



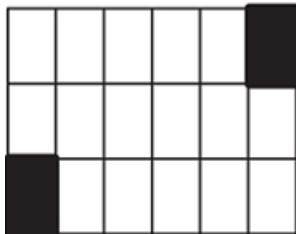
Z Fold Card Requirements

Following extensive research in conjunction with some customers and several leading adhesive suppliers, we have put together some recommendations we feel may improve the quality of glued Z Fold Card products.

To ensure adhesion of the covers to the folded insert text we use a hot melt adhesive process and therefore it is vital that the glued areas are left blank and free of ink. These areas should also be preferably free of any kind of sealant or coatings.

Due to the nature of the hot melt process, hot melt dots will feel slightly raised through the glue panels of the leaflets.

We recommend covers and text are Litho printed, hot melt dots can react with digitally printed materials potentially causing visible ghosting on outer covers and printed areas to stick together.



IF THERE IS PRINT IN THESE AREAS THEN THE COVERS WILL NOT ADHERE SUFFICIENTLY TO THE TEXT INSERT.

INITIAL RUNNING COPIES MAY APPEAR TO ADHERE SUCCESSFULLY BUT ADHESIVE PERFORMANCE MAY DETERIORATE OVER A SHORT PERIOD.

We recommend an uncoated stock as this tends to adhere to the covers better than some gloss or silk materials. There is also the benefit of the reduced risk of cracking on the folds.

Our recommendations for weight of text insert materials are dependent on the number of folds but it is usually between 60gsm to 90gsm on uncoated and offset materials and between 80gsm to 115gsm on silk & coated materials.

Cover stocks need to be on a minimum of 300gsm to 400gsm uncoated or silk.

Covers can be supplied to us either matt or gloss laminated or UV varnished on the **OUTSIDE ONLY** but please be aware that some laminations may mark during the binding process.

If you would like a border around the cover and text panels then the border must be no wider than 10mm – 15mm from the edge of the cover.

Digital substrates are liable to react with adhesive and may affect adhesion.

Disclaimer

By issuing a Purchase Order to Clinical Print Finishers UK Ltd you are accepting the above requirements in addition to our general terms and conditions of trading.

It is likely that failure to follow our recommendations may result in the product adhesion or quality being affected.

Clinical Print Finishers UK Ltd cannot be held responsible for any future quality issues if these recommendations are not followed.