



December 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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### 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 Digital is certified for HP Indigo and Dry Toner.



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Dry Toner ®

Certified for  
HP Indigo \*

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 (cm3 /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/m2)	UNI EN ISO 535			35			-
Cobb 60 sec wire side (g/m2)	UNI EN ISO 535			35			-
Bending resistance MD (mN)	ISO 2493-1	-	-	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	-

\* To know more about the HP Indigo certified items, please refer to Rives Digital data sheet

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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Dry Toner ®

Certified for  
HP Indigo \*

Property & Unit	Standard			
GSM	UNI EN ISO 536	120	250	350
Thickness (µm)	UNI EN ISO 534	171	357	512
Bulk (cm <sup>3</sup> /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 <sup>2</sup> )	UNI EN ISO 535		35	
Cobb 60 sec wire side (g/m <sup>2</sup> )	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 <sup>3</sup> /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 <sup>2</sup> )	UNI EN ISO 535			35	
Cobb 60 sec wire side (g/m <sup>2</sup> )	UNI EN ISO 535			35	
Absolute Humidity UA (%)				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 <sup>3</sup> /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 <sup>2</sup> )	UNI EN ISO 535	35			
Cobb 60 sec wire side (g/m <sup>2</sup> )	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 <sup>3</sup> /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	89	-	-	-
Bending resistance MD (mN)	ISO 2493-1	-	30	75	150
Bending resistance CD (mN)	ISO 2493-1	-	10	25	55

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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 (cm <sup>3</sup> /g)	ISO 534	1.36	1.37	1.36
Absolute Humidity (%)	ISO 287	6	6	6

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