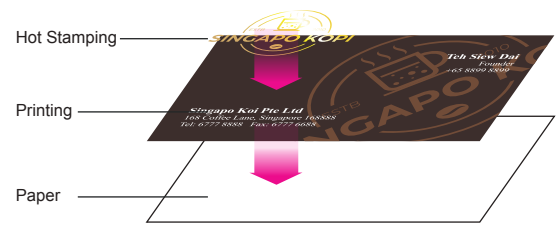## IMPORTANT

1) Area/Image to be hot stamped must be within the Safe Zone.
   (only within L shape safe zone *please refer page 8)

2) Hot stamping artwork (image) can be bleed out *(only within L shape safe zone *please refer Page 8)*, but stamping for important text MUST within Safe Zone.

3) Font size 7.0 pt.
   Note: When using minimum pts, do not bold font as they will appear coarse and over bleed. For Reverse Effect where hot stamped area excludes font, avoid using Serif fonts.
   Use bold San Serif font (minimum 10 pt with Line Thickness: 1 pt).
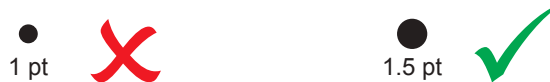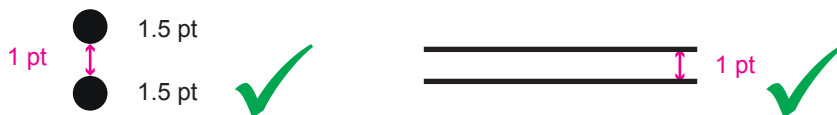   Line thickness 0.5 pt.

   | 0.25 pt ✗ | 0.5 pt ✓ |

   Dot thickness 1.5pts.

   1 pt ✗   1.5 pt ✓

   Gap between Normal hot-stamping for Line and Dot cannot less than 1.0 pt.

   1 pt — 1.5 pt / 1.5 pt ✓   1 pt ✓

Actual print

Gold Hot Stamping

4) Fill area/image to be hot stamped with either,

Pantone 871C (Gold)   **Pantone 877C (Silver)**   **Pantone 185C (Red)**

Pantone 355C (Green)   **Pantone 072C (Blue)**   **Pantone Black C (Black)**

5) Image to be hot stamped must be in Vector format, solid colour and without any tint or gradient fill.

   ✗   ✓

6) Ensure registration of image to be hot stamped is accurately aligned.
   Refer Page 9 - Possible Registration Problems

7) Hot stamping and creasing / folding must have distance 3mm to avoid crack issue
   *Must to **TAKE NOTED** and take your own risk if still want proceed this issue

Full Colour Printing

IMPORTANT

You will have to prepare 3 PDF files + 1 PDF file for Reverse Side (If applicable):
Page 1: 1 file for the full artwork,
Page 2: 1 file for the artwork without the image to be hot stamped and,
Page 3: 1 file for the image to be hot stamped.

Page 1
Full artwork inclusive of image & text to be hot stamped

You MUST fill the area to be hot stamped in maximum 2 colours:

Pantone 871C (Gold)
Pantone 877C (Silver)
Pantone 185C (Red)
Pantone 355C (Green)
Pantone 072C (Blue)
Pantone Black C (Black)

Page 2
Artwork without image to be hot stamped

Exclude the area/image to be hot-stamped.

Page 3
Artwork of Image to be hot stamped

Ensure image is positioned accurately (as per File 1) to avoid misregistration.

Pantone 871C (Gold)
Pantone 877C (Silver)
Pantone 185C (Red)
Pantone 355C (Green)
Pantone 072C (Blue)
Pantone Black C (Black)
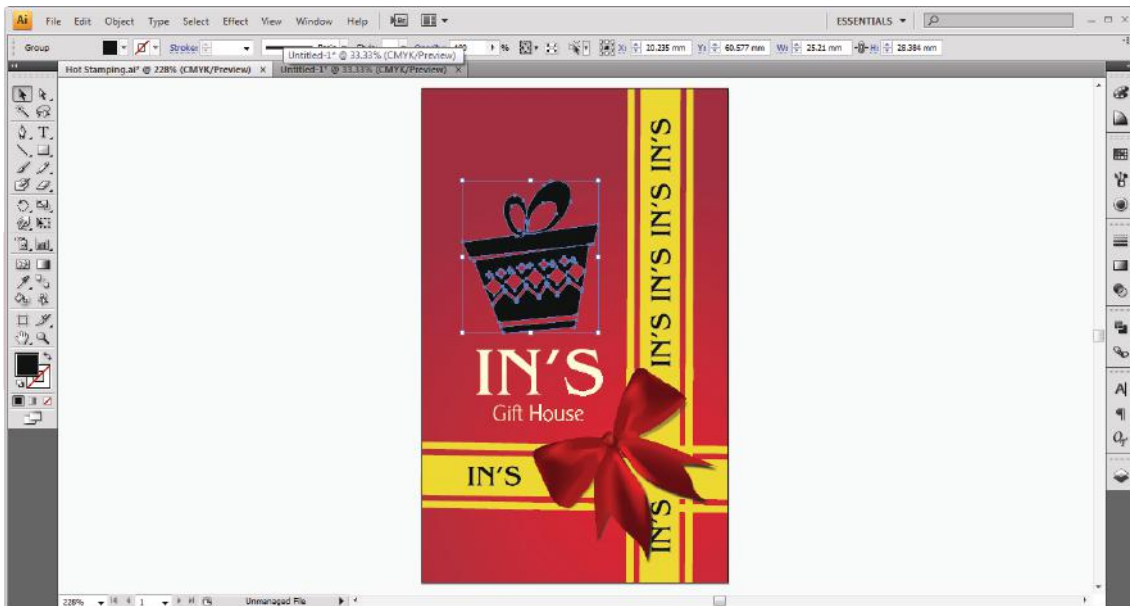
Zip all PDF files together

or

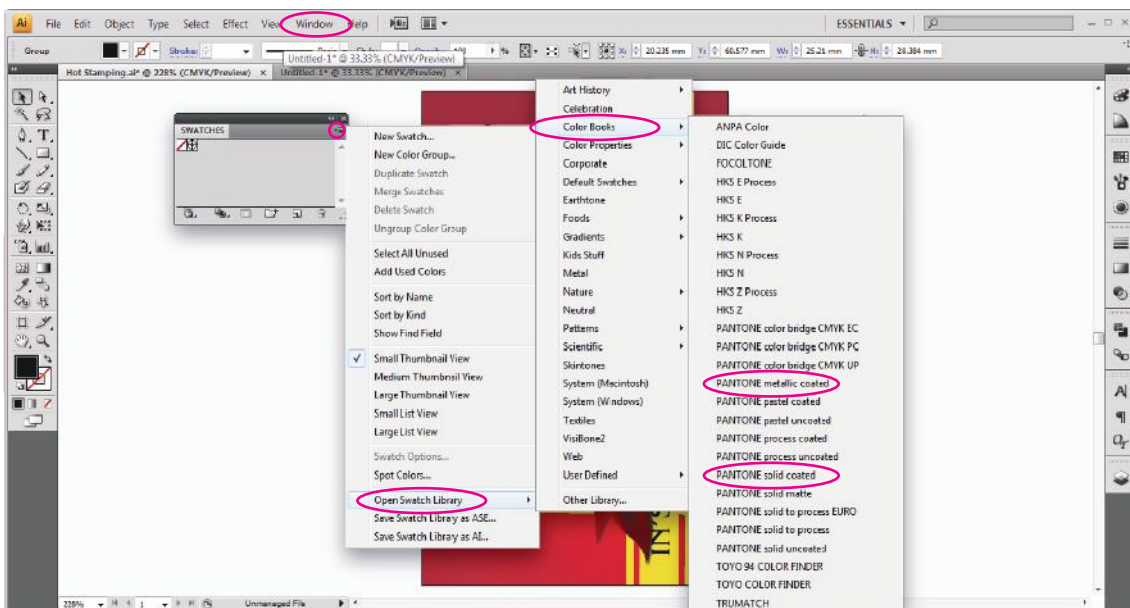Combine and save into 1 PDF file (4 pages)

Double check preparation then upload file online (Front)

Preparing Hot Stamping format in Ai **Adobe Illustrator**

**1** Select your hot stamping part. Make sure hot stamping part not in JPEG.

2 Select **"Window"** > **"Swatch Libraries"** > **"Color Books"**
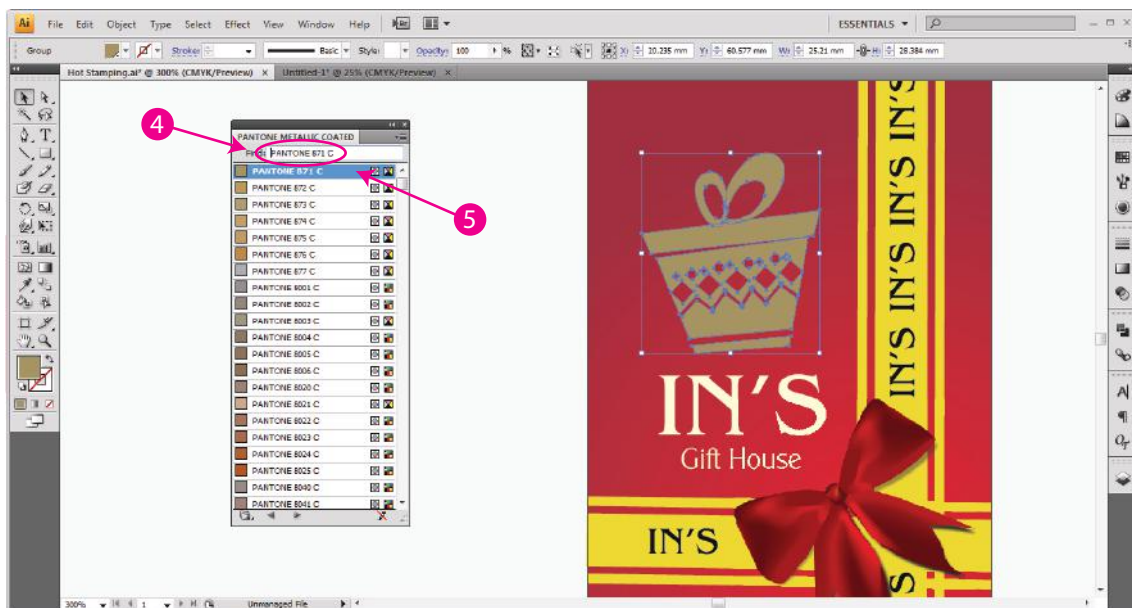
May select the color code follow category show below:

Category	Code	
PANTONE Metalic coated	Pantone 871C (Gold)	Pantone 877C (Silver)
PANTONE Solid coated	Pantone 185C (Red)	Pantone 355C (Green)
	Pantone 072C (Blue)	Pantone Black C (Black)

*Make sure fill in color code follow your order colour

Preparing Hot Stamping format in Ai **Adobe Illustrator**
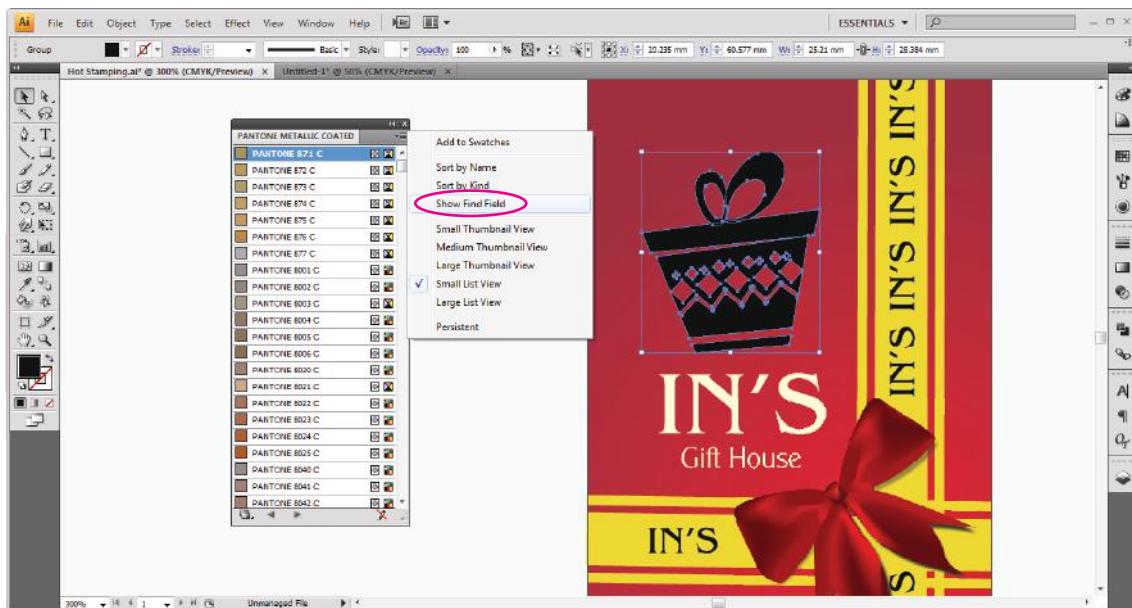
3 Select "Show Find Field"

4 Enter your hot stamping code.

5 Select the highlighted code.

2b printing
SOLUTIONS

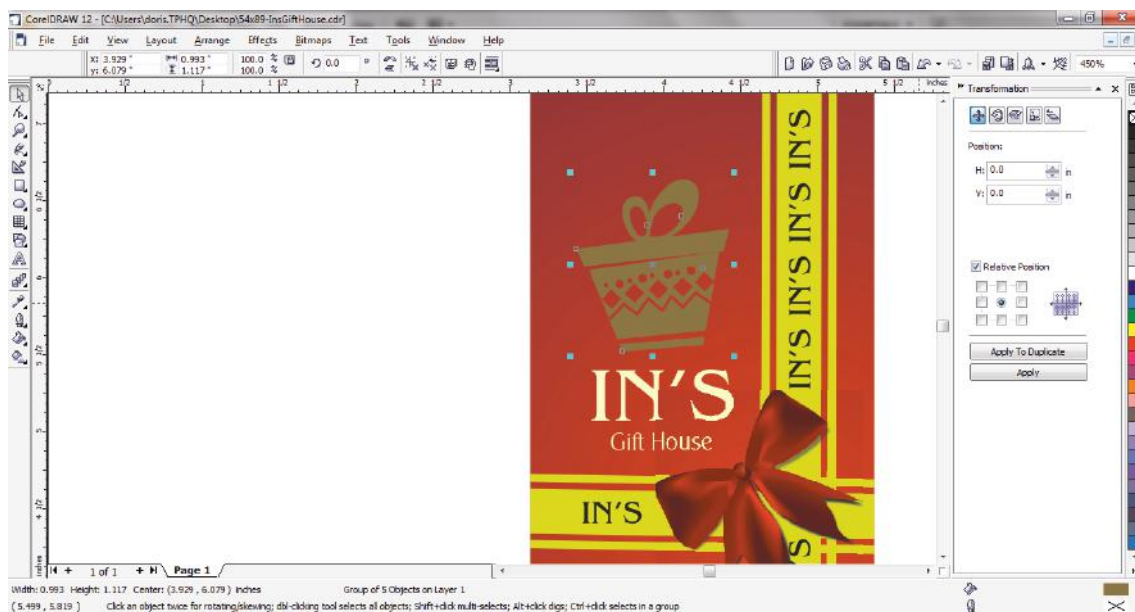**Preparing Hot Stamping format in** **Corel Draw**
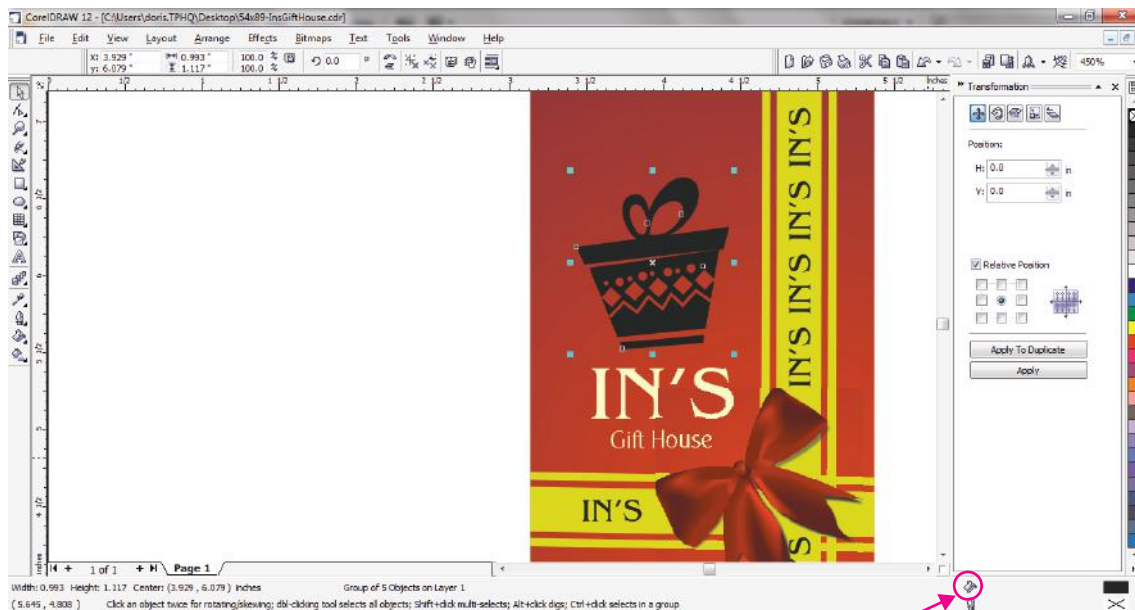
1 Select hot stamping image, then double click the icon.
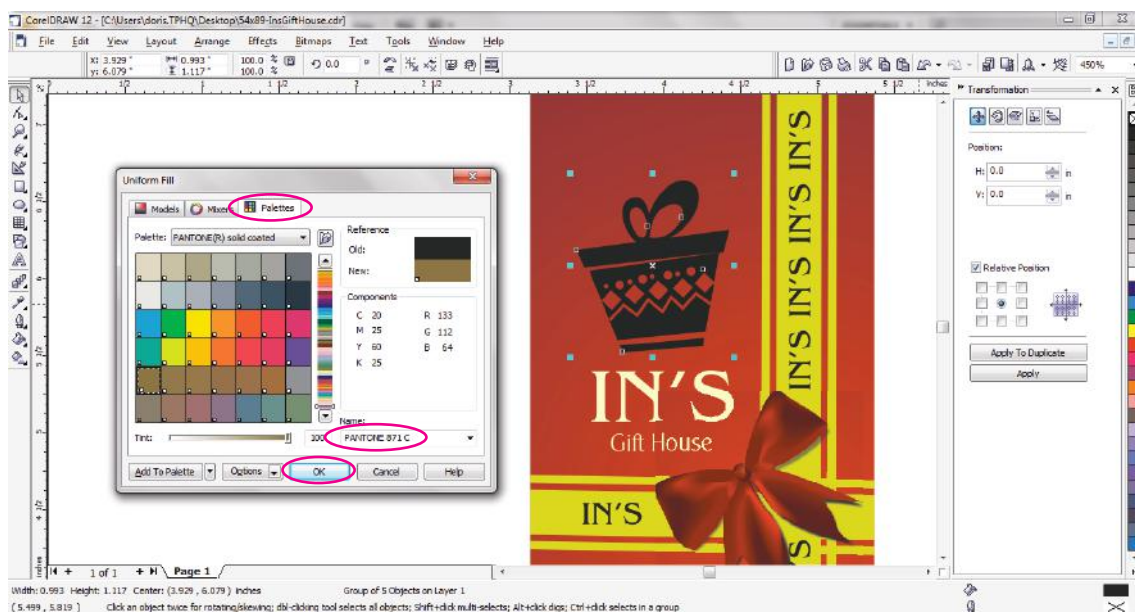
2 Select "Palettes"

3 Enter the Pantone Code.

4 Then, select "OK"

6

Preparing Hot Stamping format in Corel Draw

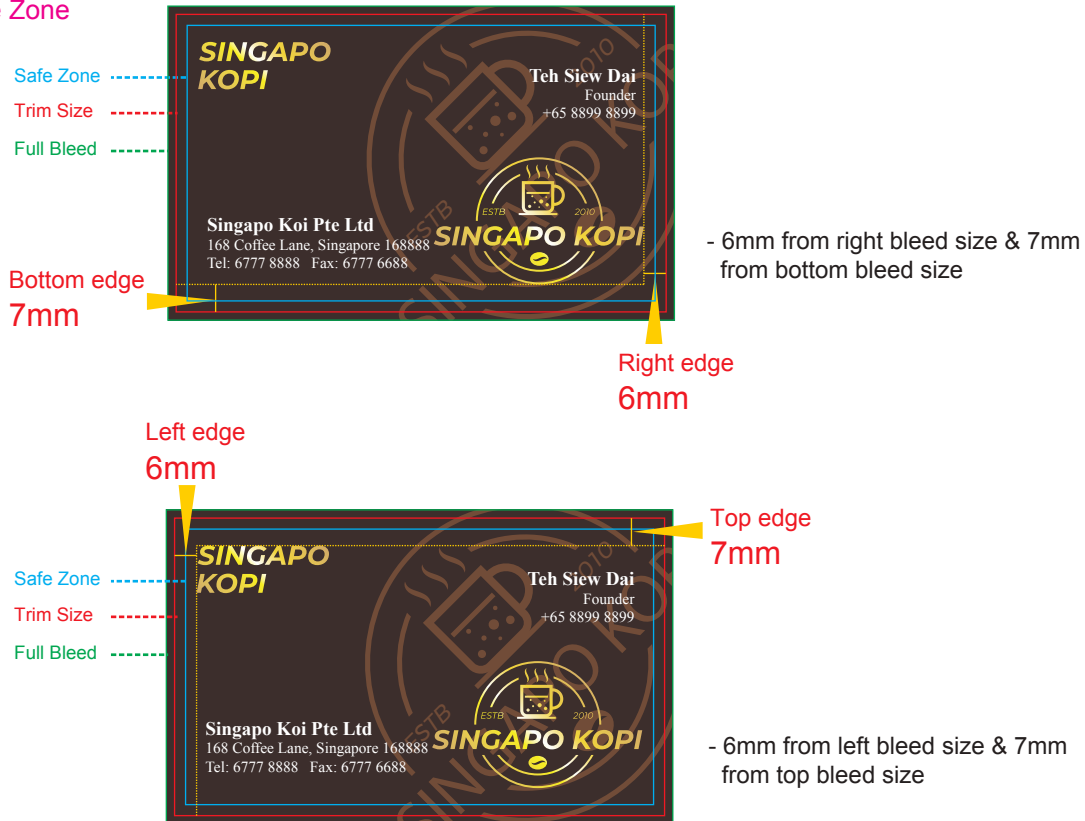**5** Result

Hot Stamping Safe Zone

Image to be hot stamped can be bleed out within the L Shape Safe Zone. While important text MUST within all the safe zone area include L shape Safe Zone.

L Shape Safe Zone

Landscape

Safe Zone
Trim Size
Full Bleed

Bottom edge
7mm

- 6mm from right bleed size & 7mm from bottom bleed size

Right edge
6mm

Left edge
6mm

Top edge
7mm

Safe Zone
Trim Size
Full Bleed

- 6mm from left bleed size & 7mm from top bleed size

L Shape Safe Zone

Portrait

Right edge
7mm

Top edge
6mm

Safe Zone
Trim Size
Full Bleed

Safe Zone
Trim Size
Full Bleed

Bottom edge
6mm

Left edge
7mm

- 7mm from right bleed size & 6mm from top bleed size

- 7mm from left bleed size & 6mm from bottom bleed size
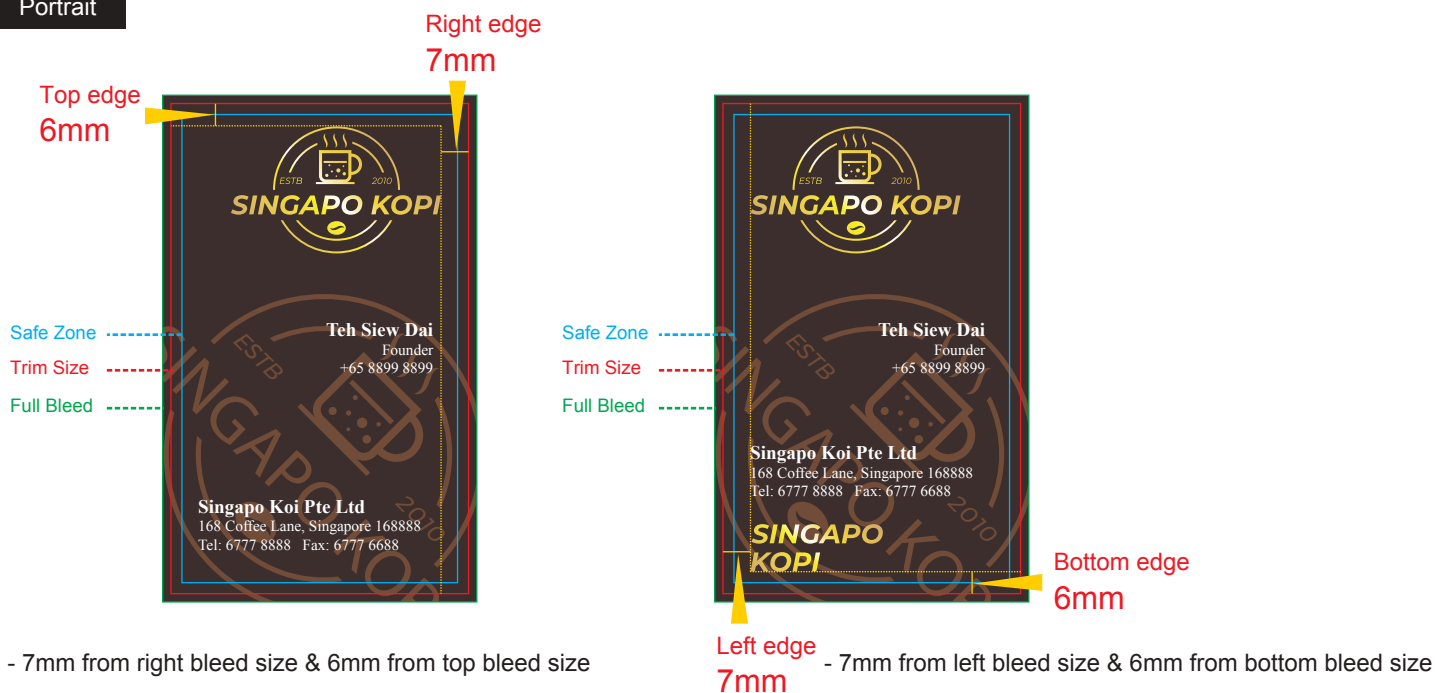
Possible Miss Registration Problems

Applying hot stamping on top of fonts or images require accurate registration.
Here are some possible problems that may occur due to poor registration.
We will not accept artwork which contains the following registration conditions as shown below.

The Desired Effect

Hot Stamping on text with outline

What may happen

Hot Stamping may overlaps the outline

Hot Stamping on text outline

Hot Stamping may not align accurately on text outline

Hot Stamping Tolerance

Product	Tolerance
Business Card Money Packet	± 1.5mm
Wedding Card Booklet	± 1.0mm
Loose Sheet	± 0.5mm (Litho offset) ± 1.0mm (Digital offset)
Packaging Wire-o Notebook	± 0.5mm

- Hot stamping may cause the card thickness to become uneven and packed cards may become slightly curved (i.e. not flat when placed on table, in wallet, card holder, etc). 2B Printing shall not accept any rejects claims for curved Business Cards due to these factors.

- For products with thin paper material such as money packet, art paper or simili loose sheet with hot-stamping finishing, stamping pressure may leave a stamping mark on the back of the product. Hence, members shall notice this risk and 2B Printing shall not be held responsible for the stamping mark on the back.

Reverse Effect For Hot Stamping

The example below is reverse hot stamping:

Printing Made Easier

Normal

优质印刷

Normal

Printing Made Easier

Reverse

优质印刷
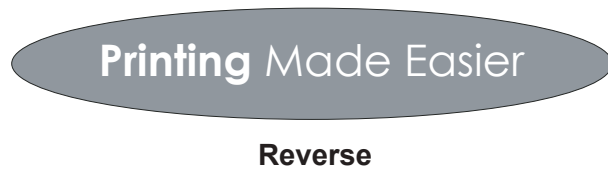
Reverse

The requirement to do reverse effect hot stamping:
1) Do not use Serif font type. Such as "Times New Roman"
2) Use only Sans Serif fonts and bold the font. Such as "Arial"
3) Minimum 10pts for font size and 1pt for line thickness.
4) It is only applicable to Matte lamination Art Paper / Art Card series with condition reverse area should not more than 35mm(H) x 70mm(W).

Printing Made Easier

35mm

70mm

Printing Made Easier

45mm

80mm
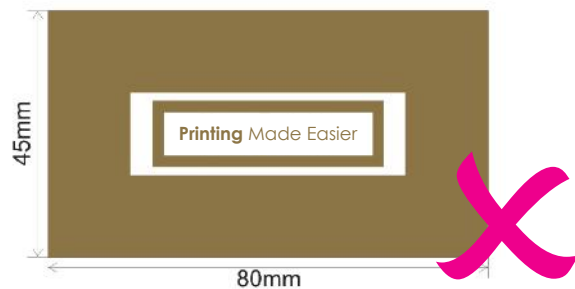
5) It is not applicable to materials with the condition listed below:
   - Uneven surface paper material (such as conqueror paper / card, fine card suwen and linen)
   - Plastic material
   - Metallic card
   - Super white
   - Gloss Lamination
6) Both side artwork with reverse hot stamping is not applicable.

Actual print

Spot UV

Hot Stamping

This artwork specification will guide you to prepare an artwork file that consist of both hot-stamping and spot UV finishing.

Important:
1. Image to be hot-stamped and Spot UV varnished may not be stacked or be too close to one another.
2. Hot stamping need 2mm distance from spot uv

File 1
Full artwork inclusive of image to be hot-stamped

You MUST fill the area/image to be hot-stamped in
Pantone 871C (Gold)
Pantone 877C (Silver)
Pantone 185C (Red)
Pantone 355C (Green)
Pantone 072C (Blue) or
Pantone Black C (Black)

Silver Stamping
Red Stamping

Important:
Different hot stamping cannot close to each other. Please leave 2mm between them.

File 2
Artwork that is to be printed in Offset Colour

File 3
Artwork of Image to be Spot UV varnished
(JPEG file not accepted)

1. Ensure image is positioned accurately (as per File 1) to avoid mis-registration.
2. You MUST fill the area/image to be Spot UV varnished in **PROCESS COLOUR (K=100)**
3. Save your file with transparent background.

DO NOT delete the 'Full Bleed' box; change the line colour to WHITE
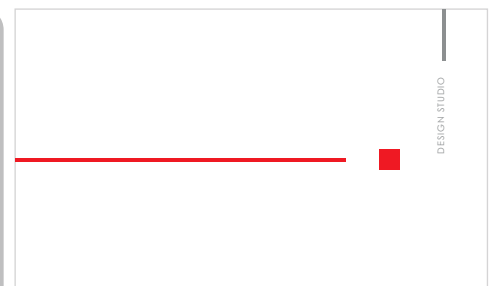
File 4
Artwork of Image to be hot-stamped

Ensure image is positioned accurately (as per File 1) to avoid misregistration.
You may choose a maximum of 2 hot-stamping colours on the same stamping side.

Important:
You MUST fill the area/image to be hot-stamped in Pantone Colour.

DO NOT delete the 'Full Bleed' box; change the line colour to WHITE

Zip all PDF files together

or

Combine and save into 1 PDF file (4 pages)

Double check preparation then upload file online (Front)

2b printing
SOLUTIONS

www.2bprinting.com.sg