



# KROMEKOTE COLORS METALLICS/PEARLESCENTS FOILS

**PRODUCTS:**

Kromekote Colors – This palette of four fundamental colors includes: Black, Ultramarine, Red, and Crème.

Kromekote Metallics – Clean and distinctive, our line of metallics includes: Gold Metallic and Silver Metallic.

Kromekote Pearlescents – With luster and an understated elegance our pearls are presented in: Frost Pearl and Ice Pearl.

Kromekote Foils – This line includes bold and distinctive foils available in five reflective shades including: Glossy Black Foil, Silver Foil, Gold Foil, Platinum Foil, Brushed Silver Foil and Brushed Gold Foil.

**PRODUCT FEATURES:**

All Kromekote Colors, Metallics, Pearlescents and Foils are cast coated with an added distinction of color. Our non-cast side is matte coated and guaranteed for four color work.

**SPECIFICATIONS:**

**Colors, Metallics, Pearlescents:**

Caliper	Basis Weight *	GSM
12pt	169	247

**Foils:**

Caliper	Basis Weight *	GSM
13pt	193	286

\* Calculated using 25x38 / 500 sheets

**SPECIALS:**

Kromekote Colors, Metallics, Pearlescents, and Foils are available in standard stock 40x26. Custom sizes, custom calipers, and custom colors are available on manufacturing orders for 4000 lbs. minimum. Allow 6-8 weeks for delivery. Allow 2 extra weeks for custom colors for laboratory match plus sample approval. All custom orders will require special price quote dependent on color, size, and quantity.

# HANDLING/STORING - PRINTING - FINISHING INSTRUCTIONS

*All four of these Kromekote paper surfaces have been sealed with a very glossy coating, effectively sealing the sheet and therefore preventing any absorption of the ink into the sheet. This is opposite of our normal Kromekote surface that is known for its ease of printing. For that reason, it is imperative to follow the suggestions below to achieve optimal performance with these Kromekote grades.*

## PAPER HANDLING & STORAGE

- The acclimation of Kromekote Colors, Metallics, Pearls and Foils to press room conditions is recommended for at least 24 hours prior to printing. Keep paper in original packaging until ready to use.
- Paper should be printed and converted at room temperature (59-77°F, 15-25°C) with relative humidity at 40-60%.
- Any unused paper should be re-wrapped and stored in its original package in a flat, cool, dry environment away from high temperatures, humidity and exposure to light and seal the carton with tape.
- Since these sheets have mirror-like gloss and are ultra smooth, even the slightest surface scratches can be noticeable. Therefore, when printing the back-side either first or last make sure you regularly check the front side for scratches caused by feed belts, guides, leaders, slow down wheels etc. on the press. Great care should also be exercised in finishing operations to avoid marring the surface.

## PRINT INSTRUCTIONS

### UV Ink Systems

- UV inks are highly recommended with inter-station curing which aids in dry ink trap.
- This sheet will run in much the same manner as any coated sheet or synthetic substrate.
- We recommend inter-station curing as opposed to post curing. If post curing and using opaque white as a base for process colors, the white has to be cured first.

### Conventional Offset Inks

- Conventional inks will not dry; have your ink supplier formulate inks for this sheet. Give a paper sample to your ink supplier for testing.
- Only use inks that dry by oxidation. Since they are not absorbed into the sheet, they must dry from the top down – this greatly increases drying time.
- Because there is no absorption, wet trapping is more difficult if there is too much under-color.
- When using opaque white as a base for 4/color process, print the opaque white first and let it dry before printing process colors over it.
- Allow ample time to dry between passes or converting; this can be from 24-48 hours.

### Press Conditions

- Keep dampening to a minimum. The sheet will not remove excess fountain solution from the blankets, thus increasing the risk of ink emulsification.
- Emulsified inks will not give optimum print results and will slow down ink drying even further.
- Keep fountain solutions as close to neutral as possible.
- In light take-off areas, ink consumption may be insufficient to prevent emulsification. Print color bars or patches in trim areas to move more ink through the ink train.
- Waterless printing is an excellent choice for Kromekote Colors, Metallics and Foils as it eliminates the ink and water issues with this non-absorbent sheet.

### Press Conditions (Continued)

- It is recommended printing small lifts no more than 3-4" high to prevent offsetting or set-off. With no absorption, all the ink is on the surface. That, combined with very slow drying, creates an environment for offsetting. We recommend trying the job on press.
- It is advisable to aqueous coat in-line depending on the amount of under-color. Too much ink under the aqueous coating can cause the aqueous coating to craze or crackle as it dries so quickly over the wet ink. If this happens, it is immediate and would mean the coating will need to be done as a second pass.
- If not aqueous coating in-line, anti-offset powder must be used. Use a micron size large enough to prevent set-off but fine enough not to get that "sand paper" feel.

- Additional printing and/or converting should not be done until the sheet is completely dry; this can take up to two full days. Even on aqueous coated sheets, the ink underneath the coating needs sufficient time to dry.
- As soon as the ink has set-up sufficiently for sheet handling, we suggest re-piling and winding the loads to speed up the drying process.
- Keeping both the feedboard and feed belts clean will reduce marring and scuffing of sheet surface. Additionally, inspection and replacement of any frayed or rough belts prior to running will eliminate this marring/scuffing.
- Keep the pressure as light as possible on the feedboard wheels, especially the ones in contact with the top when it stops at the head stops and the sheet under it is still moving forward. Slowing the press down can help.
- Clean all the feed guides and perhaps use a light coat of wax or silicone where they contact the sheet.
- If scuffing or light scratching occurs on the finished job, aqueous or UV coating the sheet will normally clear up any surface blemish.

## **FINISHING**

- To avoid marring the surface, continue to exercise great care in handling during finishing.
- Kromekote Colors, Metallics, Pearls and Foils are excellent substrates for embossing and foil stamping. Consult your foil supplier for more information.
- If you plan to foil stamp or perform any subsequent printing after aqueous coating, consult with your coating supplier to be sure that the coating you have selected is compatible with foil stamping.
- If you plan to perform any subsequent printing or surface treatment after aqueous coating, consult with your coating supplier to be sure that the coating you have selected is compatible with your final treatment.
- **Scoring and Folding:**
  - For best results, score before folding; scoring on press is not recommended.
  - Make sure to follow the grain direction for working folds. Stationary folds should run across the grain.
  - To avoid cutting through the coating, use a roundnose or bullnose rule that is two times wider than the thickness of the stock being folded. If this is unsatisfactory, try widening the score for a fatter score or tightening for a thinner one. To soften a score, try placing a thin polyester film mylar over the metal score.
  - Avoid scores that are too narrow or too shallow and channels that are too narrow or too wide. A score is deep enough when a pronounced ridge shows on the reverse side. Fold with the ridge on the inside and the score on the outside.
  - To prevent breaking and cracking of the ink along the fold line, avoid scoring or folding over printed areas. SMART Papers cannot guarantee that there will be no cracking on a fold placed directly through a solid printed area.
  - Use a bulking dummy to ensure proper placement of scores for spines and hinges.
  - Make sure the spine is the appropriate size for the contents.
- For Kromekote Foils that require die cutting, it is recommended that a die cut proof be completed before printing the job. The sheet has a film surface and therefore may die cut differently than coated cover stock.

*For additional information regarding SMART Papers,  
please visit [www.smartpapers.com](http://www.smartpapers.com)  
or call 800.443.9773.*