

# Laser Product Converting and Printing Tips

The following guidelines will help you maximize on press and imaging performance of Fasson laser products.



## CONVERTING

### PRE-PRESS

- Acclimate rolls to press room environment for 48 hours before converting; ideal press room converting conditions are 60 – 80° F and 45 – 55% Relative Humidity.
- Keep unconverted stock wrapped and up off concrete floors to prevent the material from absorbing moisture.
- Practice first-in-first-out inventory control; use of materials at the end user within six months after converting is recommended for optimum performance.

### TOP-COATING (FILM PRODUCTS)

- Non-topcoated film materials require a press applied direct flexographic topcoat for proper ink and toner anchorage. Test for compatibility with the ink manufacturer of solvent or water based formulations.
- Apply topcoat prior to flexo printing; a second pass after flexo printing will ensure toner adhesion.
- Use low-wax or wax-free topcoats. Limit the use of surfactants.
- Keep viscosity at recommended levels and pH within a 4.5 to 5.5 range for good drying characteristics; failure to do so can lead to laser printer feed or contamination issues.

## PRINTING

- Fasson® laser products are printable with water and/or solvent based inks. Coldset and conductive inks should be avoided.
- Avoid flexo-printing areas that will be laser imaged unless compatibility testing with the toner has been completed.
- Avoid flood-coating paper laser products (face and/or liner) as it could result in uncontrollable/ irreversible curl and poor toner anchorage.
- Avoid over-drying the web to dry the ink; excess heat can result in uncontrollable/ irreversible curl.

## LABEL FORMAT

- Run with Grain Direction (machine direction) perpendicular to the Feed Direction of laser printing.
- Maintain a 1/2" non image buffer around the sheets to insure proper barcode and text resolution.
- Perforations should incorporate uncut ties 0.020" thick alternating with 0.375" cuts to avoid processing jams.
- Die-cut and strip at least 1/16" matrix from the leading edge or preferably around the entire sheet to aid consistent feeding, label removal from liner, and to prevent adhesive ooze and dusting during slitting and sheeting.
- For applications where recommended matrix removal is not possible, ensure die cuts do not run off the edge of the sheets to reduce likelihood of adhesive build-up on press and in the laser printer.

## DIE- CUTTING

- Match tooling to the facestock and liner type used; steel-to-steel dies are recommended for optimum performance.
- Maintain clean, sharp knives/blades for cutting and sheeting to avoid dusting and adhesive ooze.
- Foam packed dies can minimize on-press label pre-dispensing.
- Make sure presses are grounded and use static eliminators when possible; this is especially important with film products.

## SHEETING

- Clean, sharp knives are critical to prevent rough edges. Dull knives will cause paper dust and adhesive contamination on press and in the printer.
- Consider grain direction to ensure proper feeding through laser printers (see Label Format section).

## PACKAGING AND HANDLING

- Carefully jog sheets and support stacks with chip board to prevent damaging edges.
- Poly-wrap or bag stacks off-press to protect from moisture and physical damage.
- Place individual packs in corrugated boxes (recommend max 1000 sheets/box) stacking no more than four high to avoid excess pressure/adhesive flow.
- Do not store cartons directly on concrete or in high heat/direct sunlight areas. Avoid stacking skids on boxes.
- Ideal storage conditions for converted materials are 60 – 80° F and 45 – 55% Relative Humidity in protective wrapping.

## LASER PRINTING

- Acclimate material for at least 24 hours at printer's environment prior to processing (ideally at 60 – 80° F; 45 – 55% Relative Humidity).
- Open sheet packs only as needed for job and time allotted; Crack/fan packs prior to feeding.
- Do not allow stacking of more than 200 sheets in output/delivery tray; re-wrap unused sheets with cardboard and store on flat surface in above recommended conditions.
- Keep laser printing equipment well maintained as indicated by the manufacturer (e.g. change cleaning pads, remove used toner, worn belts, rollers, dirt and debris). Use only genuine OEM replacement parts and toner cartridges.
- Every 4000 processed pressure-sensitive sheets, clean all paper paths, feed transport rollers and guide ribs; dust, adhesive, topcoat, and/or toner residue can inhibit proper processing.
- Maintain fuser temperature at the minimum setting that allows proper toner fusion and adhesion; inspect printer thermostat periodically and replace when visibly contaminated.
- Ideal location for laser printer is environment of 70 F (+/-) 10 degrees ambient temperature and 50% Relative Humidity (+/-) 10%; area should be well ventilated.
- Keep printer ventilation openings free of obstacles to prevent excessive heat build up in unit; a 14 inch clear working area around laser printer is recommended.

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