



Requirements for the artworks used for flexographic multicolor printing of sausage casings

1 Acceptable file formats

Adobe Illustrator, any version, all fonts must be in curves

Adobe PDF, any version, all fonts must be in curves

**Raster images must be linked to design and submitted together with the artwork file.*

2 Parameters of raster images used

File formats: TIF, PSD.

Graphic resolution: **300 dpi** (output with lineure of 65 lpi and resolution of 1200 dpi).

Minimum allowable raster percentage: **20%**.

Gradient fills (both vector and raster) must not 'zero out'; the upper limit of the halftone range is **90%**, the lower limit of the halftone range is **20%**.

3 Maximum number of print colors

From **1+0** to **6+6**

**For the 6+6 printing, the face and reverse colors of the casing must be the same.*

4 Geometric dimensions of artworks

Image length: **400 mm** and **500 mm**.

Maximum image width for sausage casings shall be:

- **6 mm** less than the flat width of sausage casings with a caliber of up to 55;
- **10 mm** less than the flat width of sausage casings with a caliber of 56-90;
- **20 mm** less than the flat width of sausage casings with a caliber of more than 90.

5 Process break*

It is advisable to include a process break between the print elements, while keeping the process break length to the minimum.

Length of a straight process break: not less than **2 mm**.

Length of a shaped process break: not less than **3 mm**.

No process break is needed for frankfurter/wiener casings (where engraved plates are used).

**A process break is a transverse band on the image, which appears because of the need to fasten the end parts of the printing plate on the printing cylinder. This problem is encountered only when using the traditional photopolymer printing plates. When CYLINDRICAL PLATES (engraved) are used, there are no transverse bands across the image.*

6 Requirements for white-colored elements

High-quality printing of sausage casings with large solid or fine elements (thin lines, knockouts, raster, etc.) in white color requires that such elements be assigned to two different printing plates.

7 Requirements for artwork elements

Minimum width of a separate line or dot printed in a single color:

- **0.3 mm** (positive print);
- **2 mm** (negative print).

Minimum width of a separate line or dot printed in two or more colors:

- **1.5 mm** (positive print);
- **3 mm** (negative print).

Minimum line width or dot size for knockout printing in white color must be not less than **2 mm**.

Minimum size of a 'positive' font printed in a single color: **6 pt**;

Minimum size of a 'negative' font printed in a single color: **12 pt**;

**Texts in fonts less than 12 pt can be printed in a single channel only, while texts in fonts more than 13 pt can be printed in two or more channels. It is advisable to avoid fonts with very thin elements (serifs, bridges, etc.).*

**These requirements refer only to the elements that must be reproduced by printing without distortions or defects (the semantically charged elements).*

The artwork design must take into account the vertical misregister from **0.5 mm to **0.7 mm** for each color.*

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