

	CARTONS	ENCLOSURES	FLEXO LABELS	DIGITAL		FLEXPACK POUCHES
				CARTONS	LABELS	
Trap	0.003"	0.003"	0.007"	N/A		N/A
Bleed	0.0937"	0.125"	0.0312"	0.09375"	0.0625"	0.0625"
Copy to Edge NOTE: Descenders & Ascenders are considered as copy unless noted in spec	0.0625"	0.125" minimum 0.1875" preferred	0.0312"	0.0625"	0.0312"	0.0312"
Print to Print NOTE: Descenders & Ascenders are considered as copy unless noted in spec	Litho Printing= .0156" Flexo Printing= .0312"	Litho Printing= .0156" Flexo Printing= .0312"	0.0312"	0.0312"	0.0312"	0.0312"
Maximum Size					23.875"	See Pouch Sizing Reference Sheet
Hole Punch		Copy free to edge of text must have a minimum 3/4" where 3-hole punch occurs				
Minimum Positive Font Size*	3 pt	3 pt	3 pt	3 pt		3 pt
Minimum Negative Font Size**	3 pt	3 pt	3 pt	3 pt		3 pt
Minimum Dot	1%	1%	2%	1%		1%
Line Screen	175	Gurnee: 150 Lockport: 133	133	175		175
Perforation		0.5" gutter (0.25 in both sides)				
Press Perforation		0.25 - 0.375" gutter (0.125 - 0.1875" both sides)				
Special Features (Embossing, Debossing & Foil Stamping)	0.25 pt	0.25 pt	0.5 pt	0.25 pt		0.25 pt
Minimum Positive Rule	0.25 pt	0.25 pt	0.5 pt	0.25 pt		0.25 pt
Minimum Negative Rule	0.5 pt	0.5 pt	0.75 pt	0.5 pt		0.5 pt
Micro Text	1 pt	N/A	1 pt	1 pt		1 pt
Maximum Number of Colors	6 + Coating Bridgeview: 8 + Coating	Gurnee: 4 + Varnish Lockport: 4 colors	10 + Varnish	4 CP + Indichrome		4 CP + Indichrome

PRINTING TOLERANCES



Barcodes: We require a bar width reduction of 10% of the narrow bar width to be applied to all codes with a narrow bar width over 10 Mils, and 0.5 Mil reduction if the narrow bar is 7.5 - 9.9 Mils. Check that proper Quiet Zone requirements are met. All narrow bar ratios should be 3.0:1 where applicable. Minimum UPC magnification factor is 80%, any factor less than 80% will require a deviation letter. Digital labels require an 11.5 mil minimum narrow bar for Data Matrix codes.

Art File Requirements/Guidelines: The following are basic guidelines for art file submission.

File formats (Mac): PDF, EPS, Tiff, Adobe Creative Suite

File transfer: CD, DVD, Flash Drive, E-mail or Upload to a FTP site.

File should include:

1. Die Outline Layer if job requires die-cutting
2. Varnish and/or Varnish Knockout Layer if job requires coating
3. Braille Layer if job requires braille
4. Show Color and Line Breaks
5. List PMS and Special Colors
6. Include all linked support files (fonts, barcodes, eps, scanned images, tiffs, etc.)
7. Do not flatten files and include layers if possible.

Carton Litho Screen Angles:

K 75°, C 15°, M 45°, Y 0°

Ink Sequence: K, C, M, Y, PMS or Spot (based on Ink Tack)

* Customer Logos, Brand/Drug names with Superscript/Subscript @s and TMs is to be a minimum 1/32" high for the TM and bold, and for the ® 1/32" in circumference and bold. Any deviation to this will be printed as is.

** 3 pt font is generally acceptable as a minimum negative font size but may require adjustment based on artwork.