

PREPARATION OF PRINT DATA FOR PRODUCTION OF POUCHES



MARTIN
PEROUTKA[®]

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For successful result of your job production it is necessary to observe the following rules at preparation of the graphic design and subsequently also of the printing data.

1. Data in 1:1 scale
2. Graphics in one independent layer
3. The lines (of cutout) in second independent layer in direct colour, named "vysek-cut"
4. The white ground tint (if any) in the third uppermost layer in direct colour must be named "bila-white" with the preset overprint
5. The minimum discrimination of bitmap figures is 300 DPI
6. The minimum font size are 3 points with positive and 4 points with negative font
7. The minimal line width is 0.25 point with positive and 0.3 point with negative line
8. The bleed size is 2 mm
9. The distance of motives and texts from the edge inside the cutout is min. 2 mm
10. EEAN – the barcode can be diminished to 80% of the original size only and increased to max. 200% of the original size

Most frequent errors:

1. The cutout lines are in CMYK
2. The data are in RGB colour mode
3. The data are not 1:1
4. The discrimination of the bitmap figures is lower than 300 DPI

In case of errors in the source materials obtained, based on agreement, the source materials are either returned to the client and new corrected data are requested or the corrections are carried out by us for a standard price of our DTP studio. In both cases the delivery term extension may occur. Therefore do carry out a thorough check of output sent for printing. By this you will spare both your and our time and last but not least, also money.

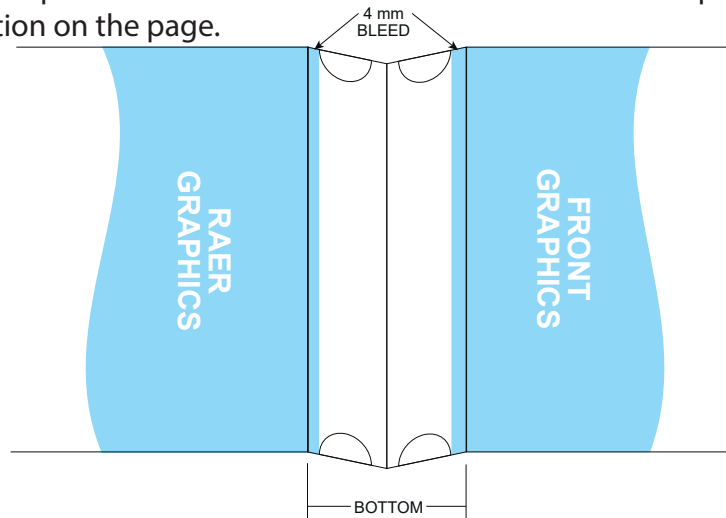
WE ARE NOT RESPONSIBLE IN ANY WAY FOR ERRORS IN THE SOURCE MATERIALS DELIVERED AND IN NO CASE WE CAN ASSESS THE "SENSE" OF THE GRAPHIC DESIGN!

- The best is PDF - minimally at PDF X3 version. After agreement it is possible to deliver also EPS, AI, PSD, bitmap
- If possible, do prepare the source materials always in curves (texts, logos, surfaces) and photos in raster.
- Do supply the printing data always with the merged transparencies.

PAY ATTENTION!! Pouches with paper surface can (mainly dark colors) change tinge of color in sealing

SIZES OF PRINTING DATA

The correct size of the printing data is one of the most important requisites for trouble-free processing without unnecessary extra charges for the DTP work. Set the document size always for actual size of the printed matter/product and set the bleed to minimum of 2 mm. In case the graphics reaches up to the bottom edge of the pouch, the bleed of 2 mm must be also on the front and rear sides of the pouch up to under the bottom fold. ALWAYS it is necessary to provide the actual size in the order. Do create the printing data always including the cut marks and information on the page.



RECOMMENDED DISCRIMINATION OF THE PRINTING DATA

- 300 DPI, line blocks 600-800 DPI. The resulting size of the document uses to be in MB units or tens order, e.g. 2-30 MB. If the resulting file is in MB hundreds order, mostly something is "wrong", such a file could be processed, but the processing demands and transmission times increase unnecessarily, etc. The graphic is responsible for discrimination, if you are not sure, the simplest way is to order a proof copy. Higher discrimination than 450 DPI with figures and 1200 DPI with curves mostly increases only the size of the printing data and it is of no great importance. It is necessary to cut the figures to sizes in which they are used. It is suitable to use the JPG compression with maximum quality setting.

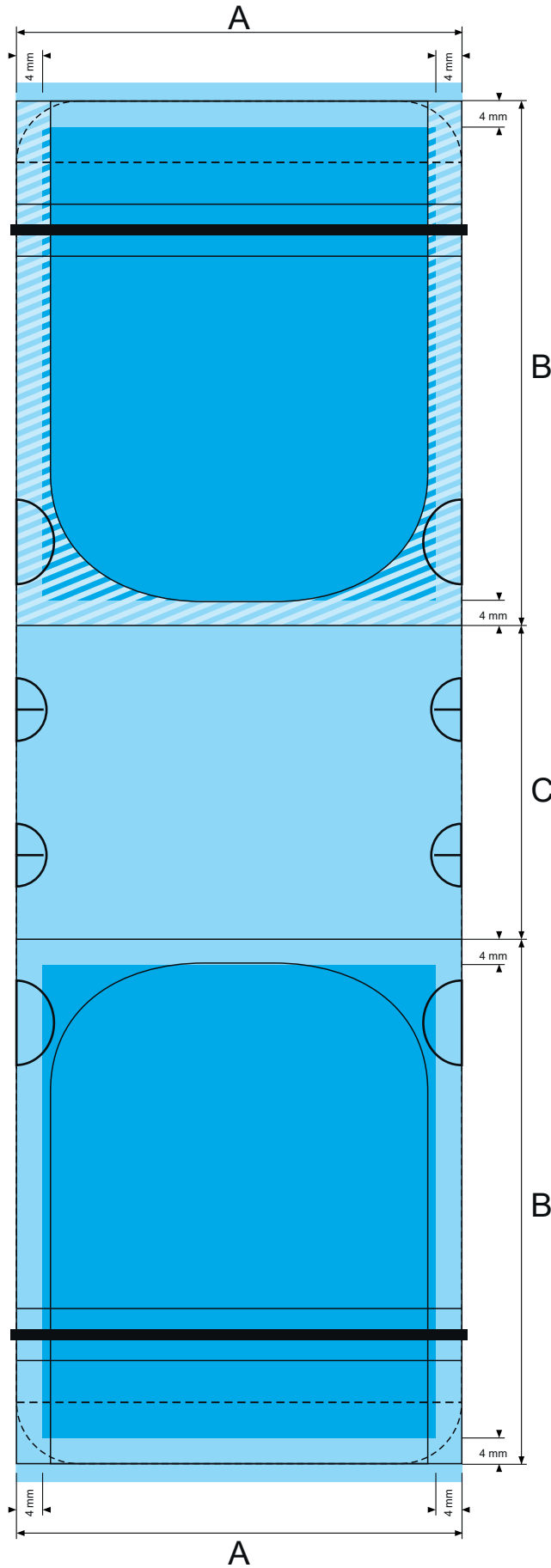
COLOUR SCHEME

The correct colour scheme of the printing data is the prerequisite for the source materials preparation. When the source materials with wrong colours or other colour models are delivered, an intense change of the output colours may occur (in such a case it is not possible to claim the wrong printing).

- All objects in the printing data must be in ISO Coated V2 colour profile in CMYK, possibly CMYK+Pantone or PANTONE only. Not in RGB!
- The document must not contain the objects with transparency settings. These objects must be rastered into a bitmap.
- At separation into CMYK do observe the maximum colour cover of 280 % with dark parts of the image (some of surface covering of the individual CMYK channels), please. Higher coverage than 280% doesn't mean higher saturation of black colour, but it brings about technological problems concerning drying of high colour layer and the quality and delivery term may be endangered.

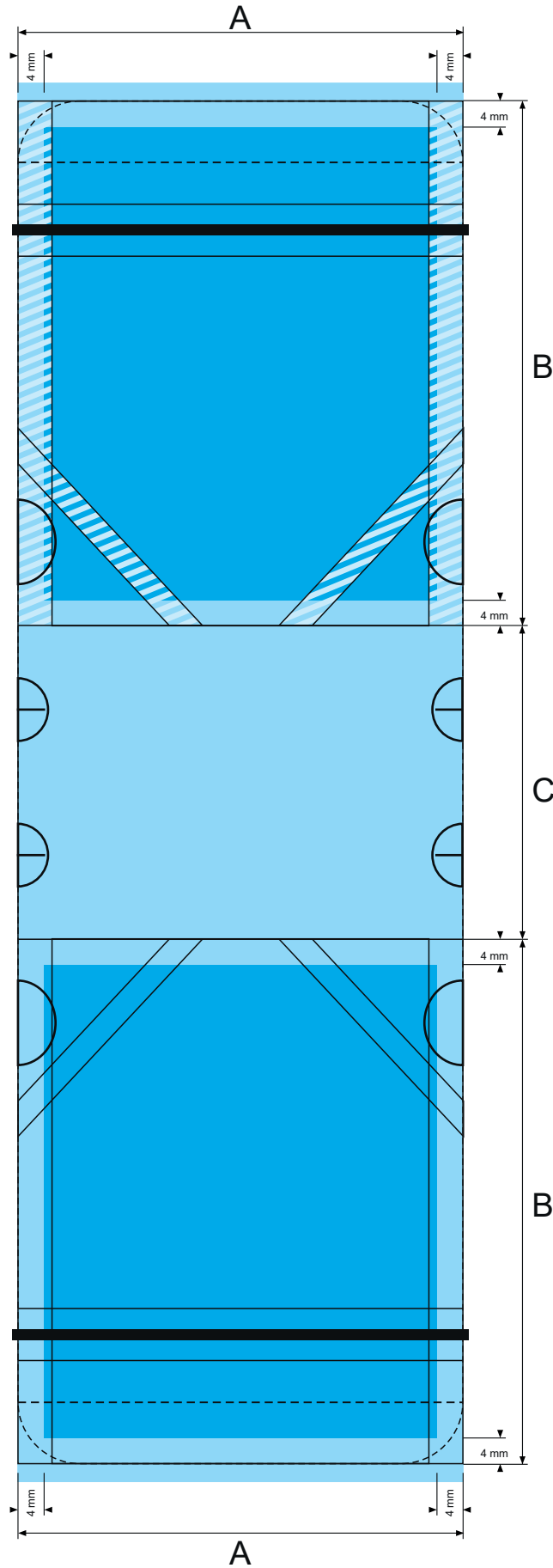
If the colour scheme specimen or other specification of colours (PANTONE, sample print, proof copy with print), we are not responsible for colour deviations of printing. If you don't have the colour scheme sample, we can prepare the digital proof copy for you.

FLAT POUCH „D” WELD



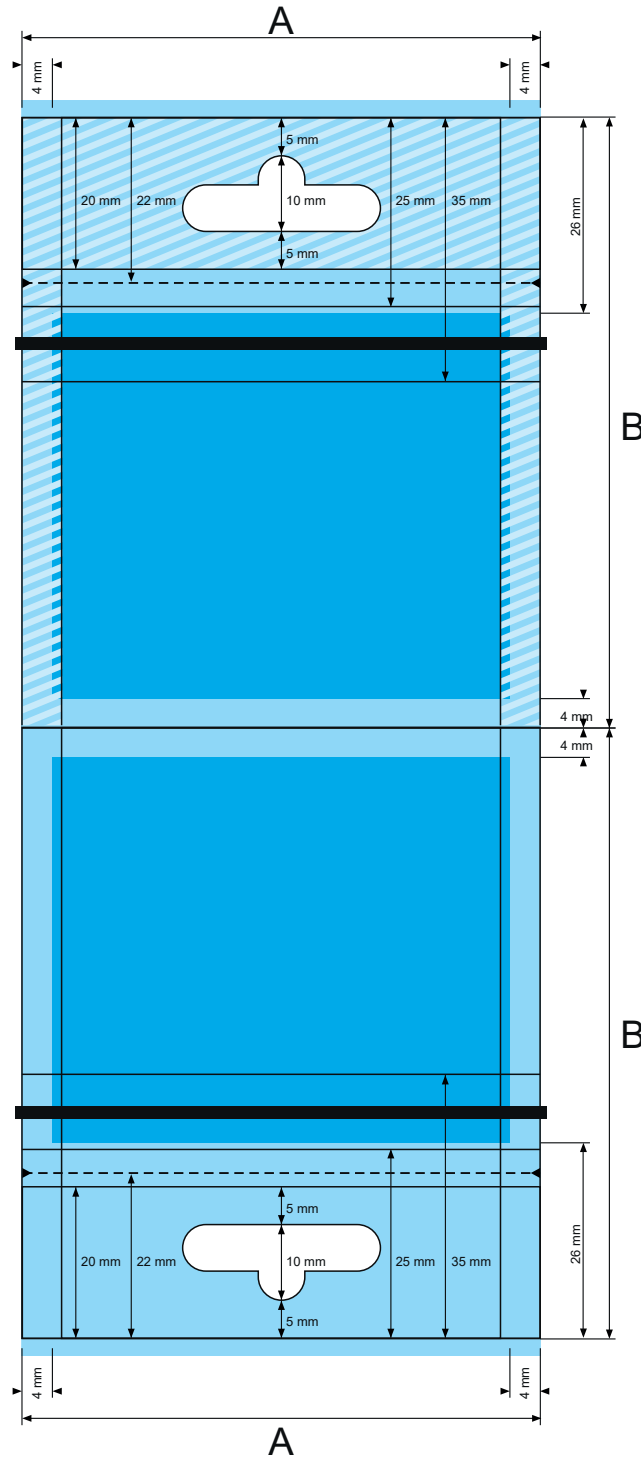
- A - pouch width
- B - pouch height
- C - bottom width
- print field
- text field
- weld

FLAT POUCH „K” WELD



- A - pouch width
- B - pouch height
- C - bottom width
- print field
- text field
- weld

**FLAT POUCH
WITH EURO HINGE
WITHOUT LOWER WELDING**



- 20 mm - weld zone
- 22 mm - tear-off height
- 25 mm - upper edge of the zipper
- 35 mm - lower edge of the zipper

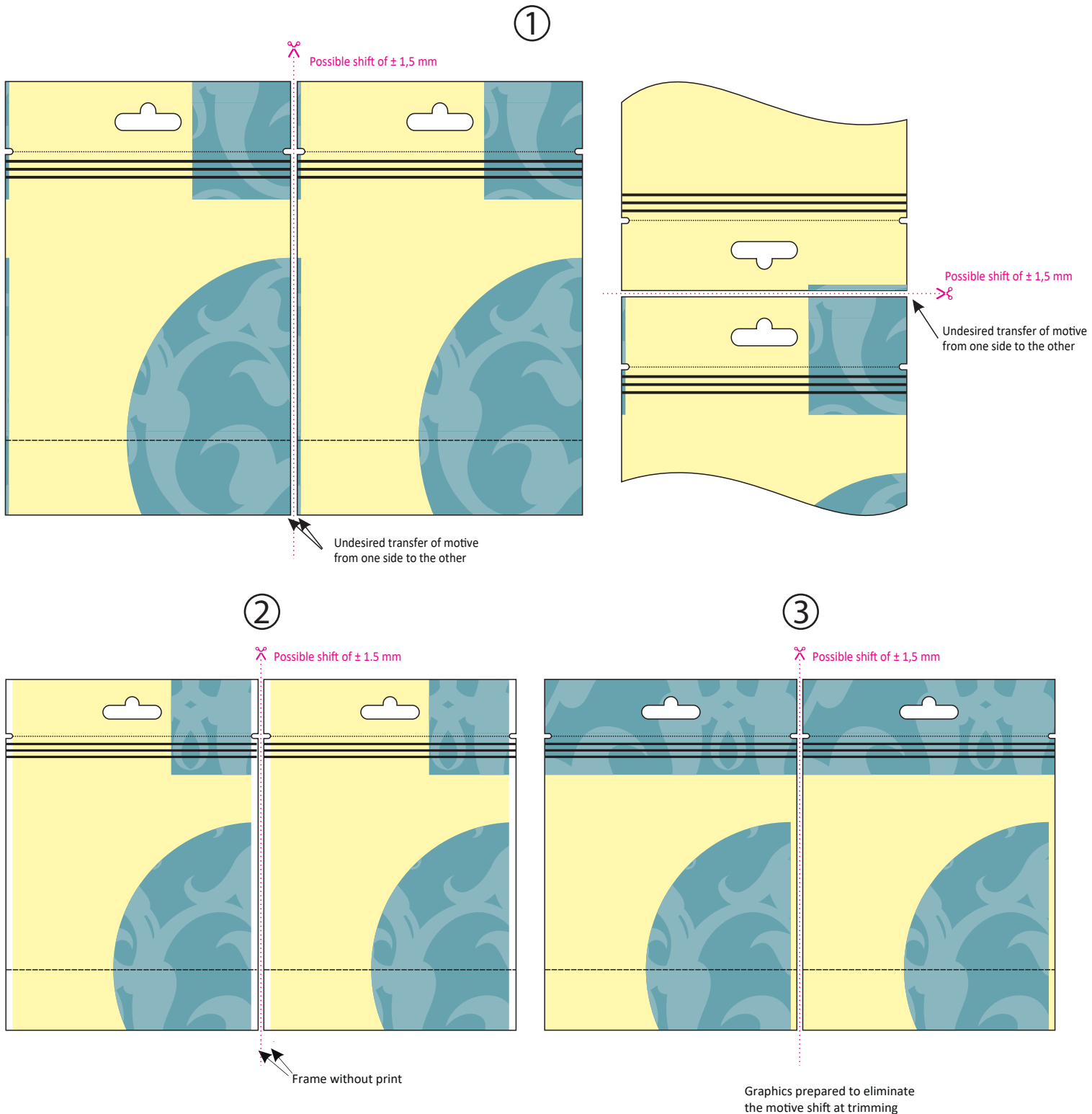
- A - pouch width
- B - pouch height
- C - bottom width
- Light Blue - print field
- Blue - text field
- Diagonal Hatching - weld

TECHNICAL POSSIBILITIES AND PRODUCTION TOLERANCES

At the pouch cutting to net dimensions there occurs the cut deviation of $\pm 1,5$ mm in vertical and horizontal direction. This causes the undesired shift of the motive to the opposite edge of the pouch.

There are the following solutions:

- 1) The customer knows of this and it does not worry him
- 2) Protective zone without print is left on the margins
- 3) The graphics has such concept to prevent the motive transfer



POUCH PRODUCTION OUT OF CUSTOMER'S MATERIAL

Requirements for additional material:

Additional material for pouch machine launch +70 m.

+3% of each order size to meet 100% amount of ordered pouches.

Roll change + 10m.

Between each order + 10m.

Last order on roll + 10m (remains in machine).

General requirements:

-The black mark for pouch machine must be 8x5 mm and must always be black!!! NOT transparent!!!

In the case of transparent and metallic material, there must be a continuous line in the black mark path white colour (also under the black mark).

The black mark must be printed even on the sacks without printing!!!

- Requirement for roll tube size: width Ø 76mm, thickness 10mm.

- Specifications of pouch min. and max. must correspond with company standards*.

- Roll max. diameter is 700 mm.

- **For each new material composition an internal test is required in order to adjust pouch machine for this material and test zipper compatibility. Zippers that are supplied directly by customer must be tested on a sample roll.**

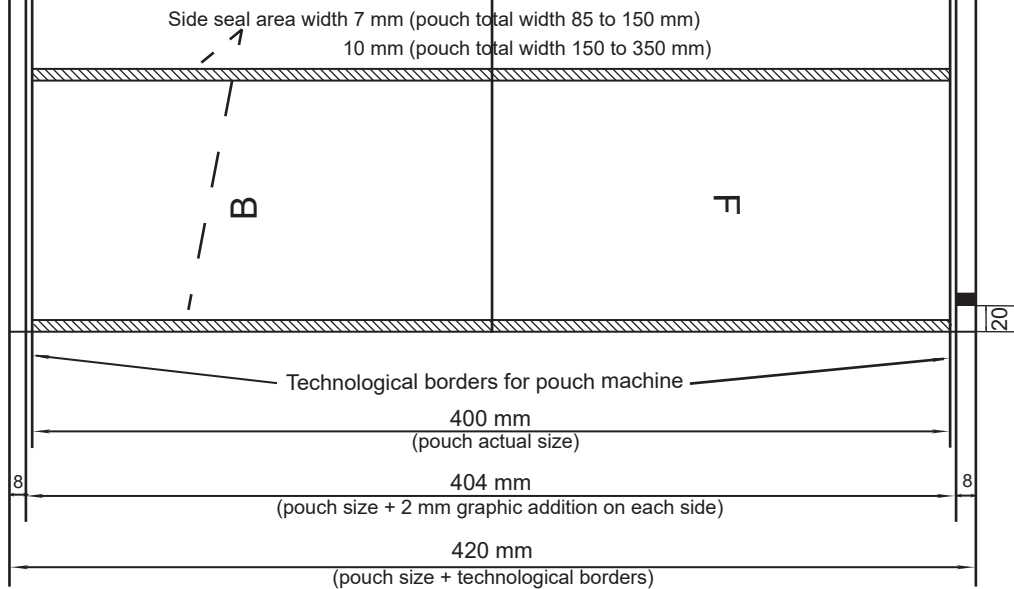
- FSC-certified products must be previously announced and managed according to FSC standards.

- Paper pouches that have graphics inside the heat seal area must be treated with a heat resistant varnish.

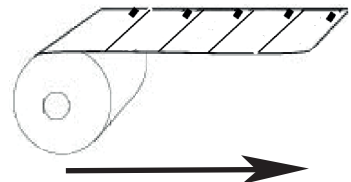
- COF(Coefficient Of Friction) values of inner layer should range from 0.1-0.25.

FLAT POUCH TECHNICAL DRAWING (EXAMPLE SHEET)

Technological borders 10 mm for pouch machine
 2 mm graphic addition + black mark 5 x 8 mm
 and must always be black!!! NOT transparent!!!
 In the case of transparent and metallic material,
 there must be a continuous line in the black mark
 pathwhite colour (also under the black mark).
 The black mark must be printed even on the sacks
 without printing!!!



Orientation of the roll
 entering pouch machine

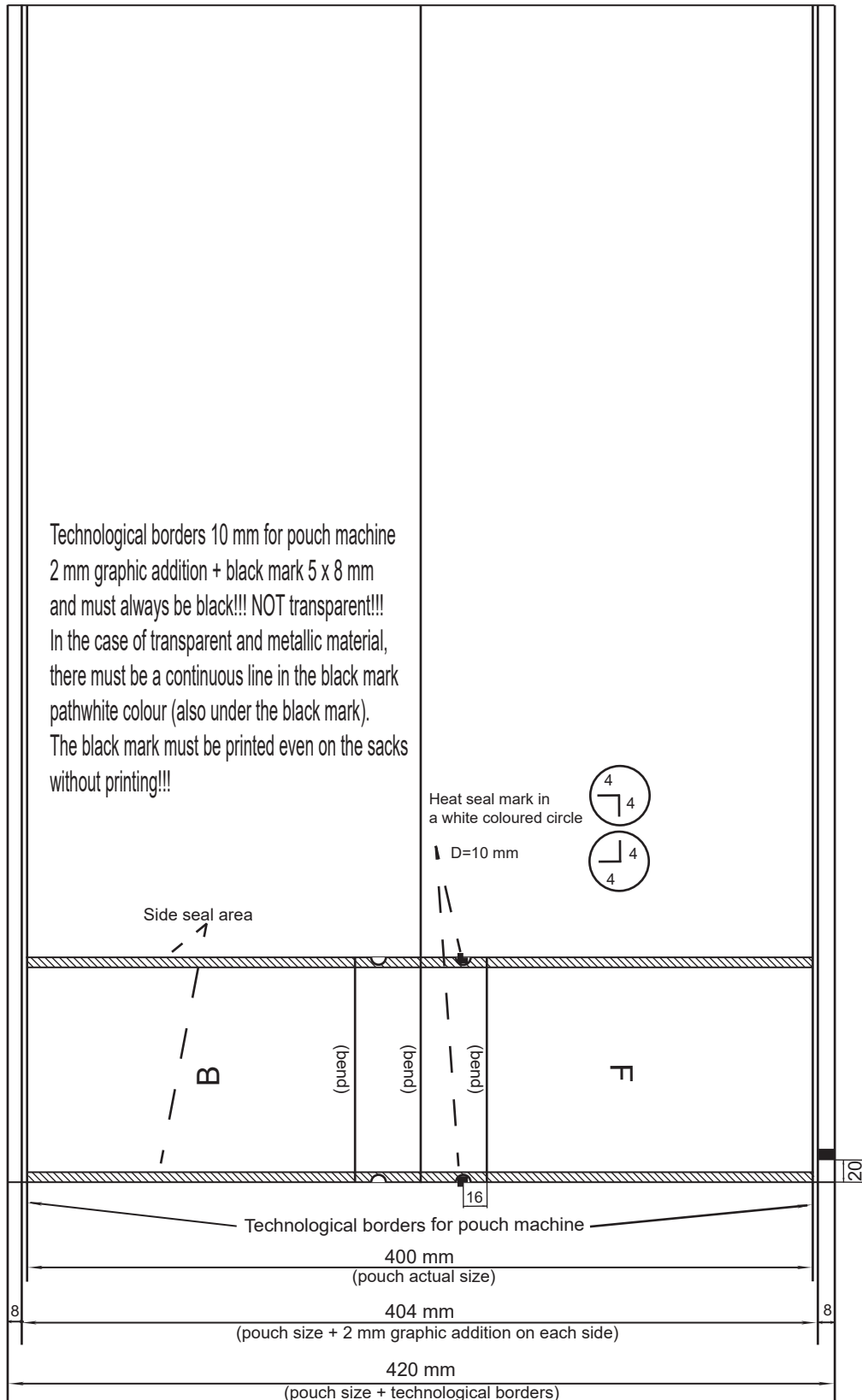


STAND UP POUCH TECHNICAL DRAWING (EXAMPLE SHEET)

Technological borders 10 mm for pouch machine
 2 mm graphic addition + black mark 5 x 8 mm
 and must always be black!!! NOT transparent!!!
 In the case of transparent and metallic material,
 there must be a continuous line in the black mark
 pathwhite colour (also under the black mark).
 The black mark must be printed even on the sacks
 without printing!!!

Heat seal mark in
 a white coloured circle

D=10 mm



Orientation of the roll
 entering pouch machine

