Best Practices For Folding Carton Separated Artwork Preparation

Die, Bleed and Marks:
Graphics must be composed to Metro's CAD drawing. This is required in order to ensure proper panel registration and bleeds for the graphics. CAD files will be sent by Metro upon request. This file will come in Illustrator format with all necessary marks, copy limits etc.

Separations:
Dot structure we use is round
Screen ruling is 147
Screen angles are to be determined by separator and indicated on proof
Rich blacks should be built using 100% black 40% cyan
Total area ink coverage should not exceed 275%

UPC's:
Bar Width Reduction should be 0.002 inch

Traps:
.007"

Spread Backs:
.004"

Copy/Line Specifications:
9pt minimum on all reverse copy
6pt minimum on all positive copy
.5pt minimum thickness on all lines

File Specifications:
Unscreened
No Curve Applied
File Formats In Order Of Preference: Native ArtPro
PDF for print
DCS2 Single File*
DCS2 Multi File*
*Note: These must be 'pure' DCS2 files and not another format wrapped into DCS2 for anyone generating there DCS2 files on there print server please check your documentation. If you are trapping in CS and generating your DCS2 files through Nexus we will take PSTI line work and CT files.

Color Naming Convention for Separation Layers:
Process colors should be named each process color layer, in print rotation order as follows: Black, Cyan, Magenta, Yellow.
Spot/Special colors should be named each spot color according to Pantones official names. For example, "PANTONE Red 032 CVC".
The die layer must be named "Die". The display color for the die can be any color that is easily visible and contrasts with the graphics and must also be named "Die".

Job Size & Position:
The job size must be set to match the size of the die.
The grid position must be set to be at the center of the "job size."

Fonts:
All fonts should be outlined or supplied.