All4Labels
GLOBAL PACKAGING GROUP

Process Specification

All4Labels Global Packaging Group

General & Contacts

- Date: 10.06.2026
- Version: 2.0
- Address: Möllner Landstraße 15, 22969 Witzhave
- Print Process:

1	Combination	6	Inkjet
2	Flexography	7	
3	HD Flexo	8	
4	Silkscreening	9	
5	Digital Offset	10	

Account Management Contact Person

- Tel.: Email:
- Tel.: Email:
- Tel.: Email:
- Tel.: Email:

Additional Request / Remarks

Color / Proof
Specifications

Color / Proof Specifications

Maximum Number of Colors

- Combination 12
- Digital Offset 7/20
-
-
-
-

Preferred Color Sequence

- Flexography cmyk
- HD Flexo cmykogv
- Silkscreening single color
-
-
-

Preferred Grid and Screen Angles

- Combination 175lpi; C7,5°, M67,5°, Y22,5°, K37,5°
- Flexography 155lpi; C7,5°, M67,5°, Y22,5°, K37,5°
- HD Flexo 175lpi; C7,5°, M67,5°, Y22,5°, K37,5°
- Silkscreening 96lpi; 45°
- Digital Offset 180lpi; C4°, M64°, Y18°, K34° // O,V,G64°,M1 4°

Remarks

CMYK color mode is mandatory
we do not use silksreen for CMYK images

Color / Proof Specifications

Color Profile for Digital Proof

- mx4 ISO Coated v2 (ECI) Usage: universal flexo
- Usage:

Typical Dot Gain

Process	5%		20%		50%		80%	
HD Flexo	8	%	45	%	68	%	91	%
Digital Offset	8	%	30	%	64	%	88	%
		%		%		%		%
		%		%		%		%
		%		%		%		%
		%		%		%		%
		%		%		%		%
		%		%		%		%
		%		%		%		%
		%		%		%		%

Spot Color Rules

General Repro
Specifications

General Repro Specifications

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Image Data Resolution

Combination	300	ppi	Silkscreening	600	ppi
Flexography	300	ppi	Digital Offset	600	ppi
HD Flexo	600	ppi	Inkjet	300	ppi

Tonal Values

Flexography	Min. Stable Printing Dot:	2	%	Min. Percentage in File:	2	%	Vignettes from:	2	% to	97	%
HD Flexo	Min. Stable Printing Dot:	2	%	Min. Percentage in File:	2	%	Vignettes from:	1	% to	99	%
Silkscreening	Min. Stable Printing Dot:	5	%	Min. Percentage in File:	5	%	Vignettes from:		% to		%
Digital Offset	Min. Stable Printing Dot:	1	%	Min. Percentage in File:	1	%	Vignettes from:	1	% to	99	%
Inkjet	Min. Stable Printing Dot:	1	%	Min. Percentage in File:	1	%	Vignettes from:	1	% to	99	%

Trapping

Flexography	Standard:	0,2	mm	Comb.:	0,3	mm	Silkscreening	Standard:	0,4	mm	Comb.: 0,3 mm
HD Flexo	Standard:	0,2	mm	Comb.:	0,3	mm	Inkjet	Standard:	0,14	mm	Comb.: mm

Bleed Cut / Crease Tolerance

All processes	Bleed:	1,5	mm	Cut Tolerance:	1	mm	Booklabel	Bleed:	1,5	mm	Cut Tolerance: 2 mm
Multilayer	Bleed:	1,5	mm	Cut Tolerance:	1,5	mm		Bleed:		mm	Cut Tolerance: mm

General Repro Specifications

Minimum Text Sizes & Line Thickness Values

• Flexography	Pos. Text:	4	pt	Negative Text:	5	pt	Pos. Line:	0,1	mm	Negative Line:	0,2	mm
• HD Flexo	Pos. Text:	4	pt	Negative Text:	5	pt	Pos. Line:	0,1	mm	Negative Line:	0,2	mm
• Silkscreening	Pos. Text:	5	pt	Negative Text:	6	pt	Pos. Line:	0,1	mm	Negative Line:	0,2	mm
• Digital Offset	Pos. Text:	4	pt	Negative Text:	4	pt	Pos. Line:	0,01	mm	Negative Line:	0,05	mm
• Inkjet	Pos. Text:	4	pt	Negative Text:	4	pt	Pos. Line:	0,1	mm	Negative Line:	0,1	mm

Barcode Specifications

• Combination	Min. Magnification:	80	%	Bar Width Reduction in Print Dir.:	0,04	mm	Against Print Dir.:	0,04	mm
• Inkjet	Min. Magnification:	80	%	Bar Width Reduction in Print Dir.:	0,02	mm	Against Print Dir.:	0,02	mm
• HD Flexo	Min. Magnification:	80	%	Bar Width Reduction in Print Dir.:	0,04	mm	Against Print Dir.:	0,04	mm
• Silkscreening	Min. Magnification:	80	%	Bar Width Reduction in Print Dir.:	0,02	mm	Against Print Dir.:	0,02	mm
• Digital Offset	Min. Magnification:	80	%	Bar Width Reduction in Print Dir.:	0,04	mm	Against Print Dir.:	0,04	mm

Additional Request / Remarks

coldpress foil uses same values as flexopraphy

Minimum text sizes and line thickness can only be achieved in non compressed textes in regular/roman and normal type width and a single color. Typo in silk screen should not be compressed.

Please be aware, since ADOBE stopped the support for all Type 1 fonts, we do not accept Type 1 fonts (Postscript, PS1, T1, Adobe Type1 and similar) in delivered artworks.

File Formats /
Data Transfer

File Formats / Data Transfer

Accepted File Formats (in order of preference)

- ArtPro+ Version: 18
- ESKO ArtPro Version: 18
- Adobe Illustrator Version: CC
- Adobe InDesign Version: CC
- PDF Version: 1.6

Medium of Data Transfer (in order of preference)

- CD
- DVD
- FTP

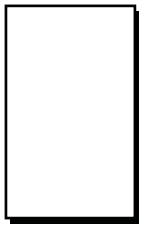
Proofs / Printouts required at Data Transfer

colour targets or proofs are required at data transfer for correct pre press work prior to print

Additional Requests / Remarks

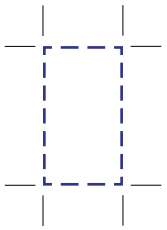
Basic
Settings

Basic Settings



Document

- color mode: CMYK
- avoid redundant or irrelevant colors
- avoid redundant layers
- the print file should be a PDF/X-4 document or a normalized PDF file

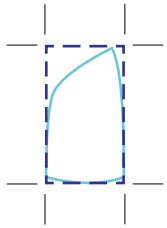


Document Settings

- define the document size to match the label size
- technical colours within the print-area have to be set as "overprinting"
- avoid redundant layers
- the print file should be a PDF/X-4 document or a normalized PDF file

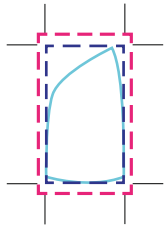
Die Cut Border

- the cutting die should be centered in the document, defined as full tone ink ("overprinting") and named adequately (e.g. die cut)



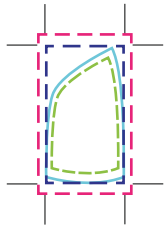
Bleed

- outside of the printing area, 1,5 mm overlap is required



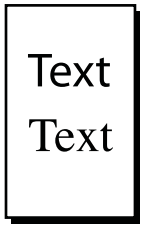
Type Area

- the type area (except bleeding elements) should have a minimum distance of 1mm to the cutting die



Text &
Pictures

Text & Pictures

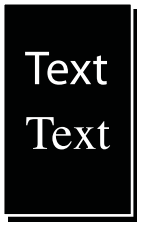


Positive Text

- positive sans-serif text should have a minimum size (see above)
- black text has to be applied in 100% black, not in CMYK, “overprinting“

Colored / Grey Scale

- for grey scaled and coloured pictures you should use a 300 ppi resolution
- for positive scaled pictures, you should use a accordingly higher resolution
- to avoid highlight breaks in certain colours, you should fill light areas with a minimum of 2% covering



Negative Text

- negative sans-serif text should have a minimum size (see above)
- at flexoprinting a medium type style is re-commended to work better against print growth

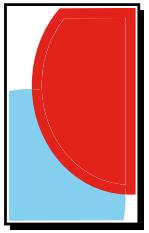
Line / Text

- for lines and text you should use a resolution of 1200 ppi

Print
Technical

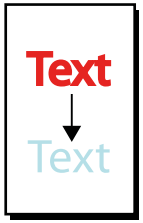
Print Technical

Trapping



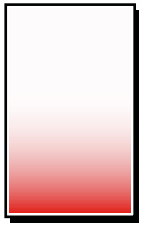
- the lighter colour will be trapped into the darker colour
- you should trap the colors (see above for details)

Backing / Underlay



- backings / underlays have to be smaller than the element printing over it (see above)

Technical Gradients



- backings / underlays have to be smaller than the element printing over it (see above)
- gradients have to fade out to 2%

Positive Outlines and Line

- for positive outlines and lines you should use a width of minimum 0,1 mm

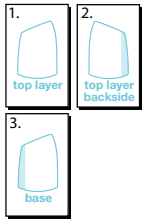
Negative Outlines and Line

- for negative outlines and lines you should use a width of minimum 0,2 mm

Negative Multicolor

- for negative lines/elements in multiple separations, registration errors have to be considered in the trapping for each color

Multilayer Labels



- for multilayer labels you should use one document page for each layer