



Flexible Packaging Printing Specifications

Please note: These guidelines serve as an overview of our printing parameters. Some of this information may pertain to your design. Please review the information carefully and contact the graphics department with any questions.

File Format:

- Files can be accepted in Photoshop and Illustrator format.
- PDF's must be unlocked, layered, and fully illustrator editable.
- Files can be submitted via FTP, Email, CD/DVD, or another electronic download.

Placed Images / Scans Linked Files:

- All placed or linked images must be provided and should be a minimum of 300ppi at the printed size.

Fonts:

Please supply both outlined and live font versions of your illustrator file. If using postscript fonts make sure to include all printer and screen fonts. We have an extensive library of fonts but we do not have every font. Missing fonts can delay the process.

Type & Text:

- Positive Type - Minimum of 5 point. ® and TM can be as small as 4.5 pt.
- Reverse Out Type - Minimum of 6 point.
- Multi-color Build Type - Minimum of 8 point.

Please note: These specs are based roughly on Helvetica Normal/Regular. Very bold fonts or fonts with curvy tapering and fine lines do not reproduce well at very small sizes. Garlock may have to adjust type or print during initial proofing process.

Rules & Lines:

- Positive Rule - Minimum 0.4 point (.007")
- Reverse Out Rule - Minimum of .75 point (.01")
- Multi-color Build Rule - Minimum of 1.5 point (.02")

Trapping:

- Standard Flexible Packaging trapping is 0.008"

Keylines:

- Keylines may be required for registration reasons for example, text that is reversed out of CMYK builds.
- Small type under 15 pt: 1.0 pt stroke / 0.5 pt visible - allows for .0035" trap
- Medium type 16 pt - 30 pt: 1.5 pt stroke / 0.75 pt visible - allows for .005" trap
- Large type 31 pt and up: 2.0 pt stroke / 1.0 pt visible - allows for .007" trap

Plate Breaks: and Edge Hold Backs:

All jobs using flat plates will require a minimum plate break of .1875" (.09375" on top & bottom.) Jobs that are not quoted to bleed off the edges will require a .0625" ink hold back from the edges. See Double Cut for more information about our Pouch & Bag designs with a full bleed.

Micro Dots:

Garlock flexographic presses require registration microdots. Please do not add crosshairs or BST marks. A minimum of two 0.016" dots will be added to the outside edges of the web. Jobs more than 30" wide require an additional microdot at the center of the web.

●● Spot Color 100% & 50%

● Spot Color 100%

Standard process-color marks



Printers Mark & Tone Scales:

Garlock has standard mark sets which are determined by job type, ink bleed, tone scale placement and double pass varnish options. For the most accurate color and quality we recommend placing the print tone scales inside the impression.

- All blocks to be .1875" X .1875" Circles.
- Process colors are to have 1%, 50% and 100% blocks. The 1% and 50% for each color are grouped together. The 100% blocks for process colors are grouped together.
- Line colors with screens requires 100% and 50% blocks grouped together.
- Any line color without an area at least 0.25" square requires a 100% block so ink density can be checked.
- Garlocks Printers Mark must be included in the tonescales.

Colors:

Our flexographic presses can print up to 10 colors. Varnish counts as a color unless it's a registered varnish. Registered varnish is applied on the second pass (surface) after the main design has printed in reverse.

Hard Copy Proofs (Color Targets):

If your design includes process colors please supply a color target. A color target is anything tangible that you are going to compare to our Contract Proof for process color approval.

Dielines:

Please provide a dieline which shows the proper placement of the eye marks (when applicable.) All jobs being converted into a pouch or bag at Garlock's facility must have a die line created by Garlock Flexibles.

Double Cut:

Garlock offers double cut bags and pouches. This enables inks to bleed to the edge of the product as opposed to having clear/unprinted edges. If this option is desirable please request your estimate to be quoted as a double cut and communicate this to the graphics department when the art and dieline is being addressed. A double cut requires wider material so this information is needed in advance.

UPC Codes:

Garlock will only guarantee the scanability of UPC codes that meet the criteria listed below.

- UPC-A or EAN styles at 100% mag or larger the BWR should be .005" - .0055"
- UPC-A or EAN style at 95% mag or smaller the BWR should be .003" - .0035"
- UPCs on process black plates with 100% mag or larger the BWR should be .004"
- UPCs on process black plates with 95% mag or smaller the BWR should be .003" - .0035"

UPC Rules & Regulations:

- Minimum magnification 80%
- If bar code is less than 100% magnification it must run in press direction.
- 0.15" left and right of UPC code must be free of art as a "quiet zone."
- UPC bar codes need to be backed by white if printing on clear film.
- UPC bar codes must print in a color with reflectance value of 5% or less (see table below.)

UPC colors with a 5% Reflectance or less, which we know will properly scan:

273	288	303	320	335	350	432	504	548	626	653	2745	2766	3025	3282	3405	5473
274	289	307	321	336	354	433	532	553	627	654	2746	2767	3035	3285	3415	5535
275	293	308	322	340	355	438	533	554	633	655	2747	2768	3135	3288	3425	072
276	294	309	323	341	356	439	534	560	634	661	2748	2965	3145	3292	3435	Spot K
280	295	312	327	342	357	440	539	561	639	662	2755	2955	3155	3295	5185	Proc.
281	296	313	328	343	378	445	540	562	640	801	2756	2935	3165	3298	5255	K
282	300	314	329	347	412	446	541	567	641	1545	2757	2945	3272	3302	5395	
286	301	315	330	348	419	447	546	568	647	2728	2758	3005	3275	3305	5463	
287	302	316	334	349	426	497	547	569	648	2738	2765	3015	3278	3308	5467	