wrinkle the film.

CLEAR STAFIX®STATIC -MATERIAL

When designing artwork that will be printed on clear STAFIX®STATIC -materials, create a separate file for the covering white. Please rasterize the covering white to 95%.

If you are printing stickers on the clear material that will be used for window advertising, it is recommended to print the image mirror-wise and to apply an additional covering white layer on top to reduce the transparency. The sticker should be installed with the unprinted side to the glass. Remember that not all the presses have white inks available; please consult with your printing house beforehand.

FINISHING POSSIBILITIES

STAFIX®STATIC -products can be die-cut and kiss-cut. Please avoid long thin shapes as they might curl away from the surface and try to round the inner corners because the inner-sharp corners might cause the film to tear. Perforating, binding and direct mail inserting is also possible. When trimming, use sharp, nick-free blades.

PACKING & SHIPPING

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) as they will reduce the static charge. Do not pack the material on vacuum-sealed packaging; the freshly printed ink can emit VOC's. Ship the materials flat. When shipping the roll material, do so by having the film on the outside.



OFFSET

Sheet-fed Traditional- & UV-Offset presses

ON PRESS

POSITION OF THE PRINTING PLATE: It is recommended to place the artwork close to the front of the sheet and leave an unprinted area on the tail of the sheet for better registration. The colour bar should be placed 2cm from the tail edge of the sheet. It is recommended to leave an unprinted area on the tail of the sheet.

FEEDING: Fan the sheets properly prior to loading. This is very important for better runnability. Run in short lifts of 200-250 sheets. Set the feeder settings for printing on thick materials. The STAFIX®STATIC OFFSET film is glued on to a cardboard by two glue lines from the long sides of the sheet. Do not cut the glue lines before printing. The sheet sizes 480x650mm and 707x1000mm have a cardboard margin on the tail edge of the sheet to allow for better feeding.



Strong air supply is essential for feeding STAFIX®STATIC. Position feeder air blowers so that the air separates the first 10-15 sheets to minimize blocking. Use additional side blowers if possible, and position them at the front of the stack. Run at max. press speed of 5000-7000 sheets per hour.

Print with low levels of water. STAFIX®STATIC absorbs no water and therefore very little water is needed (roughly less than half of what would be required with paper). If possible use metal plates that carry minimal water. The plate requires only enough water to keep the surface wet. For oxidative inks 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 any varnish or aqueous coatings! Coatings will eliminate the static charge and curl the material.

RECOMMENDED INKS FOR OFFSET	
TRADITIONAL OFFSET (OXIDATIVE INKS)	UV-OFFSET (UV-CURABLE INKS)
Flint Group Novaplast	Hostmann-Steinberg (NewV Poly Series)
Sun Chemical Foils 44, SunTec® Foils	Sun Chemical (Suncure Starluxe)

DRYING

TRADITIONAL OFFSET

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.

UV-OFFSET

Adjust the UV-lamps to a minimum level that still cures the inks but does not wrinkle the film. It is recommended that the heat of the lamps should increase progressively in the running direction of the material, applying less heat on the first lamps and more heat on the last lamps before delivery. When using a hybrid-printing machine turn off the IR lamps.



INDIGO

Sheet-fed HP Indigo® -presses

ON PRESS

Fan the sheets properly prior to loading. Place the sheets in the drawer for thicker substrates. For the 3000's and 5000's series set the blanket temperature to 145° - 150°C. The best registration is achieved by using "one shot mode" when printing. When using the "one shot mode" the blanket temperature can be set at 160° to 165°C. If you do not have the "one shot mode" available, in order to improve printing registration run the material using a null cycle before printing.

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



UV-INKJET

Large format UV- & UV-LED -curable printers

ON PRESS

The **STAFIX®STATIC UV-INKJET** film is printable with UV- and UV-LED curable inks only. The film does not have a receptive primer and therefore it cannot be printed with solvent or water based inks. Use gloves when handling the material.

Use flexible inks. Adjust the UV-lamps to a minimum level that still cures the inks but does not wrinkle the film. If the intensity of the UV-lamps is too high it may curl the material and reduce the electrical charge. Please use a printing profile suitable for non-absorbent substrates.

Avoid using the highest printing quality, it is recommended to use medium or low printing quality (approx.: 600 x 600 dpi). The maximum printing quality applies too much ink to the material and would affect negatively its ability to adhere to the surface.

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

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