



# TechLines

## Quick Reference Card

This easy-to-use compendium of specifications, taken from our **TechLines** sheets, is intended to help you prepare your electronic files for efficient production. You are encouraged to review the complete **TechLines** series and share these materials with your designer or other source involved in the creation of your printed materials. Check out our complete Technical Library at [www.riponprinters.com](http://www.riponprinters.com).

### BLEED ALLOWANCES

1/8" required for top & bottom

1/4" *strongly* preferred at face, 1/8" minimum

For saddle stitch pieces that combine heatset and coldset signatures, a 1/4" face bleed is a must.

Saddle stitch covers for books of 48 or more pages should have 1/4" minimum face bleeds.

Corner marks and exterior register marks should be no closer than 1/8" to final trim on materials for perfect bind products, 1/4" for saddle stitch products.

### DRILL & PERFORATION ALLOWANCES

5-hole, 1/2" drill – 1" preferred, 7/8" minimum

3-hole, 1/4" or 5/16" drill – 3/4" preferred, 5/8" minimum

Distance from any perforation to spine fold – 3/8" preferred, 1/4" minimum

# SHEET PRESS REQUIREMENTS

## COATED STOCKS

**Line screens:** 175 preferred; up to 200 available for halftones, duotones, 4/color separations; 133 recommended for tint screens improves the reproduction of solid color type or art in a same-color screen

**Dot gain:** 15%

**Under Color Removal (UCR):** 300% total ink limit, 94% black limit

## COATED STOCKS TO BE UV COATED

**Line screens, Dot gain:** as above

**Under Color Removal (UCR):** 280% total ink limit to ensure UV adhesion, 94% black limit

## UNCOATED STOCKS

**Line screens:** 133 for halftones, duotones, 4/color separations; 120 recommended for tint screens improves the reproduction of solid color type or art in a same-color screen

**Dot gain:** 20%

**Under Color Removal (UCR):** 270% total ink limit, 94% black limit

## FOR ALL STOCKS...

**INK SEQUENCE: C-M-Y-K**

**HALFTONE ENDPOINTS:**

3% highlight dot

94% shadow dot

# HEATSET WEB REQUIREMENTS

## #1 & #2 COATED

**Line screen:** 175      **Dot gain:** 19% at the 50% dot  
**Under Color Removal (UCR):** 340% total ink limit,  
94% black limit

## #3 COATED

**Line screen:** 150      **Dot gain:** 19% at the 50% dot  
**Under Color Removal (UCR):** 310% total ink limit,  
94% black limit

## #4 & #5 COATED GROUNDWOOD

**Line screen:** 150      **Dot gain:** 19% at the 50% dot  
**Under Color Removal (UCR):** 300% total ink limit,  
94% black limit

## SUPER CALENDERED

**Line screen:** 133      **Dot gain:** 22% at the 50% dot  
**Under Color Removal (UCR):** 270% total ink limit,  
90% black limit

## OFFSET STOCKS

**Line screen:** 133      **Dot gain:** 30% at the 50% dot  
**Under Color Removal (UCR):** 260% total ink limit,  
90% black limit

## FOR ALL STOCKS...

**INK SEQUENCE: K-C-M-Y**

**HALFTONE ENDPOINTS:**

3% highlight dot

93% shadow dot

# COLDSET WEB REQUIREMENTS

## OFFSET STOCKS

**Line screen:** 133

**Dot gain:** 30% at the 50% dot

**Under Color Removal (UCR):** 260% total ink limit,  
90% black limit

## GROUNDWOOD STOCKS

**Line screen:** 120

**Dot gain:** 30% at the 50% dot

**Under Color Removal (UCR):** 245% total ink limit,  
90% black limit

## NEWSPRINT & DIRECTORY STOCKS

**Line screen:** 100

**Dot gain:** 30% at the 50% dot

**Under Color Removal (UCR):** 235% total ink limit,  
90% black limit

## FOR ALL STOCKS...

**INK SEQUENCE: K-C-M-Y**

**HALFTONE ENDPOINTS:**

3% highlight dot

92% shadow dot for black in halftones & duotones

85% shadow dot for Pantone colors in halftones & duotones

## MARGIN ALLOWANCES

From **all** live matter to final trims, **including copy in bleed tabs** – 1/4" preferred, 3/16" minimum

For saddle stitched products requiring multiple sections; single web press sections of 12, 20, 28, 36, 40 or 44 pages – 1/2" preferred, 3/8" minimum

## RESOLUTION FOR HALFTONE SCANS

Scanning resolution is determined by the line screen as noted inside for each press and available stocks.

For an output line screen less than 150 lines per inch (lpi), we recommend a minimum "quality factor" of 2. For example: for projects printing on uncoated papers where the film will be output at 120 lines per inch (lpi), set the scanning resolution to at least 240 dots per inch (dpi) - **the lpi times 2.**

A quality factor of 1.5 can be used for 150 lpi or greater since these screen frequencies can resolve finer details.

## CREATING SUCCESSFUL PDFs FOR PRINT PRODUCTION

Individual titles available on our web site, [www.riponprinters.com](http://www.riponprinters.com), are based on the following native software programs:

Acrobat Distiller 7	InDesign CS3
Acrobat Distiller 8	InDesign CS4
Acrobat Distiller 9	InDesign CS5
PageMaker 6.5	QuarkXPress 6.x
PageMaker 7	QuarkXPress 7.x
CorelDRAW	QuarkXPress 8.x
	QuarkXPress 9.x

## ELECTRONIC PREPRESS SOFTWARE WE SUPPORT

### MACINTOSH

Adobe Illustrator CS3, CS4, **CS5**

Adobe InDesign CS3, CS4, **CS5**

Adobe Photoshop CS3, CS4, **CS5**

QuarkXPress 6.x, 7.x, 8.x, **9.x**

### WINDOWS XP PROFESSIONAL & WINDOWS 7

Adobe Illustrator CS3, CS4, **CS5**

Adobe InDesign CS3, CS4, **CS5**

Adobe Photoshop CS3, CS4, **CS5**

QuarkXPress 6.x, 7.x, 8.x, **9.x**

*Please note that we have older software versions [ie. QuarkXPress 5.x, InDesign 2.x]. If you have questions about older versions, please contact your customer service representative or customer education.*

*If a program you use is not listed above, please call before submitting your job.*



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