



July 2023

From Rives Tradition to Rives Shetland, the range offers 5 finishes, felt-marked textures with geometric and fabric-inspired patterns

Printing Guidelines

Design and pre-press

A screen of 133-150 lpi should be used. Finer screens up to a maximum of 200 lpi can give good results with careful ink density control. For dark 4 colour images with high ink density, under colour removal may be required depending on the visuals. Aim for the total ink film weight of 260%.

Offset litho printing

For optimum results on textured product increase the blanket pressure or use a softer blanket to achieve consistent ink lay down.

Printing inks

Conventional positive drying inks should be used with or without infra-red drying assistance. Oxidizing inks or UV inks may also be used. Avoid using overnight / stay fresh / duct stable inks. Allow sufficient drying time. Use laser stable inks for subsequent laser printing. Consult your ink supplier about specific projects to ensure ink suitability.

Paper handling

To avoid marking and set-off when printing multiple colours, 35µ anti set-off spray for boards and 20µ for paper weights are recommended. Turn off the delivery stack jogger and restrict the delivery pile when printing boards. Always protect paper from environmental humidity and temperature changes by using stack cover or stretch wrap.

Varnishing

To achieve a gloss varnish, it is essential to pre-seal the surface. Silk screen matt UV varnish should be used first, followed by subsequent applications of gloss UV varnish to achieve the desired effect. Ensure suitable inks are used prior to varnishing and that the inks are completely dry before varnish application. Not recommended for paper weight.

Blind Embossing

All finishes can be blind embossed. For subsequent laser printing, we recommend a shallow emboss to allow good feeding and to avoid damaging the emboss.

Die Stamping

Rives papers can be die stamped with superior result on smooth papers with very detailed imagery. Use water based inks for subsequent use with laser printers.

Hot Foil Stamping

All finishes in the range can be foil stamped. Foil printer can recommend the best foil for the image and paper choice. It may be necessary to remove the paper texture from the foiled area to improve image clarity.



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Printing Guidelines

Film Laminating

Rives papers can be film laminated. Silvering may be evident depending on the print image. To reduce silvering increase laminating pressure and if possible apply excess adhesive if using wet glue lamination. The film will bridge the texture of Rive Design

Sealer and coatings

Sealers and press coatings can be used to help reduce marking for further operations. Ensure the inks are suitable and best result are achieved when the inks are dry before sealing.

Thermography

UV thermography systems can be used for letterheads ensuring compatibility with office printers.

Die and laser cutting

Rives papers and boards can be die cut. While laser cutting is easy some scorching will be apparent around the cut area. Laser cut papers are more prone to miss-feeds and jams within office printing technologies.

Folding and creasing

To guarantee good folding results, prior creasing is recommended. Creases should be made parallel to the grain of the board. For best results, a creasing rule and matrix system should be used

Binding and adhesives

Standard adhesives and binding techniques can be used.

Blind Embossing

Compatibility to office printers should be tested. Low weight papers often give acceptable results for text and simple graphic applications.

Digital technologies

Rives range is certified for HP Indigo and Dry Toner.



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| Property & Unit | Standard | | | | | | |
|---|----------------|------|------|------|------|------|------|
| GSM | UNI EN ISO 536 | 100 | 120 | 170 | 250 | 320 | 400 |
| Thickness (µm) | UNI EN ISO 534 | 145 | 172 | 245 | 355 | 445 | 550 |
| Bulk (cm ³ /g) | UNI EN ISO 534 | 1.45 | 1.43 | 1.44 | 1.42 | 1.39 | 1.38 |
| Whiteness CIE (%) | ISO 11475 | 130 | 130 | 130 | 130 | 130 | 130 |
| Opacity (%) | UNI ISO 2471 | 88 | 89 | - | - | - | - |
| Cobb 60 sec felt side (g/m ²) | UNI EN ISO 535 | 35 | | | | | |
| Cobb 60 sec wire side (g/m ²) | UNI EN ISO 535 | 35 | | | | | |
| Bending resistance MD (mN) | ISO 2493-1 | N/A | N/A | 50 | 155 | 280 | 580 |
| Bending resistance CD (mN) | ISO 2493-1 | | | 25 | 70 | 110 | 270 |
| Absolute Humidity UA (%) | | 6.8 | 6.8 | 6.5 | 6.5 | 6.5 | 6.5 |

These values are to be considered only as indications and are subject to change according to trade tolerances in the quality specification. Issue date: March 2023



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| Property & Unit | Standard | | | |
|---|----------------|------|------|------|
| GSM | UNI EN ISO 536 | 120 | 250 | 350 |
| Thickness (µm) | UNI EN ISO 534 | 171 | 357 | 512 |
| Bulk (cm ³ /g) | UNI EN ISO 534 | 1.43 | 1.43 | 1.46 |
| Whiteness CIE (%) | ISO 11475 | 130 | 130 | 130 |
| Opacity (%) | UNI ISO 2471 | 89 | - | - |
| Cobb 60 sec felt side (g/m ²) | UNI EN ISO 535 | | 35 | |
| Cobb 60 sec wire side (g/m ²) | UNI EN ISO 535 | | 35 | |
| Absolute Humidity UA (%) | | | 6.5 | |

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| Property & Unit | Standard | | | | |
|---|----------------|------|------|------|------|
| GSM | UNI EN ISO 536 | 120 | 170 | 250 | 350 |
| Thickness (µm) | UNI EN ISO 534 | 180 | 245 | 355 | 495 |
| Bulk (cm ³ /g) | UNI EN ISO 534 | 1.50 | 1.44 | 1.42 | 1.41 |
| Whiteness CIE (%) | ISO 11475 | 130 | 130 | 130 | 130 |
| Opacity (%) | UNI ISO 2471 | 89 | - | - | - |
| Cobb 60 sec felt side (g/m ²) | UNI EN ISO 535 | 35 | | | |
| Cobb 60 sec wire side (g/m ²) | UNI EN ISO 535 | 35 | | | |
| Absolute Humidity UA (%) | | 6.5 | 6.5 | 6.5 | 6.5 |

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| Property & Unit | Standard | | | | |
|---|----------------|------|------|------|------|
| GSM | UNI EN ISO 536 | 90 | 120 | 220 | 320 |
| Thickness (µm) | UNI EN ISO 534 | 120 | 160 | 304 | 440 |
| Bulk (cm ³ /g) | UNI EN ISO 534 | 1.33 | 1.33 | 1.38 | 1.38 |
| Whiteness CIE (%) | ISO 11475 | 130 | 130 | 130 | 130 |
| Opacity (%) | UNI ISO 2471 | 87 | 89 | - | - |
| Cobb 60 sec felt side (g/m ²) | UNI EN ISO 535 | 35 | | | |
| Cobb 60 sec wire side (g/m ²) | UNI EN ISO 535 | 35 | | | |
| Absolute Humidity UA (%) | | 6.5 | 6.5 | - | - |

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| Property & Unit | Standard | | | | |
|---|----------------|------|------|------|------|
| GSM | UNI EN ISO 536 | 120 | 170 | 250 | 350 |
| Thickness (µm) | UNI EN ISO 534 | 138 | 187 | 275 | 390 |
| Bulk (cm ³ /g) | UNI EN ISO 534 | 1.15 | 1.10 | 1.10 | 1.11 |
| Whiteness CIE (%) | ISO 11475 | 130 | 130 | 130 | 130 |
| Opacity (%) | UNI ISO 2471 | N/A | N/A | N/A | N/A |
| Cobb 60 sec felt side (g/m ²) | UNI EN ISO 535 | N/A | | | |
| Cobb 60 sec wire side (g/m ²) | UNI EN ISO 535 | N/A | | | |
| Bending resistace MD (mN) | ISO 2493-1 | N/A | N/A | N/A | N/A |
| Bending resistace CD (mN) | ISO 2493-1 | N/A | N/A | N/A | N/A |
| Absolute Humidity UA (%) | | N/A | N/A | N/A | N/A |

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| Property & Unit | Standard | | | |
|-----------------------------------|-----------|------|------|------|
| GSM | ISO 536 | 140 | 270 | 350 |
| Thickness (µm) | ISO 534 | 180 | 368 | 475 |
| Whiteness CIE (%) | ISO 11475 | 144 | 144 | 1144 |
| L&W Stiffness (15°/ 50mm) MD (mN) | ISO 2493 | 180 | 140 | 290 |
| L&W Stiffness (15°/ 50mm) CD (mN) | ISO 2493 | 90 | 70 | 145 |
| Bulk (cm3 /g) | ISO 534 | 1.29 | 1.36 | 1.36 |
| Absolute Humidity (%) | ISO 287 | 6 | 6 | 6 |

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| Property & Unit | Standard | | | |
|-----------------------------------|-----------|------|------|------|
| GSM | ISO 536 | 140 | 270 | 350 |
| Thickness (µm) | ISO 534 | 180 | 368 | 475 |
| Whiteness CIE (%) | ISO 11475 | 84 | 84 | 84 |
| L&W Stiffness (15°/ 50mm) MD (mN) | ISO 2493 | 180 | 140 | 290 |
| L&W Stiffness (15°/ 50mm) CD (mN) | ISO 2493 | 90 | 70 | 145 |
| Bulk (cm3 /g) | ISO 534 | 1.29 | 1.36 | 1.36 |
| Absolute Humidity (%) | ISO 287 | 6 | 6 | 6 |

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| Property & Unit | Standard | | | |
|-----------------------------------|-----------|------|------|------|
| GSM | ISO 536 | 140 | 270 | 350 |
| Thickness (µm) | ISO 534 | 190 | 370 | 475 |
| Whiteness CIE (%) | ISO 11475 | 144 | 144 | 144 |
| L&W Stiffness (15°/ 50mm) MD (mN) | ISO 2493 | 200 | 150 | 300 |
| L&W Stiffness (15°/ 50mm) CD (mN) | ISO 2493 | 100 | 75 | 150 |
| Bulk (cm3 /g) | ISO 534 | 1.36 | 1.37 | 1.36 |
| Absolute Humidity (%) | ISO 287 | 6 | 6 | 6 |

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| Property & Unit | Standard | | | |
|-----------------------------------|-----------|------|------|------|
| GSM | ISO 536 | 140 | 270 | 350 |
| Thickness (µm) | ISO 534 | 190 | 370 | 475 |
| Whiteness CIE (%) | ISO 11475 | 84 | 84 | 84 |
| L&W Stiffness (15°/ 50mm) MD (mN) | ISO 2493 | 200 | 150 | 300 |
| L&W Stiffness (15°/ 50mm) CD (mN) | ISO 2493 | 100 | 75 | 150 |
| Bulk (cm3 /g) | ISO 534 | 1.36 | 1.37 | 1.36 |
| Absolute Humidity (%) | ISO 287 | 6 | 6 | 6 |

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