



# GOLDEN STAR K

## description

High transprence woodfree E.C.F. (elemental chlorine free) papers, obtained from a large refining of fibres with a particular care of the running of paper machine that gives the paper a natural transprence, without the aid of transprence enhancers.

## range

size	grain	substance
A4	LG	100
A3	SG	100 160
SRA3	SG	160
folio	70x100 LG	80 90 100 110 160 200 240

## technical features

standard/instrument  
unit of measure

substance	thickness	transprence	smoothness	internal tear
ISO 536	ISO 534	DIN 53147	ISO 5627	DIN 53115
gr/m <sup>2</sup>	μ	%	s	mNm/m
			Felt Wire	cross ±10%

80 ± 3%	75 ± 5	75	25 ± 10	25 ± 10	690
90 ± 3%	80 ± 5	75	25 ± 10	25 ± 10	785
100 ± 3%	85 ± 5	75	25 ± 10	25 ± 10	880
110 ± 3%	95 ± 5	72	25 ± 10	25 ± 10	980
160 ± 3%	125 ± 5	65	15 ± 5	25 ± 10	1470
200 ± 4%	160 ± 5	65	12 ± 5	15 ± 5	1850
240 ± 5%	185 ± 5	60	10 ± 5	15 ± 5	2250

Surface pH 8 ± 0,5

## ecological features



ELEMENTAL  
CHLORINE  
FREE  
GUARANTEED



## notes

This paper, in its nature, is particularly sensitive to hygrometric variations. The optimum condition of storage environment and of use of the product are: temperature between 17 and 23°C (63-73°F); relative humidity 50% ± 5.

The product is completely biodegradable and recyclable. Special runs available upon request.



Envelopes available on stock.

The Company reserves the right to modify the technological features of the product in relation to market requirements.



Golden Star K is used in de luxe publishing for dust jackets and insterts printing, mailing, as well as in stationery for envelopes and shoppers.

applications

GSK is pulp and surface-sized in order to make it suitable for drawing and writing with manual techniques or plotter. GSK is ideal for single and multi colour printings with offset, letterpress and screen printing processes. The paper is particularly reactive to humidity changes, and reaches very rapidly the balance with the environment: all that entails dimensional variations. We recommend to leave the paper in its wrapping for 24 hours in the printing room. If the need is to print in multi-colour we recommend to work in a conditioned room, or at least to take all the cares required to avoid dimensional variations. GSK can be used with the main printing systems: letterpress, offset, blind embossing, hot-foil stamping, thermographic and screen printing. The surface has no porosity, so that inks do not dry through absorption into the media. Polymerisation in offset printing from the sheet takes place by means of oxidation, so that inks for plastics should be used. Excellent results have been achieved with U.V. inks and in web offset printing with Heat Set inks. The adhesion of the ink, once dry, is very good. It is also particularly important to check the other process variables, especially the fountain solution, which must be dosed at minimum levels to ensure that emulsifying is kept within modest levels. We recommend a buffered pH of 5÷5,5 with 800÷1200 µS conductivity. It may be appropriate to add small quantities of additives to the fountain solution and/or the ink to accelerate the ink polymerisation process. Anti-setoff spray powder is useful and low output stacks are necessary. Drying times depend on the quantity of ink and process variables and may vary from 8-10 hours to more than 24 hours. In this regard, good results are obtained with UCR and GCR grading to reduce the mass of ink transferred on to the paper.

printing  
suggestions

In hot foil stamping, because of the high density of these papers and their very low compressibility, careful adjustments of the process temperature and pressure is required. Appropriate foil and the use of specific backing material is recommended when printing large areas.

For the cutting stage we recommend to employ “used blades” sharpened to 23°; cut small stacks, at the most 5 cm; also in die-cutting avoid too sharpened tools. Fold preferably with folds parallel to the grain direction: avoid low-damp conditions, especially to fold the lighter substances.

converting  
suggestions

GSC also can be sewed with metallic stitch, however the lighter substances are critical. In sizing we suggest to use Hot melt glues, also cold glue as long as not water-based. In paper binding the glue must be put along the grain direction.

GSC can be plastic laminated on one side or on both sides. We suggest to do careful and preventive tests with your usual plastic-coater. In case of hygrometric variations, plastic laminating only on one side might cause curling problems .