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| <b>GRIP REQUIRED</b>          | Minimum of 10mm on all four sides of job.<br>This being from the finished size of the artwork to the edge of the sheet.  |
| <b>COVERAGE</b>               | Sheet will be covered in their entirety save for grip and side allowances.   |
| <b>CUTS</b>                   | Where different cuts are present we will run cut-for-cut as delivered to us.   |
| <b>KINDS</b>                  | a) Where different kinds are present in the job, we will run kind-for-kind as delivered to us.<br>b) Please supply all mixed-kind jobs uncollated.   |
| <b>NUMBERED JOBS</b>          | Please advise when booking if jobs are to be embossed after celloglazing.  |
| <b>CURING TIME</b>            | We recommend heavy ink jobs are not embossed or scored within 24 hours of celloglazing.  |
| <b>FOILED JOBS</b>            | For gloss cello we can cello either before or after foiling, however for matt cello we must cello prior to foiling. It is important to let your stamping house know the foiling will be celloglazed; the foil must be compatible with cello.   |
| <b>EMBOSSING</b>              | Please advise when booking in jobs and on orders, if jobs are to be embossed after celloglazing.<br>We recommend heavy ink jobs are not embossed or scored within 24hours of celloglazing.   |
| <b>BOOK COVERS</b>            | Book covers that are 'perfectly' bound require a glue that will not adhere to cello. To compensate, we can single side cello or double side cello and leave a gusset for the binding in the centre of the inside cover.  |
| <b>GLUING</b>                 | a) Standard Cello – gloss or matt, use double tape or hot melt glue.<br>b) Glueable Cello – gloss and matt, is machine glueable.<br>Please specify on your order if this film is required, and please check with your gluing house.<br>c) If a glue flap/s are to be left clear of cello this must be specified on the order. Supply a sample sheet to us as a guide that shows all score and cut lines. Note: We will always run the cello 3mm over the score line into the glue flap. This will ensure cello doesn't peel back when score is folded. |
| <b>COMPATIBILITY</b>          | All celloglazing film used by Rotoflex is of food grade.   |
| <b>DE-DUSTING</b>             | This is not required for our process unless excessive amounts of powder have been used.  |
| <b>COLOUR CHANGE</b>          | Our celloglazing won't yellow over time like UV varnish, or be subject to chemical reactions with inks as in the case of wet laminating. Our film generally will not change the colour of the job. There is however always some slight change in any colour once film is laid over. Gloss film will intensify the colours and matt film will slightly flatten the colours. Test samples can be arranged should they be required for customer approval.   |
| <b>STIPPLE</b>                | Please be aware when celloglazing over a printed stipple the film will magnify the stipple. For example, cello over red stipple brings the red up and intensifies the colour. You can check this effect for yourself by placing sticky tape over print, or we can run a sample.  |
| <b>MARKING OF FILM</b>        | Please be aware that while cello is quite robust it can still be scuffed. All matt cello finishes should be handled carefully as its nature leaves it more prone to scratching, similar to matt board.   |
| <b>QUANTITIES &amp; OVERS</b> | Please list the total number of sheets required to be celloglazed on your orders. We will only run this quantity (e.g. 1000 plus all or 1000 plus 100 overs). All sheets requested on order will be run and charged for. No allowances for overs is made.  |
| <b>PRESSURE SENSITIVE</b>     | Pressure sensitive orders can be celloglazed. Ensure that the job is properly dry before we celloglase.  |
| <b>PAPER STOCKS</b>           | The minimum weight coated stock is preferably 130gsm (e.g. Gross Art). However, uncoated stock can be lighter. Should there be need for lighter stock please contact our staff for further consultation. We do request an extra tolerance for overs be allowed on paper weight jobs.   |

## CELLOGLAZING | VARNISHING | ENCAPSULATION

## PRE-COAT AND ADHESIVE LAMINATING (CELLOGLAZING)

### THE DIFFERENCES:

Both processes use the same surface materials, 12 and 18 micron Bopp film. This is where the similarities start and end. Pre-coat film is the same surface material. Extrusion coated at the mill, with thick (12 to 15 micron) coating of thermally activated adhesive. This is the top of the range method. Adhesive Laminating – The same surface film is roller-coated on the laminating machine with a water-based adhesive. It can only attain a fraction of the coating weight of the premium product. With the glue comes the chemistry and associated problems. The main one being colour change with Fanal pigments in certain links. Usually associated with violets – rhodamine reds and reflex blue, or mixed colours containing a percentage of one of these.

We are not aware of standard process inks ever being effected. With the use of colour-stable inks for special colours this problem should not occur (*Refer to your ink supplier*). On a smooth surface stock the end result makes it difficult to determine the process used. However, as the stock surface becomes more grain, the added coating weight of adhesive on the pre-coat becomes evident.

See the following performance chart.

| CRITERIA                      | STOCK TYPE         | PRE-COAT (PREMIUM)                | ADHESIVE LAMINATION |
|-------------------------------|--------------------|-----------------------------------|---------------------|
| VISUAL FINISH                 | Smooth Stock       | Excellent                         | Excellent           |
|                               | Poor Surface Stock | Good                              | Fair                |
|                               | Rough Stock        | Fair                              | Poor                |
| SURFACE DURABILITY            | Gloss              | Excellent                         | Excellent           |
|                               | Matt               | Fair                              | Marginally better   |
| FILM WEIGHT                   |                    | 24 to 30 micron                   | 15 to 20 micron     |
| COLOUR CHANGE                 |                    | Should not happen                 | Can happen          |
| YELLOWING                     |                    | Should not happen                 | Rarely              |
| STICKING IN EDGES OF STACKS   |                    | No                                | Sometimes           |
| LIFTING ON FOLDS              |                    | Depends on Stock and ink coverage | Same                |
| EMBOSSING                     |                    | Require prior warning             | Same                |
| FOOD GRADE (INDIRECT CONTACT) |                    | Yes                               | Yes                 |