



	CARTONS		ENCLOSURES		FLEXO LABELS		DIGITAL CARTONS LABELS		FLEXPACK POUCHES	
	Trap	0.003"		0.003"		0.007"		N/A		N/A
Bleed	0.0937"		0.125"		0.0625"		0.09375"		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"	
Print to Print NOTE: Descenders & Ascenders are considered as copy unless noted in spec	Offset Printing: .0156 Flexo Printing: .0312		Offset Printing: .0156 Flexo Printing: .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 0 pt HD Plates Req		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" both sides)							
Press Perforation			0.25 - 0.375" gutter (0.125 - 0.1875" both sides)							
Special Features (Embossing, Debossing & Foil Stamping)	0.25"		0.25"		0.5 pt		0.25"		0.25 pt	
Minimum Positive Rule	0.25"		0.25"		0.5 pt		0.25"		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		Gurnee: 5 + 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 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.)
- 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 Superscripts/Subscripts with @'s and TM's 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.

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

REF Form #05-25 SONDER PAK