

PACKAGES CONVERTORS LIMITED	Document type: SOP			
	Title: BUFC Pre-Press Do's and Don'ts			

Prepared by Mobeen Hussain <i>Mubeen Hussain</i>	Approved by Salman Rehman <i>Salman Rehman</i>	PAGE 1(4)	REV 3	DATE 01.07.2024	DOC NO. WIART/BUFC/7.2.1/08
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1. Purpose:

To avoid missing any special operations in a job at OP and CC Machines.

2. Scope:

These instructions are applicable for CC and OP.

3. Overall Responsibility:

Overall responsibility lies with the Offset Line Manager.

4. Instructions:

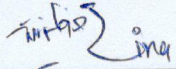
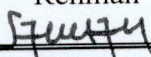
Colors.

- Following color sequence will be followed for offset jobs.

Black/Cyan/Magenta/Yellow/Special 1/Special 2/special 3/Water base/UV /
flexo gold

- Check list will be made as per above color sequence.
- CMS will be done as per mechanical color sequence.

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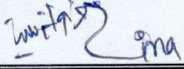
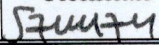
- Give outline in all thin text (reverse & direct).
- Black text should be over print in color areas
- Add extra bleed in overall artwork (end flaps, Folding flaps, Glue flap & Dust flaps) as per do's & don't
- Color strip or design repeat should be added on counter edge of pack for step & repeat A to B.
- Ensure Glue flap and coding area should be unvarnished
- please get rub resistance test for unvarnished job while ink development jobs.
- Metallic Gold and silver will be finishing color for printing can be change in approved sequence by production if required.
- job Design elements should be discussed if upper than 2 color mixing
- Color matching reference should be one for job printing
- For both side printing jobs water base and uv/Drip off and any kind of varnish design should discuss with offset.
- Following things should be discussed while design making with offset team in case of New and design change jobs 1,colors/2,water base print/3,uv print/4,flexo gold/5,offset gold and silver/6,Drip off and any kind of special operation.

Font:

- Minimum text size for direct printing is 4 points.
- Minimum text size for reverse printing is 4 regular but could be less than 4 even if bold
- Text and reading graphic should 2mm to 2.5mm away from the cutting & creasing.
- For embossing, minimum text width should be 1mm.

Bleeding:

- Bleeding will be 3 to 5mm on different flaps for normal carton
- Bleeding will be 2.5 to 3 mm on glue flap for normal jobs.
- Bleeding will be 2 to 2.5mm on end flap without middle cut.

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- Color strip or design repeat of 3 to 5 mm will be added on counter edge of pack to avoid the Cut to Print bleed issue during CC and FG operations after printing.

For Fluting Designs:

- Bleeding will be 7 to 8mm on different flaps for fluting jobs.
- Bleeding on glue flaps for fluting will also be 7 to 8 mm
- Text and graphics from cut and crease will be 5mm on fluting jobs.
- Color strip of 7 to 8 mm will be added on counter edge of pack to avoid the Cut to Print bleed issue during CC and FG operations after printing.

Trapping:

- No keep-away should be there in text for normal jobs.
- Color to color trapping for offset inks will be 0.2mm.
- Trapping for flexo inks will be 0.3 to 0.4mm where possible.

Embossing:

- Embossing should be away 5 mm from the cutting and creasing.
- Embossing should have the structure's main line thickness up to 1mm.
- Embossing and De-bossing should always be done in separate operations.
- Embossing/de-bossing should never be done with creasing rules.
- Any embossing with width less than 1mm should only be done through metal based embossing.

UV/WB Reference Line:

- UV/WB reference line should be mentioned in KLD by development and then designer will apply in any appropriate color of design to be printed.

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Hot Foil

- Hot foil trapping will be on printing 0.2mm to 0.3mm but should be overprint normally.
- Hot foil area must be unprinted and without any varnish with 0.5mm inner bleeding.

Expert Cut Machine

- We must need 2.5 mm to 4 mm white area (unprinted) both side of camera reading mark in angle & stopper sides.
- For different sized boards in same job/same PO, angle side mark to be kept at same distance from sheet edge (angle side)
- For board size variation greater than 20mm, change angle mark or print double angle mark on angle side

Traceability

- Angle mark required on normal jobs 1.
- Different color Angle mark required for export and similar jobs 2.
- For export/similar and combine layout jobs traceability color box will be on carton flaps in art work to avoid mixing on packing area. (should be checked in CTP)

Special instructions

- . Use a buff color beneath flexo inks. Use the basic yellow color for buff or consult otherwise.
- . Special/New jobs will be discussed with OP

New Jobs Must be Discussed with CC team!