

Fact Sheet N°7



Printing on Kallima

Best practices



The printing and finishing processes are complex – so many variables need to be accounted for with each project in the pressroom.

Kallima Coated Cover is compatible with most printing techniques, as long as **industry best practices** are followed.

CONDITIONS

Dampness, dryness,
dust, cold or heat



In the warehouse, paper should remain in its original packaging, in an environment free of excessive **dampness, dryness, dust, cold or heat**.

In the pressroom, ideal conditions for paper are **50% relative humidity** and **73 degrees Fahrenheit**.

MOISTURE

The cellulose fibers used to make paper have a strong affinity for water.

Paper will **quickly lose or absorb moisture from the ambient air** to achieve equilibrium with its environment.

Kallima products are shipped in moisture-repellent packaging.

Rolls, skids or cartons should have ample time to acclimate to pressroom conditions and be **unwrapped right before printing**.





Unprinted paper should be immediately **rewrapped** and **sealed**.

After allowing time for loads of printed material to dry and cool, they should be **covered in plastic between processes**.

Variations in the moisture content of paper can affect its **dimensional stability**, making it **shrink, expand** or **curl**.

A dry environment can also lead to **static electricity issues**, which can cause jams, poor jog, ink smearing and bindery problems.

ACIDITY

Kallima Coated Cover is **Acid Free**.

Most paper made today uses an **alkaline process**, which is more environmentally friendly and essential for archival documents.

An overly acidic press chemistry can cause problems like calcium carbonate buildup on the blanket.

We recommend using a fountain solution with a **pH between 4.5 and 5**.

pH between 4.5 and 5



BACK TRIMMING & KNIFE ANGLES

When it comes to guillotine cutting, one edge will always be rougher than the other – the edge opposite the clamp.

Back trim to get cleaner edges:

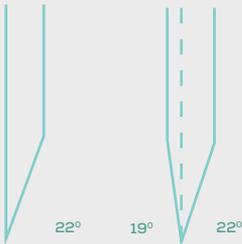
1. Turn the pad
2. Cut off the edge that was opposite the clamp

Where back trimming isn't practical, we recommend specific **knife angles**:

Single bevel knife 22°
Double bevel knife 19° then 22°

POST-PRODUCTION PROCESSES

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