File Submission Guidelines

Electronic File Requirements

- Layered Illustrator CC or Normalized PDF file.
- All text outlined and/or fonts provided.
- All supporting images must be provided. Images must be CMYK format (ok to include spot colors), and a minimum resolution of 300 ppi or higher when the image is scaled 100%. Layered Photoshop PSD files preferred.
- File should be set up with correct Pantone colors applied.
- File should be clean with no trapping.
- File is not to contain unused colors, layers, and hidden or extra objects.

Print Type	Decoration	# of Printing Units
• Flexo • Rotary Screen • Digital	• Hot Stamp • Emboss / Deboss • Rotary Tactile • Cold Foil	10 Maximum (includes primers & varnishes) + Emboss & Die Cut

Die Cut

- Minimum Corner Radius = .0156"
- All text must be inset a minimum of .0625" from the die cut.

Standard Substrate Options

- **Film:** Clear, White, or Metallized
- **Paper:** Metallized, Semi-Gloss, High-Gloss, Uncoated

Flexographic Printing

- Standard Line Screen is 150lpi-178lpi. Higher Line Screen may be used depending on graphics.
- Flexo press tolerance for mis-registration is .007".

Colors and Screened Tints

- If a screened value and solid line are the same color, the screen and line elements will be separated on different plates to achieve the best print quality.
- Avoid manufacturing colors from tints of spot colors. If a lighter color ink is required, contact FDC to request color drawdowns for approval.
- Reverse lines and text should knock out of only one color. If knocking out of two or more colors, a holding line will be required to maintain a clean print and avoid registration issues.
- Text should be made from one color, not manufactured from two or more colors to avoid registration issues. The one instance text can be made from two colors is if the color shaping the text overprints a background to make the finished color.
- Screen values and vignettes require a minimum dot of 2%.
- For metallic ink, 100% is recommend for best color effect.

Text

- Minimum typeface for SANS-SERIF text:
  - 3pt positive/overprinting type (4pt for uncoated stock)
  - 4pt **BOLD** reverse/knock-out type (6pt **BOLD** for uncoated stock)
- Minimum typeface for SERIF text:
  - 3pt positive/overprinting type (4pt for uncoated stock)
  - 5pt **BOLD** reverse/knock-out type (7pt **BOLD** for uncoated stock)
- All legal copy must be a minimum of 6 pt.

Minimum Line Weights & Trap

- .003" positive
- .005" positive (uncoated stock)
- .005" reverse
- .007" reverse (uncoated stock)
- .007" traps
- .007" pullbacks
- .014" keylines

FORT DEARBORN COMPANY

Rev 11.2018

Decorative Label Solutions
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Rotary Screen Printing

- Rotary Screen press tolerance for mis-registration is .007".
- Press tolerance for mis-registration between Flexo and Rotary Screen is .010".

Text	Minimum Line Weights & Trap

Text
- Minimums for SANS-SERIF typefaces:
     o 6pt positive/overprinting type (7pt for uncoated stock)
     o 8pt **BOLD** reverse/knock-out type (10 pt **BOLD** for uncoated stock)
- Minimums for SERIF typefaces:
     o 7pt positive/overprinting type (8pt for uncoated stock)
     o 12pt **BOLD** reverse/knock-out type (14pt **BOLD** on uncoated stock)
	Minimum Line Weights & Trap
	- .010" positive
	- .014" positive (uncoated stock)
	- .014" reverse
	- .021" reverse (uncoated)
	- .010" trap to flexo
	- .020" keylines

Rotary Tactile Printing

- Standard deposit for Rotary Tactile is 40-60 micron. Heavier deposit of 100+ micron is available, dependent on graphics.

Text	Minimum Line Weights & Trap

Text
- Minimums for standard deposit Rotary Tactile
     o 8pt positive/overprinting type
     o 9pt reverse/knock-out type
- Minimums for heavier deposit (110+ micron) Rotary Tactile
     o 9pt - 10pt positive/overprinting type
     o 10pt - 11pt reverse/knock-out type
	Minimum Line Weights & Trap
	- .028" positive (standard deposit)
	- .042" positive (heavy deposit)
	- .042" reverse (standard deposit)
	- .056" reverse (heavy deposit)

Emboss / Deboss

- It is not recommended to emboss/deboss film.
- Minimum line weight is .003". Standard relief is .007"
- Minimum type is 8pt.
- Embossed items must have a minimum of .017" between each element.

Hot Stamping / Cold Foil

- Minimums for positive type are 3pt - 5pt, dependent on facestock.
- Minimums for reverse type are 3pt - 6pt, dependent on facestock.
- Minimum line weights are .014" - .021", dependent on facestock.
- Cold Foil is not recommended on uncoated stock.

UPC Barcodes

- Minimum barcode magnification is 80%.
  - o Fort Dearborn Company will not guarantee UPC readability at less than 80%.
- Maximum recommended truncation is .50"
- Bar width reduction is 0
- Quiet Zones
  - o .10" parallel to bars, .02" perpendicular to bars
- Bar codes can be printed in either direction on the web.

General

- Registration symbols (®), trademarks (™), and similar symbols must meet minimum line weights. Fort Dearborn Company will make adjustments to the symbol sizes as needed to ensure they are printed legibly.
- For DIGITAL printing, spot colors are simulated using CMYK or extended gamut to the closest possible match.

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