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Instructions for printing on SMart

Feeder

- 1 SMart paper can be printed at up to 8,000 impressions per hour depending on the type of press used.
- 2 Air velocity applied to SMart Paper should be at least 10% stronger than regular paper.
- 3 If difficulty occurs in feeding the paper, this problem may be resolved by increasing the air velocity on the sheets or reducing the number of sheets per pile.
- 4 SMart Paper can be affected by static electricity. It is recommended that static eliminators be used and that the relative humidity of the press room be maintained at 50% or above.

Printing unit

- 1 Integrated colour removal (i.c.r) or gray component replacement (g.c.r.) in the colour separation process can reduce ink consumption and set off.
- 2 It is recommended that SMart Paper is printed using scuff resistant (hard drying) offset inks. Consult your ink supplier for optimum results. Expensive synthetic types of ink are unnecessary in most cases. Obviously, if the job must survive outdoors then light fast inks are required to minimise fade.

Dampening solution

- 1 A 10% alcohol fountain solution is recommended. Ph level should be maintained around 4.5 - 6 and temperature of solution around 15°C.
- 2 Since SMart Paper has low water absorption properties, poor ink transfer may be the result if there is excess water on the plate surface. Excess water on the plate may also reduce the ink's concentration in multicolour printing processes, causing ink emulsion, and will require longer time for drying.

Delivery unit

- 1 Use a fine powder for spraying. Generally, spray 30% more than for normal cellulose paper. Actual applied quantity is based upon the printing conditions and the amount of ink coverage. Reduce the amount of spray powder if the job is to be backed up.
- 2 Apply the least wheel pressure on the printed SMart Paper during delivery.

Drying

- 1 Since SMart Paper has low absorption for ink, it is necessary to place the printed paper on the rack for drying to avoid set off.
- 2 The pile height for SMart Paper on the rack is recommended not to exceed 200mm.
- 3 When the pile of the paper reaches the allowed height on a rack, stop and use a new rack.
- 4 Make sure that there is no impact on the pile of the printed paper until the ink is dry.
- 5 Approximate drying times are :two colours 4 - 6 hours, four colours 6 - 8 hours.
- 6 Cutting & finishing should be left until ink is dry. This depends on the amount of ink carried on the job and the kind of press used.
- 7 Infrared drying can effectively reduce the drying time, but room temperature also significantly affects the drying time.
- 8 Two thirds of the drying time can be saved if alcohol dampening systems are used in conjunction with infrared drying.
- 9 If using infrared drying, adjustments will be necessary to avoid overheating the SMart Paper and causing deformation of the sheet.

The above instructions are a guide only and testing prior to running the job is always recommended. Please contact Stockman Paper Merchants if further details are required.