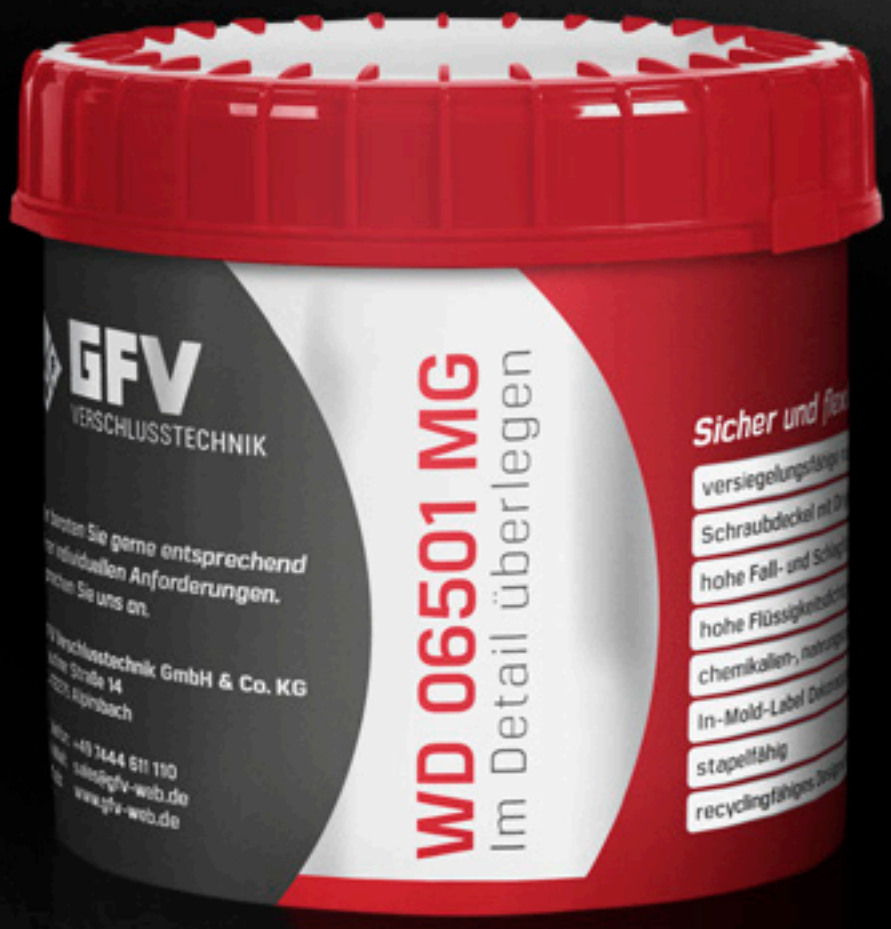
Graphic directives for

In-Mould-Label (IML)

Version: Februar 2019



GFV
VERSCHLUSSTECHNIK

1. The In-Mould label decoration process

The In-Muold label (IML) is a printed foil to decorate our packages. The IML is put in an injection mould in the course of our production processes and made indissolubly linked to our products via injection moulding. The integration of the decoration process in the injection moulding allows making high qualitative and high hygienic products. The colour and the visual appearance of the foil print are nearly unlimited. Thanks to the choice of appropriate foils, additives, colours and varnish, it is possible to create barrier, fragrance, haptics or peel eects.

2. Design making

We assume that the clients send us a ready, digital version of the graphic designs that we can then convert into an IML print data together with our external IML partners. If you need help to create your graphic design, we would be happy to propose you this service. When creating the graphic design, please mind the following points:

2.1. Rectangular IML drawing

In order to be able to apply your graphics data to the packaging of your choice, your data must be adapted to the respective can jacket processing. For this purpose, the appropriate IML rectangle drawing is available for each box via our sale or in the service center on our homepage. On our (rectangle) drawings, the IML outline and its location on our products are represented by a red line. The IML dimensions are also given numerically. All drawings are made on a scale of 1: 1 so that they can be used directly as a layout template.

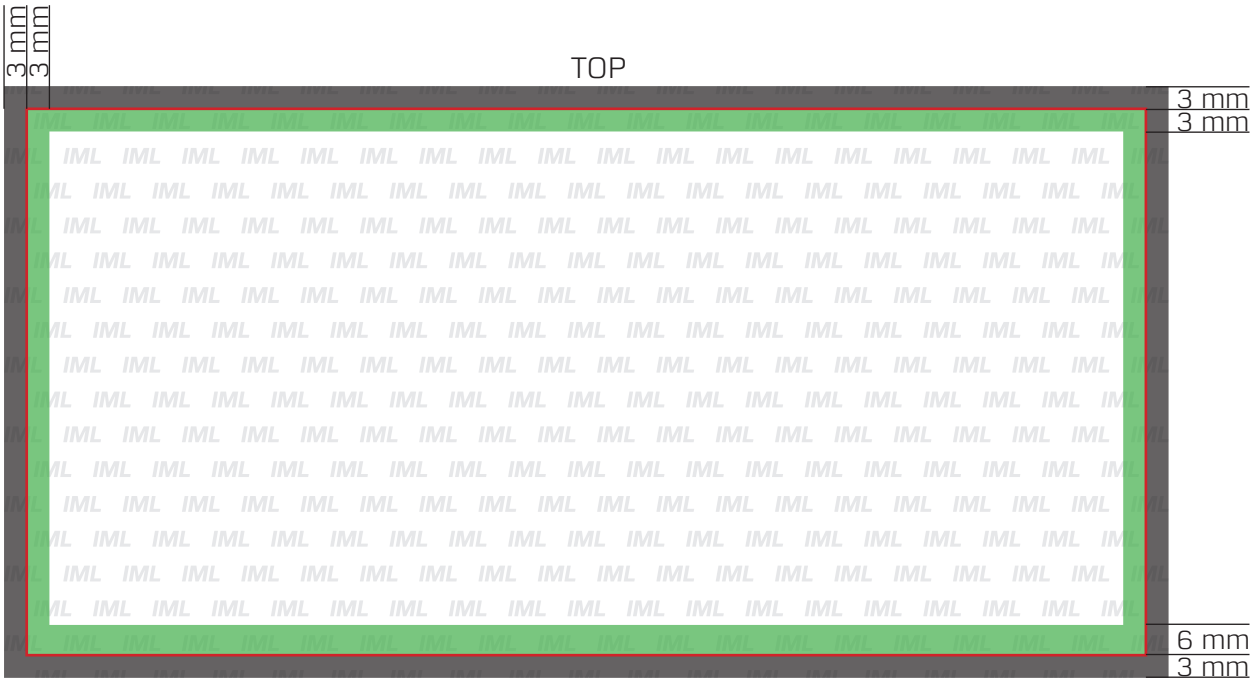
2.2. Trim

Because of tolerances in the graphic processing as well as in the printing and stamping, it is necessary that every side of your image material has a trim bigger than the IML outlines shown on our (rectangular) drawing. This trim must be

- for the IML rectangular drawing 3.0 mm

2.3. Text-free zone

Because of printing and stamping tolerances, a text-free zone of at least 3 mm from the IML outlines must be observed on every side. At the lower edge 6 mm are to be kept.



IML rectangular drawing with IML outlines (red line), text-free zone (green zone) and trim (grey zone)

2.4. Text size and line thickness

For a perfect legibility at the point of sale, we recommend you to observe the following minimal text size and line thickness:

type positive 6 pt	line positive 0,15mm	one-coloured
type negative 7 pt	line negative 0,20mm	
type positive 7 pt	line positive 0,20m m	multi-coloured
type negative 7 pt	line negative 0,20mm	

2.5. Images

The minimal eective resolution of images on IMLs must be of 300 ppi. All images must be delivered in the CMYK format. For logos, the minimal eective resolution must be of 2400 ppi.

Negative example:

Actual resolution: 300 ppi
Enlargement factor: 417%
Eective resolution: 72 ppi (< 300 ppi)

Original size

Image after enlargement

2.6. Colours

Please consider by the colour choice of your graphic design that our IML printing partner is not able to print more than 8 colours at a time so far. For transparent IML foils, it also includes UV white (normally, the IML foils are white). The maximal colour coverage should not exceed 270%.

2.7. Bar codes and Data Matrix codes

Furthermore, the bar codes should observe a reduction or zoom factor between 80% and 200% as well as a line thickness reduction of 0.051 mm.

2.8. Oset at the IML confluence

Because of the nature of the injection process, there may be an oset at the IML confluence. Oset sensible graphic designs (like horizontal line courses) should therefore be avoided in the zone of confluence.

3. Data transmission

Ideally you should transmit your data as an open PDF document with outline fonts. If the fonts in your files are not outline fonts but are editable, we ask you in any case to send us the fonts you used. You can easily send your digital data to us via e-mail or, from a data size of 10 MB, ideally via our FTP server. For a transmission via FTP server, please contact our sales department.

4. IML validation

There are dierent possibilities to validate the IML. The most common way is with a digital proof we send to you by e-mail. On request, we can also make a press proof and send it to you by post. Please note that neither the digital proof nor the press proof is binding with regard to the colours. The main reason for it is that the later colour appearance is influenced by interactions between the IML and the packaging that cannot be simulated. Independently from the validation process, possible necessary corrections must be exactly described and marked. We then include them in your print image before we begin a new validation process.