

Stora Enso Fors Boards

Printing recommendations, sheetfed offset

The conditions below have been tested for a number of years when printing our board on a Heidelberg SM 74.

Printing pressure (Back cylinder pressure)	≤260 GSM = 0,20 mm	
	>260 GSM = 0,25 mm	
Particle size of spraying powder	≤ 300 GSM = 30 µm	
	>300 GSM an even larger size can be used	
Dampening water	pH	5,2 – 5,5
	Degree of hardness	8 – 12 dH
	IPA (alcohol) conc	Approx 7 - 8%
	Temperature	10 – 11 °C
	Conductivity	Should be constant over time

	Top side	Reverse side
Screen rulings	150 - 175 lpi	133 lpi
Printing densities	K = 1,90	K = 1,40
	C = 1,50	C = 1,20
	M = 1,50	M = 1,25
	Y = 1,40	Y = 1,10