

### PRINTING:

#### Environment

- A room with comfortable temperature and humidity offers the best print performance.
- Allow unpackaged material to acclimatize to the printer room environment.

#### Control Ink Load

- In some cases, excessive ink will expose face film to a higher concentration of solvents. It's best to strike a balance between ink saturation and speed. General guidelines; 720dpi/8pass for high quality and 540dpi/6pass for standard.
- When selecting a media configuration for new material. If a proper ICC Profiles is available for your workflow, use it. If not, then print a small test image using a standard setting and look for neutral grays and bright Coke reds (not tomato) without over inking.
- If graphic has full saturated colors to the edge, consider adding a ¼ inch white boarder.

### POST PRINT:

**Allow for sufficient time for inks to dry and outgassing (Eco-solvent) after printing. If you contour cut the graphics soon after printing, some edge curl is common.**

- For rolls wound onto take-up core (print side out), stand on end allowing material to slightly unwind/loosen so air can circulate near ink.
- For Sheets. Calendered vinyl tends to curl up when sheeted (toward face film). After print is dry to the touch, stack face down on table or rack to complete Ink curling.

### LAMINATING:

**Protecting your graphics will increase lifespan and if done correctly minimize curl.**

- Laminate protects the graphic from fading and scratching. It also makes the sticker thicker and easier to install.
- Correct tension and pressure control is important to avoid air pockets, wrinkles, boat wakes and tunneling. Do not stretch the film when applying laminate.

### CUTTING:

- A sharp blade is essential for success.
- Make sure to leave enough material at the front (leader) and back of graphic outside of the optical registration marks. This provides the pinch rollers with enough space to properly feed and cut.
- Prior to the contour cutting process, all heaters (pre, print and post) on Hybrid devices (printer/cutter) must be turned off and allowed to cool to room temperature. Contour cutting film while heaters are on will result in edge curling of the decal.
- Always make a test cut prior to cutting the graphic to set correct downward force pressure and speed. For each different material, an adjustment will need to be made to achieve a satisfactory cut. A general rule, use the least amount of pressure necessary to cut through the face stock and adhesive. If too much pressure is set the knife could partially score the liner. This could cause issues when the cut graphic is peeled for application.