



# **Combibloc & Pure Pak Specifications for Design & Printing**



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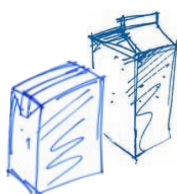
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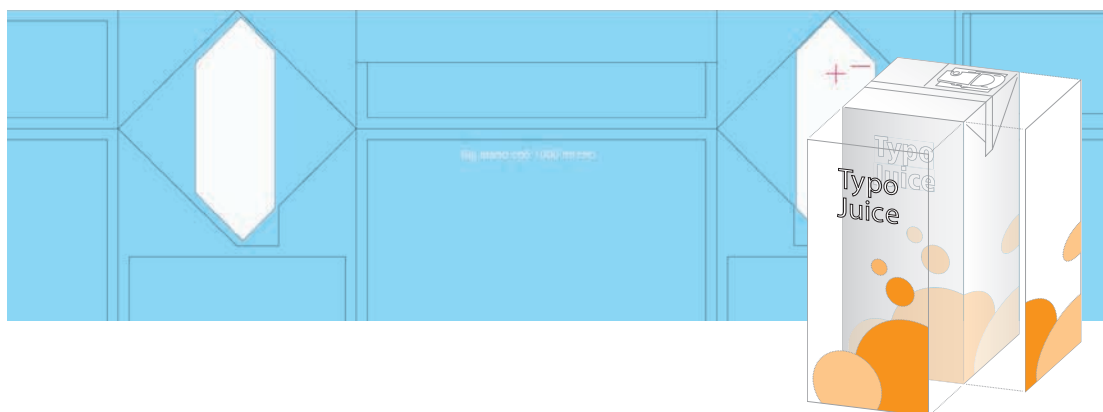
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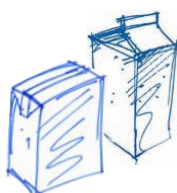


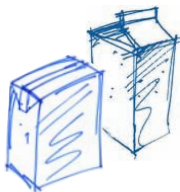
## The VISY system for success.

VISY Primary Packaging (*combibloc* & Pure Pak) is the company leading the way in the Australasian packaging industry. We manufacture *aseptic* & Gable Top carton packaging for foodstuffs such as milk, juice, soups and sauces while providing and maintaining the required filling machines.

VISY is driven by the goal of achieving joint success with our customers. We use our high-grade, high-performance and flexible system throughout the entire packaging process. One portion of this process is preparing the packaging design for production in Offset and Flexo printing.

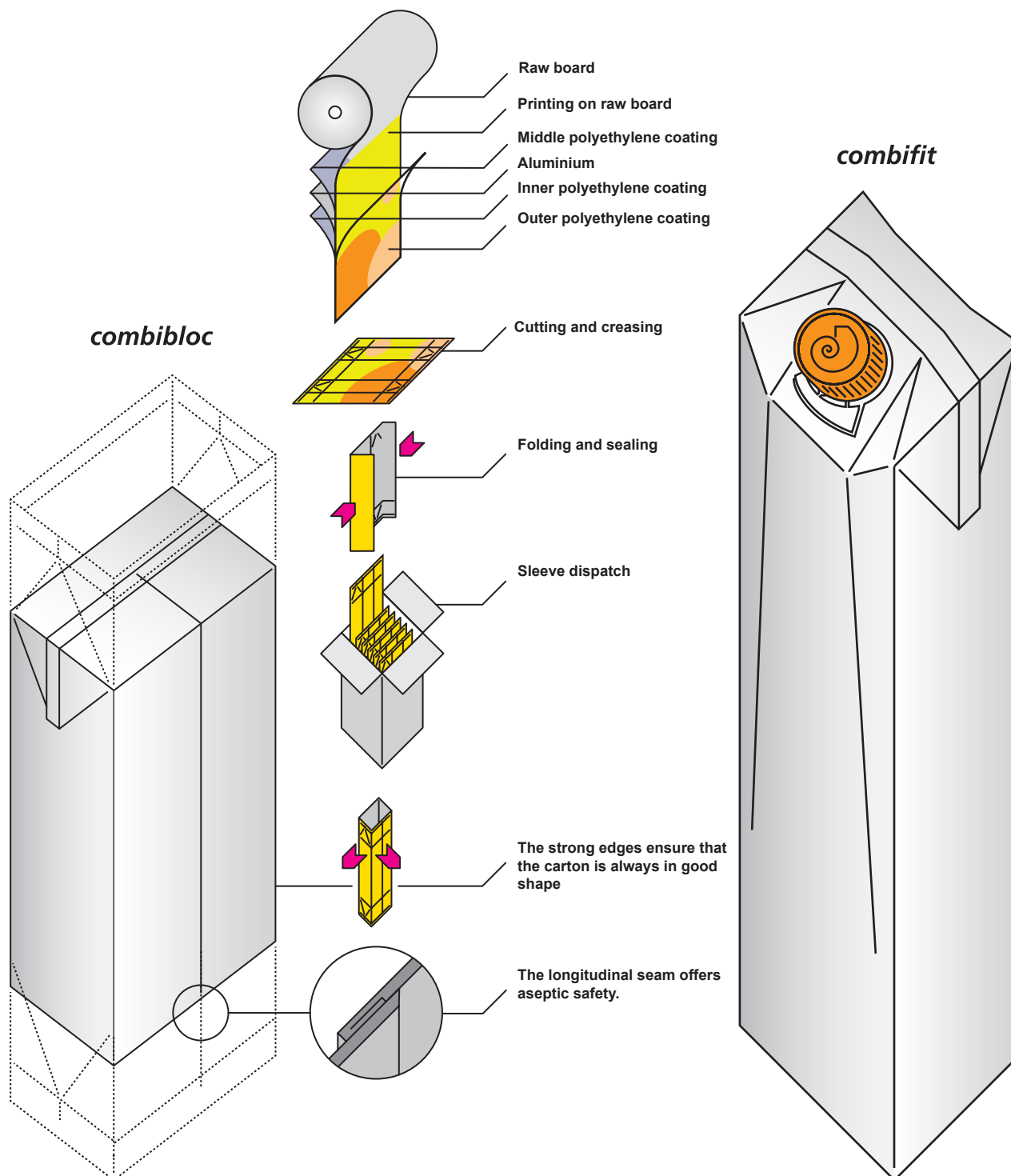
VISY would like to present this manual to you in order to support you in laying out the design of your carton packaging. Applying the criteria described in this manual will provide a reliable foundation for the optimum adaptation of your design ideas to the VISY production technology.





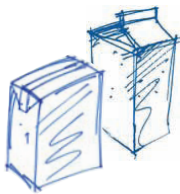
# Introduction

Carton structure for *combibloc* and *combifit*



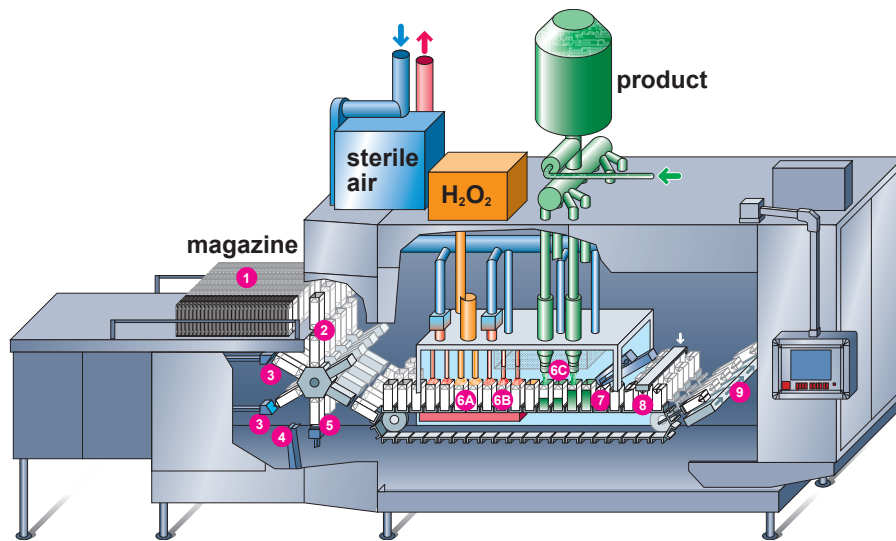
The preformed carton sleeves are produced in the packaging material plants at VISY Combibloc and they are later aseptically filled on the filling machines at the customers premises. The carton is given an inside and outside layer of high-grade polyethylene (PE) including an extremely thin layer of aluminium and another inner layer of polyethylene.

Before outer coating is applied, a high-grade Offset (Litho) printing technique that is especially suited to high runs of sophisticated products with intensive colours is used to print the carton.

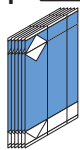


# Introduction

## The *combibloc* Filling Machine Process

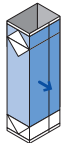


### 1 Magazine



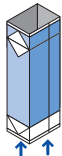
The magazine holds the sleeves, and is refilled by the operator or the optional CAM module.

### 2 Sleeve extraction and opening-up of sleeves



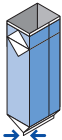
The individual sleeves are extracted through suction units, they are opened up rectangularly and are pushed onto a mandrel. This ensures a reliable guidance for the sealing of the bottom section.

### 3 Bottom activation



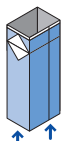
Hot air is used at two stations to activate the areas of the bottom section of the sleeve.

### 4 Bottom folding

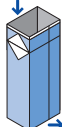


During the time the mandrel wheel transports the sleeve to the bottom pressing station, rotating lateral folders and a longitudinal folder are used to prefold the bottom section.

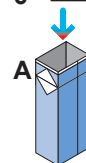
### 5 Bottom pressing station



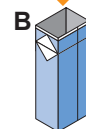
Bottom press dies and the face side of the mandrel are used to fully press and seal the bottom section of the carton. The specific design of the pressing elements ensures the typical, patented concave-shaped bottom section guaranteeing the particularly good standing features.



### 6 Aseptic area



First, hydrogen peroxide steam is injected in order to sterilize the inside of the carton.

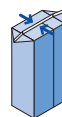


Afterwards, heated sterile air is blown in at several stations to dry out the package from the inside. The sterilization process is used to kill all micro-organisms inside the package in a reliable way.



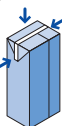
The product is then filled into the carton in two stages. The aseptic zone is under a slight overpressure of sterile air, thus avoiding the ingress of non-sterile air from the outside. This prevents the aseptic area from being contaminated.

### 7 Top sealing through ultrasonic sealing



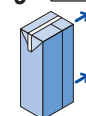
The top section of the carton is folded by ultrasonic sealing tools and is sealed above the filling level. Before sealing the carton with ultrasonic energy, steam is injected into the carton to reduce the head space to a minimum after the cooling-down process. A nitrogen injection is available as an option.

### 8 Top forming station

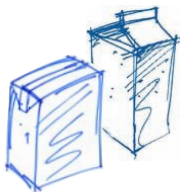


The polyethylene is heated up with hot air at the top triangles (ears) and at the narrow side of the carton, the top triangles are then folded downwards and are sealed to the carton.

### 9 Ejector and discharge station

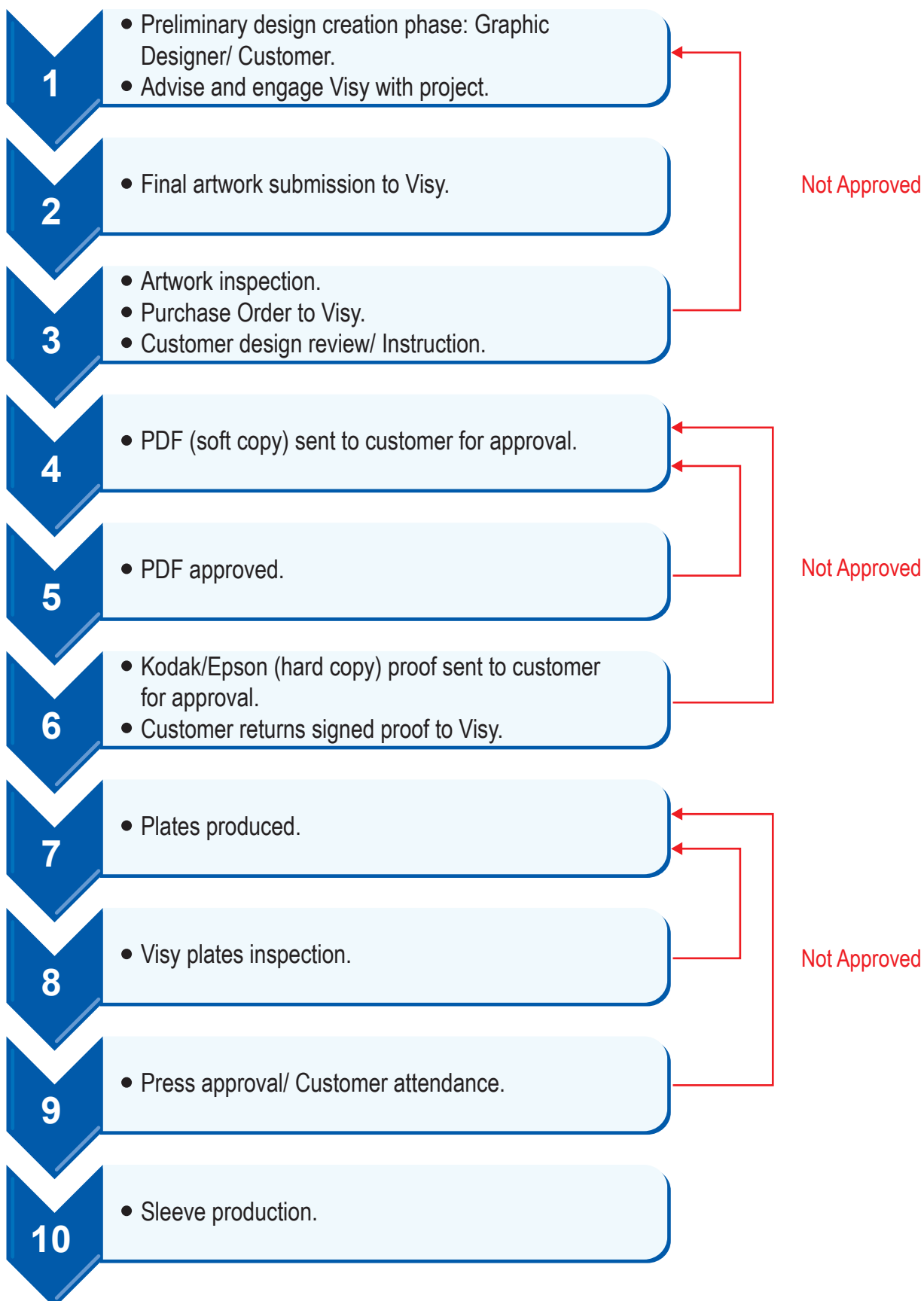


The carton is ejected out of the pocket chain, and is put up and then placed onto the out feeding conveyor.



# Introduction

## combibloc & PURE-PAK Design Workflow



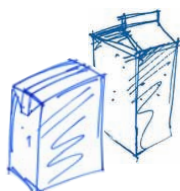




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# ***combibloc (aseptic) specifications*** **for Design & Printing**

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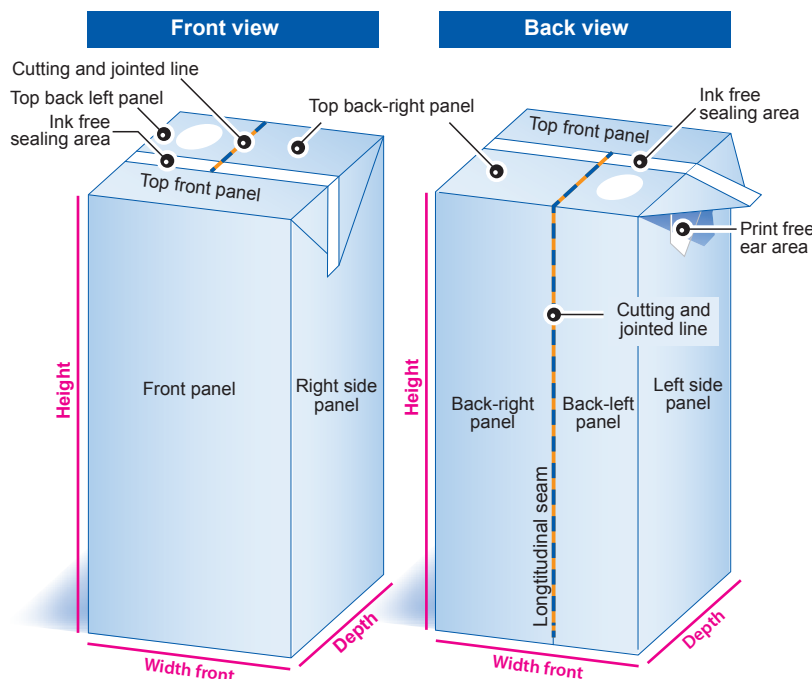
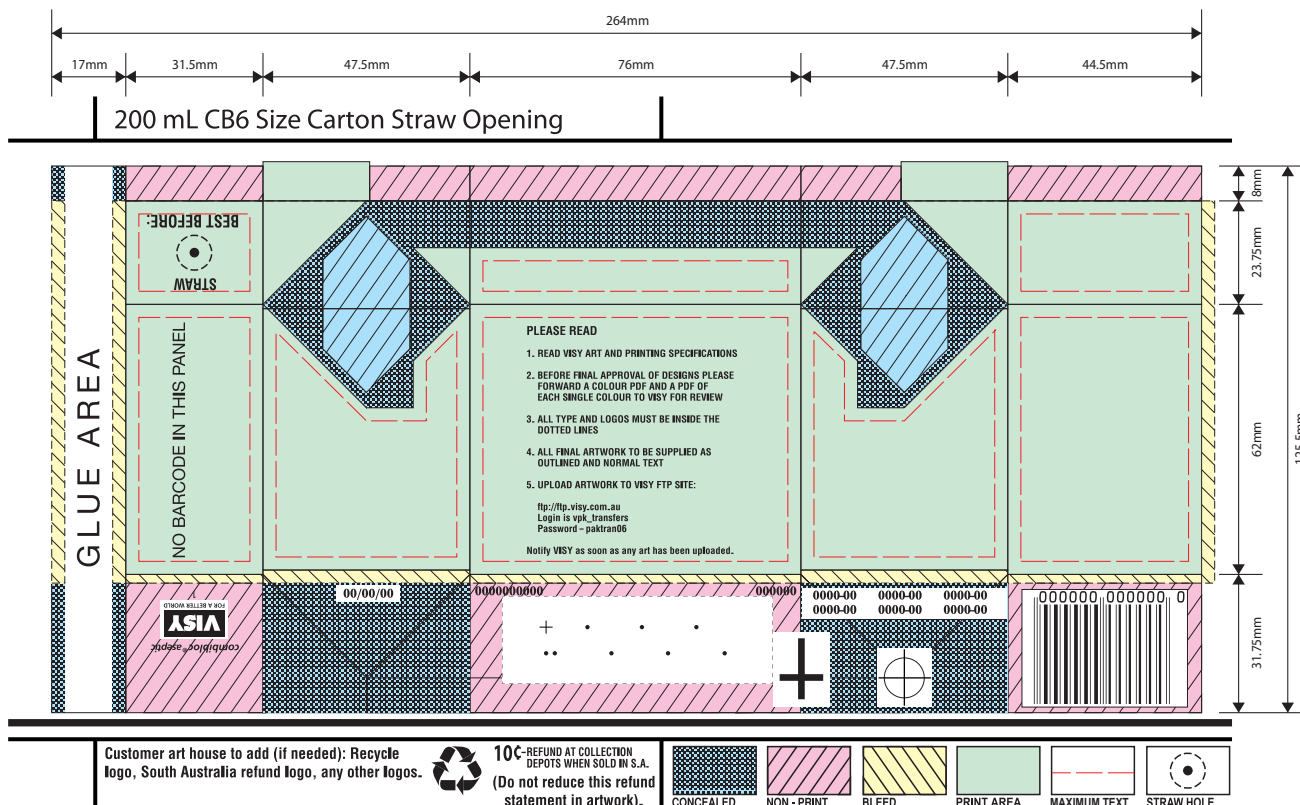
**PURE-PAK®**

**Combibloc® aseptic**



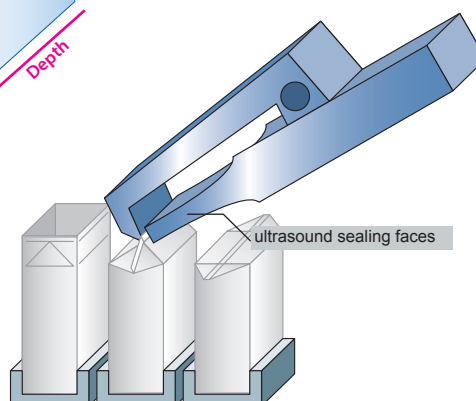
# combibloc (aseptic)

Working with *combibloc* Keylines (CB6)



Width front (mm)	Depth (mm)
76	47.5
Sizes (ml)	Height (mm)
200	62
250	75
375	109
500	142.5
Re-setting measurement (mm)	
Single	Total
123.75	247.5

The seal is generated by pressure and ultrasound and pressure is applied by two sealing faces.



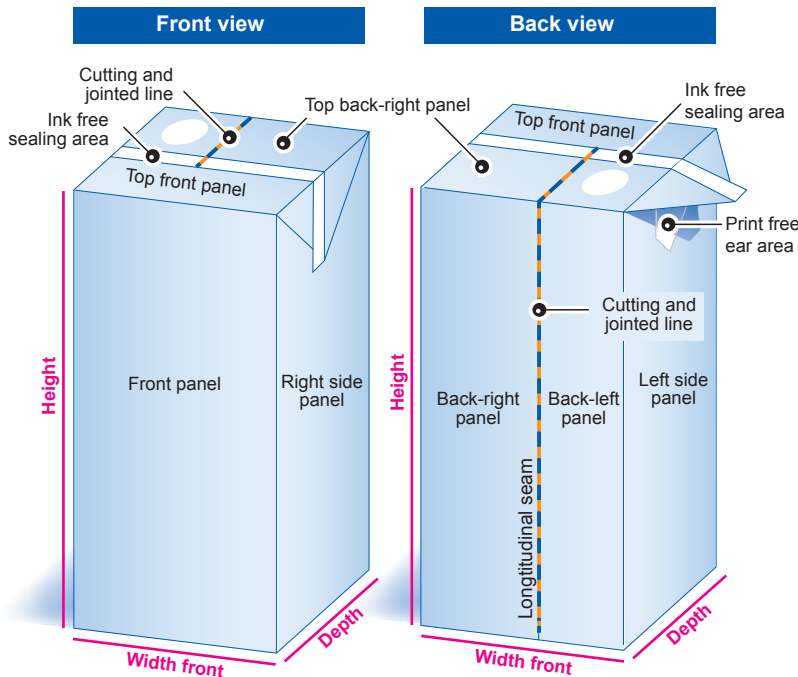
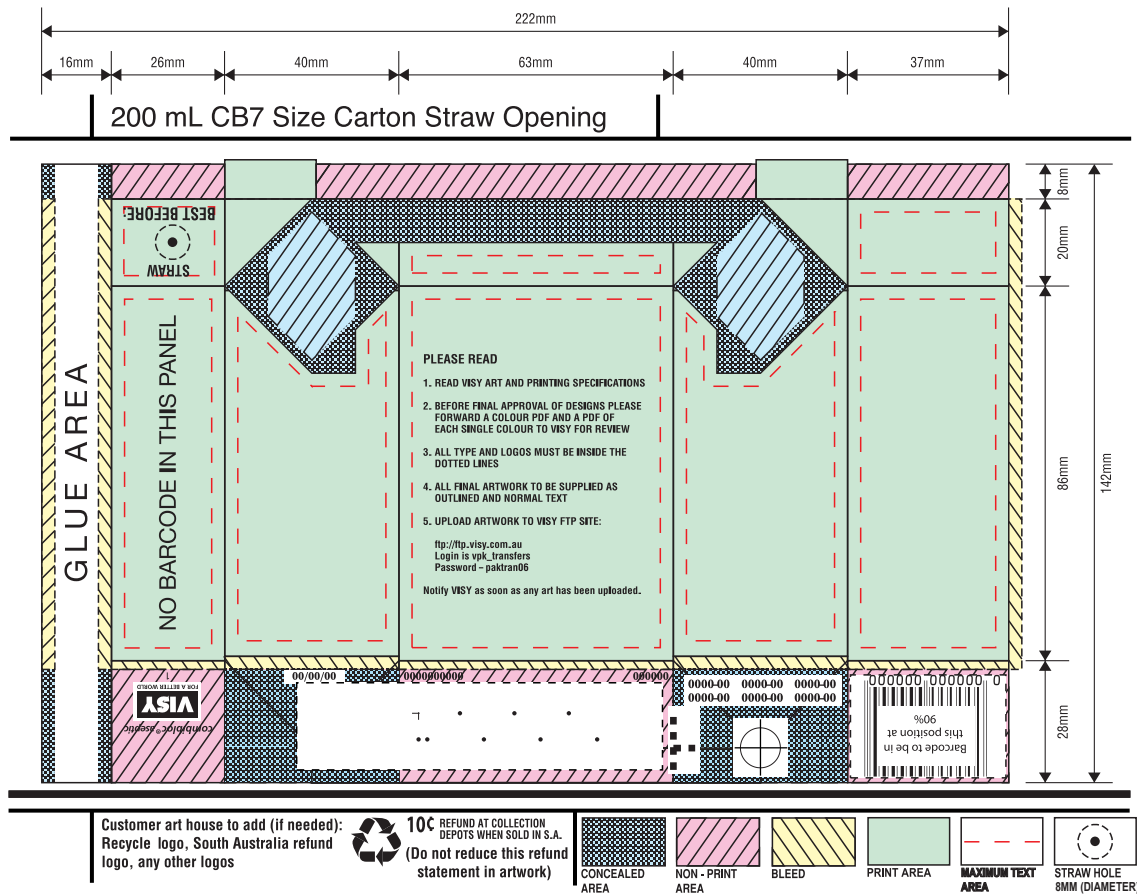
Working with *combibloc* Keylines (CB6)





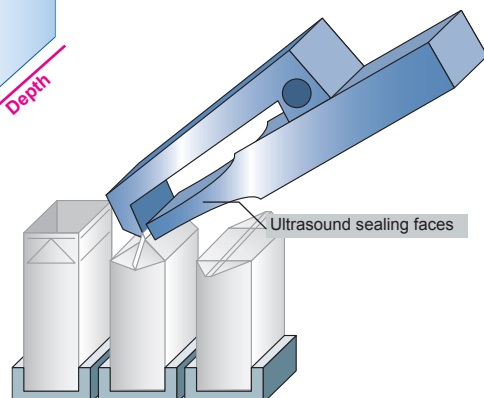
# combibloc (aseptic)

Working with *combibloc* Keylines (CB7)



Width front (mm)	Depth (mm)
63	40
Sizes (ml)	Height (mm)
150	66.5
200	86
250	105
300	124
330	135
350	142.5
375	151.75
Re-setting measurement (mm)	
Single	Total
103.25	206.5

The seal is generated by pressure and ultrasound and pressure is applied by two sealing faces.





# combibloc (aseptic)

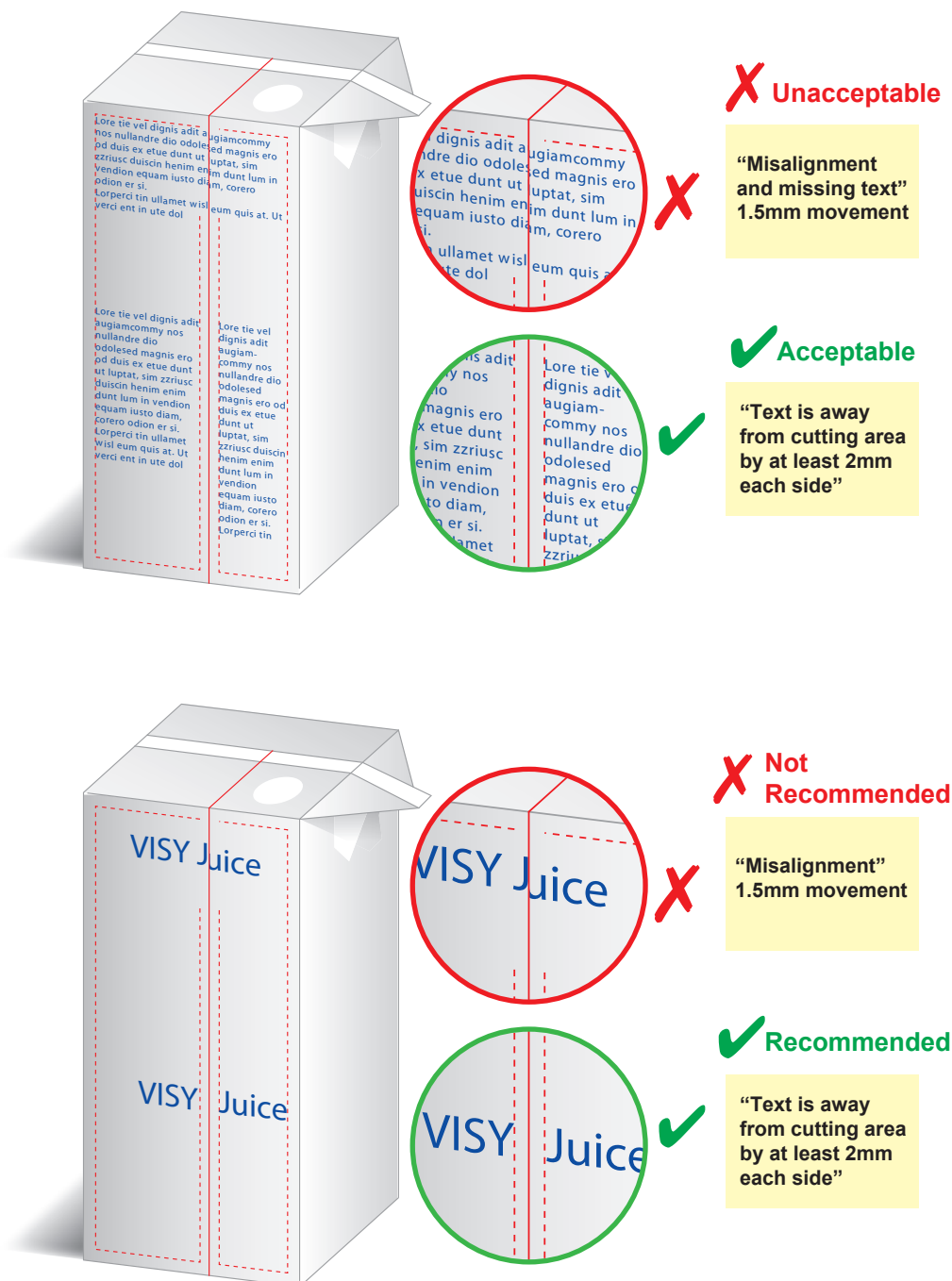
## VISY combibloc Back Panel & Seam



In order to avoid possible misalignment and missing text on the cutting area of back panel, we recommend to split the text to 2 columns and leave the space between cutting area of at least 2mm each side.

Cut to print deviation can be **up to 1.5mm on the back seam.**

Please Note: Where the pack is within the VISY tolerances, VISY will take **"No Responsibility"** for any type missing or not lining up over back seam.





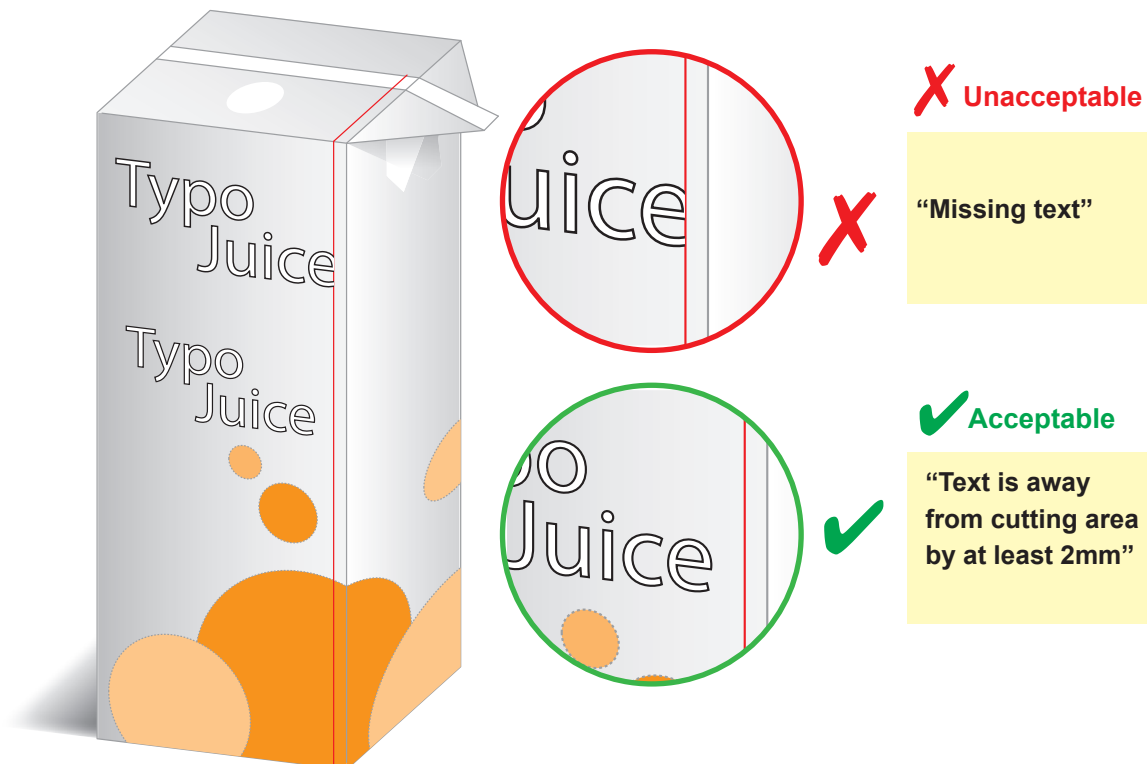
## combibloc (aseptic)

### Back Panel & Seam



In order to avoid possible misalignment and missing text on the cutting area of back panel, we recommend to leave a space between cutting area of at least 2mm each side.

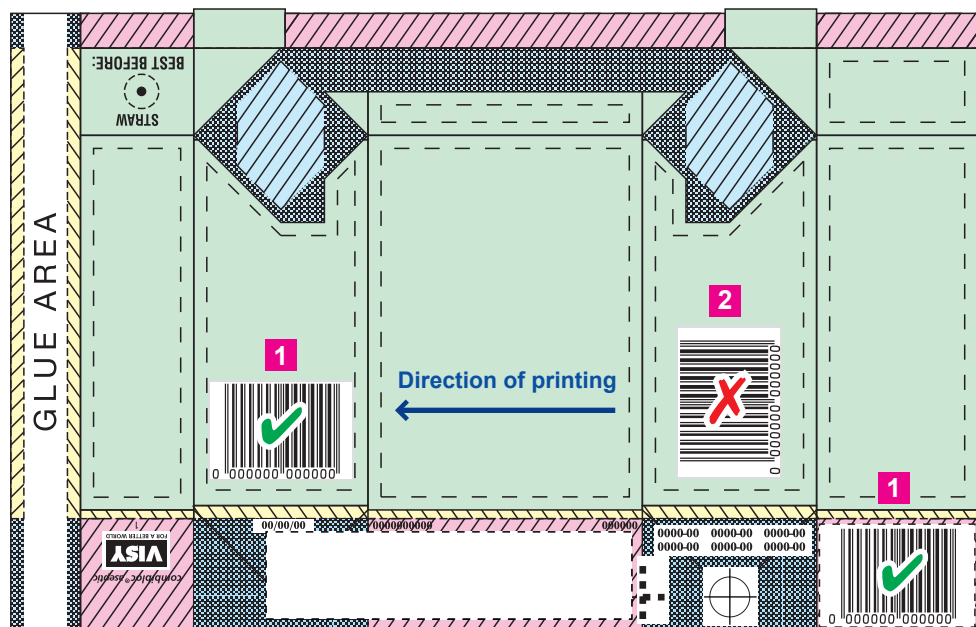
Please Note: Where the pack is within the VISY tolerances, VISY will take "No Responsibility" for any type missing or not lining up over back seam.





# combibloc (aseptic)

## Combibloc Barcode Size & Position



**1** The barcodes standard position is parallel to the print direction, In this position VISY will ensure the readability of the barcodes in the standard position. Barcode are to be created and printed in a single dark colour (1 colour) only. All printed barcodes will be checked using the same equipment as EAN.

**2** In this position VISY will not guarantee the readability of the barcodes. If artwork is received which shows that barcodes have been created and positioned contrary to VISY recommendation, a written statement will be required absolving VISY of any liability for poor or zero decode.

■ For barcode placement, all VISY require is the relevant number. VISY will ensure that the barcode is generated according to the correct barcode specifications.

Standard barcode size - EAN 13			Standard barcode size - EAN 8		
90%	-	23.63mm x 35.56mm	90%	-	20.99mm x 26.25mm
100%	-	26.26mm x 37.29mm	100%	-	23.12mm x 29.12mm
110%	-	28.89mm x 41.02mm	110%	-	25.25mm x 32.00mm
125%	-	32.83mm x 46.61mm	125%	-	28.45mm x 36.30mm

■ Barcodes must be set up in a high contrast colour. Therefore, please set up the code in black, cyan, dark blue or dark green and avoid codes in yellow, orange, red, violet, bright brown tones and pastel colours since the red-light laser perceives these colours as white.



Please ensure

- Positive text and keyline thickness > 0.4mm
- Positive text size > 6pt bold sans serif
- Do not use composed colours on small text. Use only one colour text

At least > 0.18mm



### Text Image

IMAGE



Recommended: The text will look sharp and clear if use vectorized text convert into path on Illustrator file.

IMAGE



Not recommended: The text looks blurred if use the rasterized text or Photoshop file.

### Text Line Thickness & Size

Original Data	Printing Result



Recommended: For legible text on the final packaging use:

- Text line thickness: not less than 0.18mm
- Text Height: not less than 6pt



Not recommended: The text will be illegible and become broken text if use text size is smaller than recommended.

### Text Colour

One colour only

JUICE



Recommended: One colour for positive text for sharp text result on the packaging.

M50 + Y100 + C100 + K50

JUICE



Not recommended: The text will be blurred, if use composed colours due to print register movement.



# combibloc (aseptic)

## Negative (Reverse) Text Specifications



Please ensure

- Negative (reverse) text and keyline thickness > 0.4mm
- Negative (reverse) text size > 8pt bold sans serif
- Do not use composed colours on small text. Use only one colour text  
outline of negative (reverse) text on composed colour background is > 0.5mm.

At least 0.25mm



### Text line thickness & size

One ink for background colour	
Original Data	Printing Result
Type thickness $\geq 0.25mm$ Concentrated	Concentrated
Below minimum spec, type will "close-up" (fill in) Concentrated	Concentrated



Recommended: For legible text on the final packaging use:

- Text Line Thickness: not less than 0.25mm
- Text Height: not less than 8pt bold sans serif



Not recommended: If the type is below the minimum specification, some part of text will disappear and will not be readable due to ink filling in the gaps.

### Reverse text (white text) on composed background

Three inks on background colour	
Original data	Printing result
With darkest colour outline 0.3mm around text Concentrated	Concentrated
Without the outline frame on text Concentrated	Concentrated



Recommended: Create an outline of darkest colour thickness 0.3mm around the white text for colour trapping. Otherwise, the white text will become blurred due to print register movement.



Not recommended: Without an outline thickness around the text, the white text will become blurred due to print register movement.





VISY recommend that vignettes be created with a maximum of three colours. Vignettes to be created with a start system value of 1% and continue to 100% with in the 256 grey levels.

In pixel oriented vignettes the resolution should be 300 dpi.





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# Pure Pak (Gable Top) Specifications for Design & Printing

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**PURE-PAK®**

Combibloc® aseptic



# PURE-PAK (Gable Top)

## PURE-PAK Design Specifications



VISY Primary Packaging (PURE-PAK) manufacture Gable Top carton packaging for foodstuffs such as milk, juice, soups and sauces. VISY Packaging offer two printing options, Offset (Quality Print) and Flexo (Standard Print).

Flexo (Standard Print) has a maximum of 4 spot colours available and is commonly used for the more simple spot colour plain designs.

Please Note: 4 Colour Process printing is not possible on Flexo Standard Print.

Offset (Quality Print) has a maximum of 6 colours available and is commonly used for the more advanced high quality 4 colour process/special colour designs.

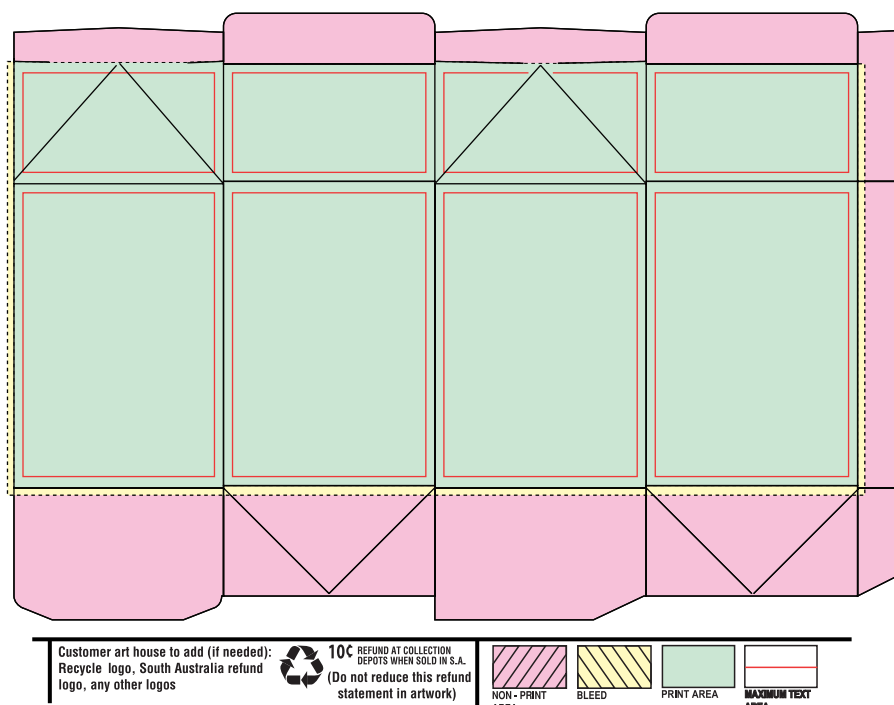
Visy is driven by the goal of achieving joint success with our customers. We use our high-grade, high-performance and flexible system throughout the entire packaging process. One portion of this process is preparing the packaging design for production in Offset and Flexo printing.

We would like to present this section of the manual to you in order to support in laying out the design of your carton packaging. Applying the criteria described in this manual will provide a reliable foundation for the optimum adaptation of your design ideas to the VISY production technology.



# PURE-PAK (Gable Top)

Working with PURE-PAK Keylines



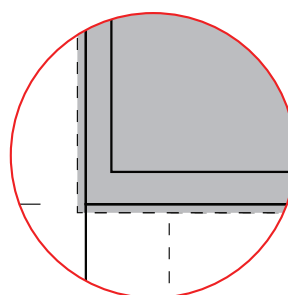
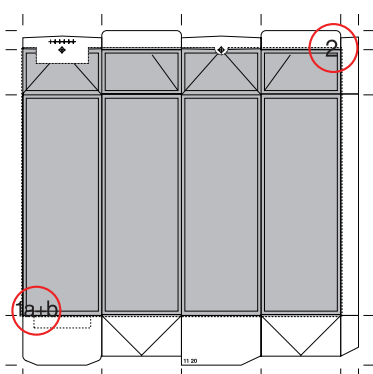
## ■ Link up panels 1 and 4

If your illustration or image covers all four panels, please allow for an element of overlap (illustrated below) on both panels one and four (figs. 1a and 2).

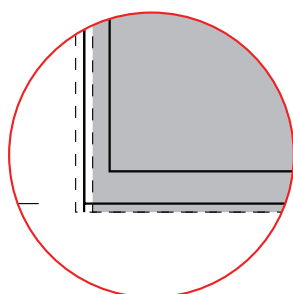
If your illustration or image is required to 'wrap' around the carton, pictures and lines etc, on the left hand side (panel one) should of course be perfectly aligned with the right hand side (panel 4).

## ■ Exception

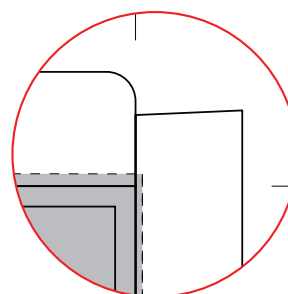
For (non-skived) cartons, a 2mm non-printed are must be allowed for (fig. 1b).



1a. overlapping for juice and 'skived' products



1b. **Exception:**  
overlapping for non-skived products

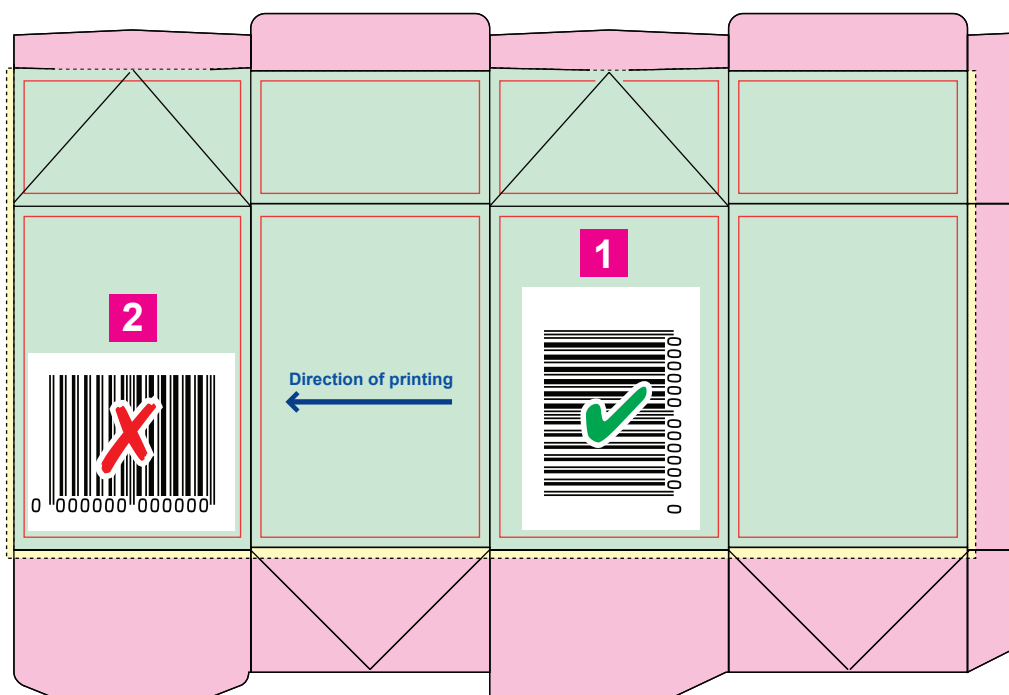


2. overlapping from 4. to 5. panel



# PURE-PAK (Gable Top)

## PURE-PAK Barcode Size and Position



■ For barcode placement, all VISY require is the relevant number. VISY will ensure that the barcode is generated according to the correct barcode specifications.

■ Barcodes must be set up in a high contrast colour. Therefore, please set up the code in black and avoid light colours and colours with a high red content as this may lead to decoding problems and should be avoided.

**1** The barcodes standard position is parallel to the print direction, In this position VISY will ensure the readability of the barcodes in the standard position. Barcode are to be created and printed in a single dark colour (1 colour) only. All printed barcodes will be checked using the same equipment as EAN.

**2** In this position VISY will not guarantee the readability of the barcodes. If artwork is received which shows that barcodes have been created and positioned contrary to VISY recommendation, a written statement will be required absolving VISY of any liability for poor or zero decode.

Standard barcode size - EAN 13		
125%	-	32.83mm x 46.61mm

Standard barcode size - EAN 8		
125%	-	28.45mm x 36.30mm



# PURE-PAK (Gable Top)

## Positive Text Specifications



Please ensure

- Positive keyline thickness (1 colour) > 0.2mm (Offset), 0.5mm (Flexo)
- Positive keyline thickness (2 colour) > 0.5mm (Offset), 1.0mm (Flexo)
- Positive text size > 7pt bold sans serif (Offset & Flexo)
- Do not use composed colours on small text. Use only one colour text

At least > 0.3mm



At least > 7pt bold sans serif

### Text Image



Recommended: The text will look sharp and clear if use vectorized text convert into path on Illustrator file.



Not recommended: The text looks blurred if use the rasterized text or Photoshop file.

### Text Line Thickness & Size

Original Data	Printing Result
量	量
量	量



Recommended: For legible text on the packaging use:  
 ■ Text line thickness: not less than 0.3mm  
 ■ Text Height: not less than 7pt



Not recommended: The text will be illegible and become broken text if use text size is smaller than recommended.

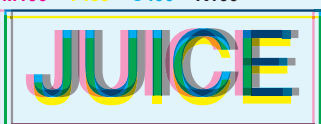
### Text Colour

One colour only



Recommended: One colour for positive text for sharp text result on the packaging.

M100 + Y100 + C100 + K100



Not recommended: The text will be blurred, if use composed colours due to print register movement.





# PURE-PAK (Gable Top)

## Negative (Reverse) Text Specifications



Please ensure

- Negative (reverse) keyline thickness (1 colour) > 0.7mm (Offset), 1.0mm (Flexo)
- Negative (reverse) keyline thickness (2 colour) > 1.0mm (Offset), 2.0mm (Flexo)
- Negative (reverse) text size > 8pt bold sans serif (Offset), 10pt bold sans serif (Flexo)
- Do not use composed colours on small text. Use only one colour text  
outline of negative (reverse) text on composed colour background is > 0.5mm.

At least > 0.7mm



At least 8pt bold sans serif (Offset)

At least 10pt bold sans serif (Flexo)

### Text line thickness & size

One ink for background colour	
Original Data	Printing Result
Type thickness $\geq$ 0.7mm Concentrated	Concentrated
Below minimum spec, type will "close-up" (fill in) Concentrated	Concentrated



Recommended: For legible text on the final packaging use:

- Text Line Thickness: not less than 0.7mm
- Text Height: not less than 8pt bold sans serif (Offset), 10pt bold sans serif (Flexo)



Not recommended: If the type is below the minimum specification, some part of text will disappear and will not be readable due to ink filling in the gaps.

### Reverse text (white text) on composed background

Three inks on background colour	
Original data	Printing result
With darkest colour outline 0.3mm around text Concentrated	Concentrated
Without the outline frame on text Concentrated	Concentrated



Recommended: Create an outline of darkest colour thickness 0.5mm around the white text for colour trapping. Otherwise, the white text will become blurred due to print register movement.



Not recommended: Without an outline thickness around the text, the white text will become blurred due to print register movement.



# PURE-PAK (Gable Top)

Vignettes, Gradations & Screen Ruling



## Quality Print (Offset) Vignettes

VISY recommend that vignettes be created with a maximum of three colours.

Vignettes to be created with a start system value of 1% and continue to 100% with in the 256 grey levels.

In pixel oriented vignettes the resolution should be 300 dpi.



## Quality Print (Offset) Screen Ruling

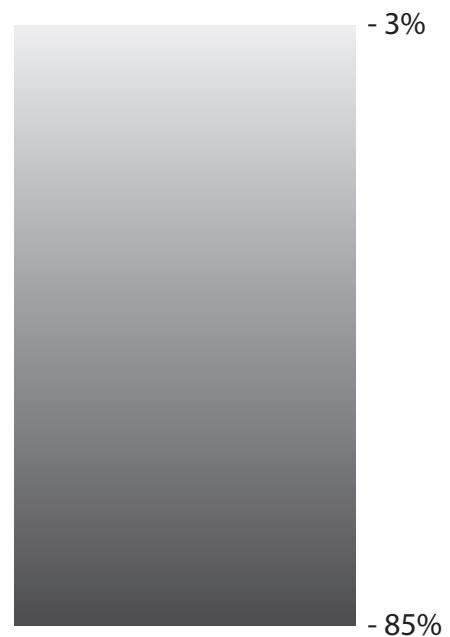
VISY Recommend Screen Ruling  
133# - 150# l/pi (48 - 60 l/cm)

## Standard Print (Flexo) Vignettes

VISY recommend that vignettes be created with a maximum of three colours.

Vignettes to be created with a start system value of 3% and continue to 85% with in the 256 grey levels.

In pixel oriented vignettes the resolution should be 300 dpi.



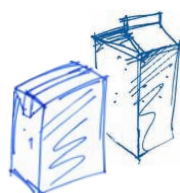
## Standard Print (Flexo) Screen Ruling

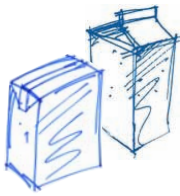
VISY Recommend Screen Ruling  
50# l/pi (20 l/cm)



# Combibloc & Pure Pak

## Artwork Recommendations





# Artwork Recommendations

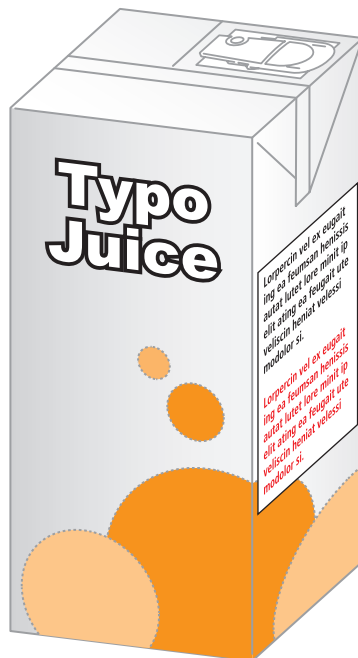
## Cost Effective Design



When creating a design, please consider that there may be revisions necessary in the future. In many cases the ingredients or the nutrition facts need to be revised after some time.

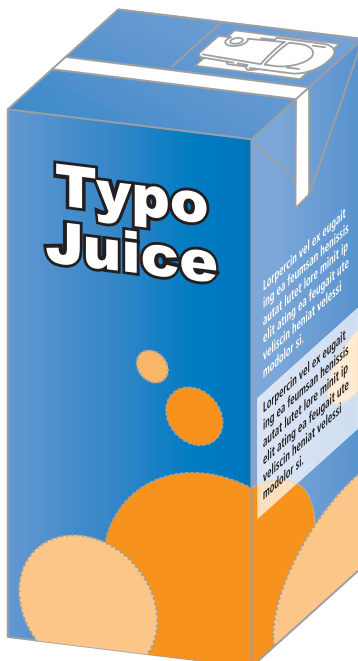
If the design is prepared with the future in mind, these text elements should be designed with “one colour” only.

Please try to avoid negative or reversed text. In case of a revision, it will make the change of at least two print plates (colours) necessary.



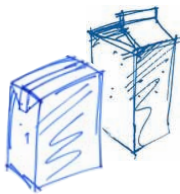
✓ **Recommended:**  
**One colour - save print plate cost.**  
Only one print plate needs to be changed in case of a text change.

✗ **Not recommended:**  
**Composed colour text - higher print plate cost**  
Two or more print plates need to be changed for each text change.



✗ **Not recommended:**  
**Negative text- higher print plate cost**  
Two or more printing plates may be required for text change.

✓ **Recommended:**  
**One colour - save print plate cost.**  
Only one print plate required for text change.



# Artwork Recommendations

## Colour Trapping / Spreading



Inherent to the VISY Offset (Litho) printing process, print register variation / movement (colours moving in opposite directions to each other) of up to 0.3mm may occur.

In order to achieve the optimum result for graphic elements which incorporate two or more colours fitting each other exactly, VISY will ensure that the correct process-specific trapping is applied where necessary.

### Type of colour trapping / spreading

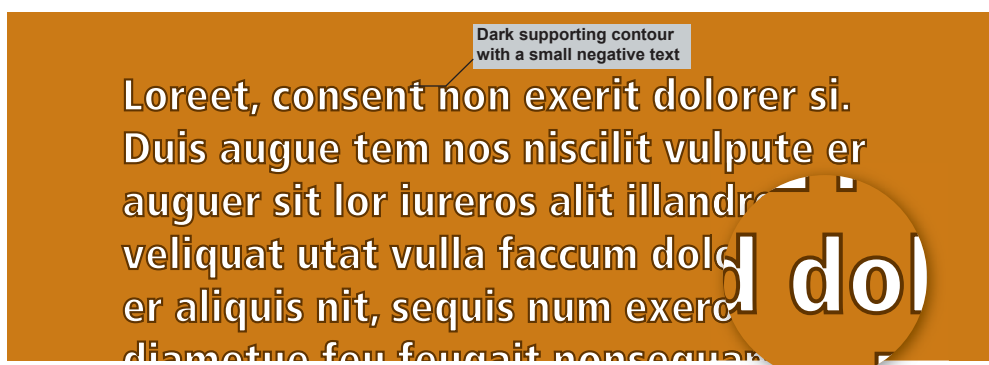
- 1 Two colour trapping (stroke): make the lighter colour a little larger (0.3mm) than the darker colour. This creates, in case with complementary colour, a dark outline which cannot be eliminated. Otherwise, we will see the white tiny line between two colours.

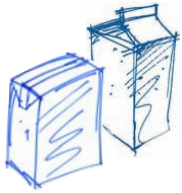


- 2 Choke-out: make lighter colour a little smaller (0.3mm) than the darker colour. Otherwise, we will see some lighter colour or dark colour on the white text or blurred text.



- 3 Contour line: create outline 0.3mm of darkest colour around the white text on composed colours. Otherwise, the white text is not sharp or clear. We will see the blurred text instead.





# Artwork Recommendations

## Colour Variance on VISY Print (Light & Dark)



During the printing process it is common for build-up, there may be colour shift or variance in different batches with background areas, logos and product colours.

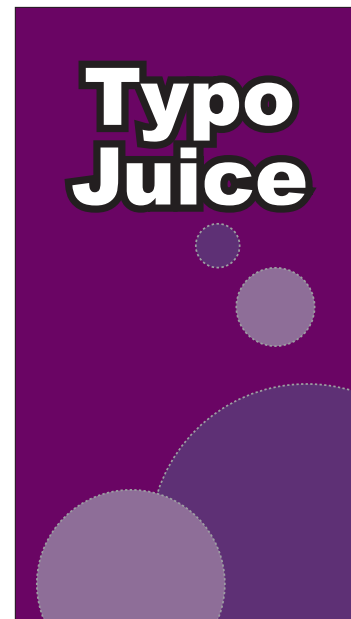
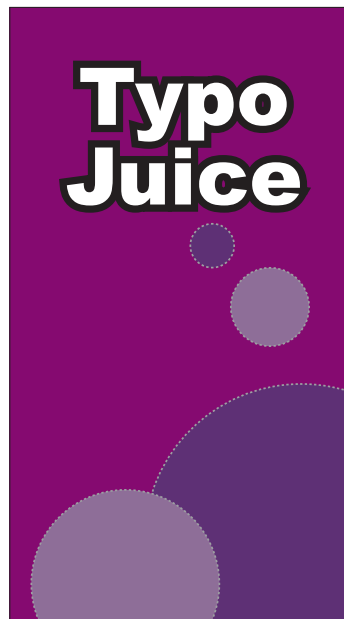
**1** The background colour is composed of 3 colours: magenta, cyan and black. The background colour can deviate during the printing process due to changes in the viscosity of the used ink.

**2** The background colour is composed of 2 colours: magenta 60% and yellow 60%. The background colour can deviated during the printing process due to changes in the viscosity of the used ink.

Light Deviation

Target

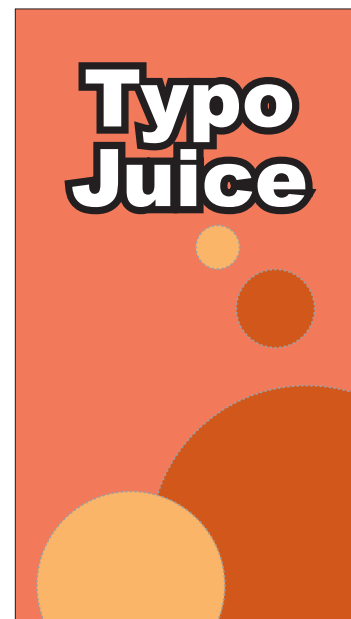
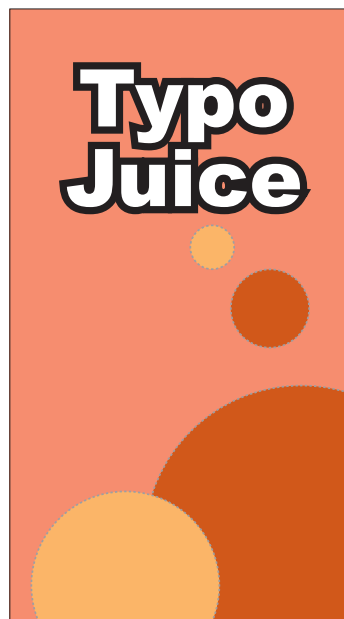
Dark Deviation



Light Deviation

Target

Dark Deviation

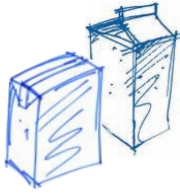


Light Deviation

Target

Dark Deviation





# Artwork Recommendations

## Information for Delivering Artwork Files



Due to the ever increasing variety and revisions of graphic software applications currently available VISY have compiled some information in order to facilitate and speed up the adaptation of your design files to the VISY Combibloc & Pure Pak printing process.

Please bear in mind that any data or materials delivered outside the recommendations listed below may incur additional time and cost penalties. If as a result of VISY being in receipt of any artwork which does not follow the VISY guidelines and subsequent corrections are required to be carried out the resultant cost will be passed on and charged directly to the customer.

Before delivering the data, please make sure that you have prepared the material and artwork file as below:

### ■ Open computer files

Certain rules have to be followed for creating and delivering the open computer files. For example, no layers must be flattened in Photoshop or Illustrator.

In other words, picture, texts and background etc — all have to be in separated layers for work efficiency.

### ■ Program and operating systems used

We can process all open computer files from standard graphics programmes using the Apple Macintosh operating system. Our preferred file formats are - Adobe Illustrator, Adobe Photoshop, Adobe Indesign and Artpro. We will accept PC formatted files only when saved for full Macintosh compatibility. Please do not use any Microsoft Office software (such as Corel Draw, Word, Excel or Power Point) for layouts.

### ■ Data/File media

We will accept files and data on any of the following media forms, files can be supplied via - CD-Rom, DVD, Email (under 5mb file size) and ftp (VISY file transfer system).

The ftp file transfer system can be accessed using the following information:

Web address - <ftp://ftp.visy.com.au>

Login - vpk\_transfers

Password - paktran06

### ■ Preferred data formats

Please make sure that all files are created and saved in the following file formats -

Logos etc - EPS (encapsulated postscript)

Images - Tiff (cmyk & multi channel), Photoshop EPS (one file), Photoshop DCS1 & DCS2 and CMYK colour space.

### ■ The completeness of data components

All data components which are linked to the document such as fonts, pictures or graphics, etc. are on the data media. All font information has to be converted to path in graphic EPS computer files. Please always supply all necessary fonts, images and data with Macintosh EPS computer files.

### ■ Picture data

We process the picture data formats TIFF, EPS, PSD and DCS. Digital picture resolution also has to be at least 300 dpi on a scale of 100% for optimum reproduction quality. Graphic elements such as logos and symbols should be set up for optimum reproduction in printing as vector graphics.

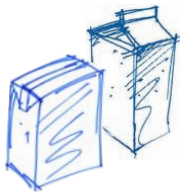
### ■ Document structure

The artwork and design must be created on the VISY supplied dielines.

### ■ Fonts

Please include all used printer and screen fonts onto the delivered media, without the fonts used VISY is not able to begin the pre press process.

VISY accept the following font types - Adobe postscript fonts Type1. Alternatively fonts can be converted to paths or outlines.



# Artwork Recommendations

## Information for Delivering Artwork Files



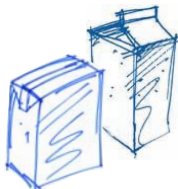
### ■ Print-out and colour specifications

Colour sample, printed sample, instruction of spot colour and other requirements are important to be attached along with the artwork file. This is the only way we can compare the computer file you supply with the expected results.

### ■ Check-list and delivering data form

VISY have prepared a check list to make work easier in order to ensure there are no unpleasant surprises. For smooth handling, the customer should also fill out the delivering data forms and forward them to us together with artwork files.

Please remember that we can only start the origination process on receipt of all data.



# Artwork Recommendations

## Check List



### ■ Print-out and colour information

A colour print-out with remarks on colours has been attached. The existing colour specifications such as labels have also been attached and labelled. Internal and logo colours are given or they are attached as patterns.

### ■ Programme and operating systems used

The computer files were created in Illustrator, Photoshop or ArtPro in the Macintosh operating systems. Please consult with VISY if other programmes than the ones mentioned above have been used to create the files. All computer files have been supplied as open data.

### ■ The completeness of data components

All linked data components of the document such as font (also used in EPS computer files), pictures and graphics, etc are on the data carrier. All font information is present or converted to outline graphic EPS computer files from the Windows environment.

### ■ Document structure

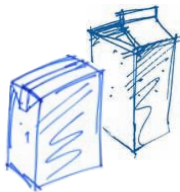
The design has been created on the VISY supplied dieline.

### ■ Colours

It only contains CMYK colours with the exception of the defined special colours. The RGB files have to be converted to CMYK. Colours not used in the document are deleted.

### ■ Picture data

The picture data correspond to the TIFF, EPS, DCS or PSD formats in the colour modes of CMYK.



# Artwork Recommendations

## Delivery Form



Please attach this sheet to your data when sending to VISA Packaging

Company Name: \_\_\_\_\_

Contact Person: \_\_\_\_\_ Phone: \_\_\_\_\_

Product Title: \_\_\_\_\_

Brand Name: \_\_\_\_\_

Computer File Name: \_\_\_\_\_

Carton Format: \_\_\_\_\_

### Data carrier

☐ CD/DVD      ☐ ftp      ☐ Email (under 5MB size)

### Programs and operating systems

☐ Illustrator    Version \_\_\_\_\_    ☐ MAC    ☐ PC

☐ Freehand    Version \_\_\_\_\_    ☐ MAC    ☐ PC

☐ InDesign    Version \_\_\_\_\_    ☐ MAC    ☐ PC

☐ Photoshop    Version \_\_\_\_\_    ☐ MAC    ☐ PC

☐ ArtPro    Version \_\_\_\_\_    ☐ MAC

### Colour standard

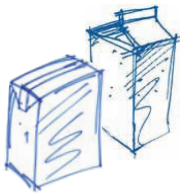
☐ Colour print-outs    ☐ Cromalin    ☐ Epson    ☐ Off-set print

☐ Digital proofs    ☐ Printed Sample

Special instructions: \_\_\_\_\_

\_\_\_\_\_  
\_\_\_\_\_

date/signature: \_\_\_\_\_



## ***combibloc / Pure Pak “Quality Print” (Cycle)***

### **Artwork for New & Revised Designs required by 1st week of Month:1**

- Artwork received after the 1st week of month one may not be ready for printing the following Month.

### **Order & Signed Proofs are required by 15th of Month:1**

- Signed proofs for New & revised Designs received after the 15th of Month:1 will not be produced in the next months production.

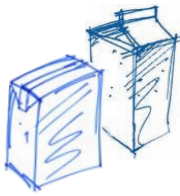
### **Sleeves available for delivery 1st week of Month:3**

Month: 1	Month: 2	Month: 3
S M T W T F S	S M T W T F S	S M T W T F S
1 2 3 4	1 2	1 2 3 4 5 6 7
5 6 7 8 9 10 11	3 4 5 6 7 8 9	8 9 10 11 12 13 14
12 13 14 15 16 17 18	10 11 12 13 14 15 16	15 16 17 18 19 20 21
19 20 21 22 23 24 25	17 18 19 20 21 22 23	21 22 23 24 25 26 27
26 27 28 29 30 31	24 25 26 27 28 29 30	28 29 30 31
<div>Artwork required 1st Week of Month:1</div>	<div>Purchase Order &amp; Signed proofs required by 15th of Month:1</div>	<div>Six Week Production Period</div> <div>Sleeves available 1st week of Month:3</div>

**For *combibloc* or Gable Top cartons artwork questions please contact -**

Charlie Pongrac  
E-mail: charlie.pongrac@visy.com.au  
Direct line: 03 9301 0310  
Facsimile: 03 9302 3537

Peter Moulas  
E-mail: peter.moulas@visy.com.au  
Direct line: 03 9301 0258  
Facsimile: 03 9302 3537



### Pure Pak (Gable Top - Cycle:1)

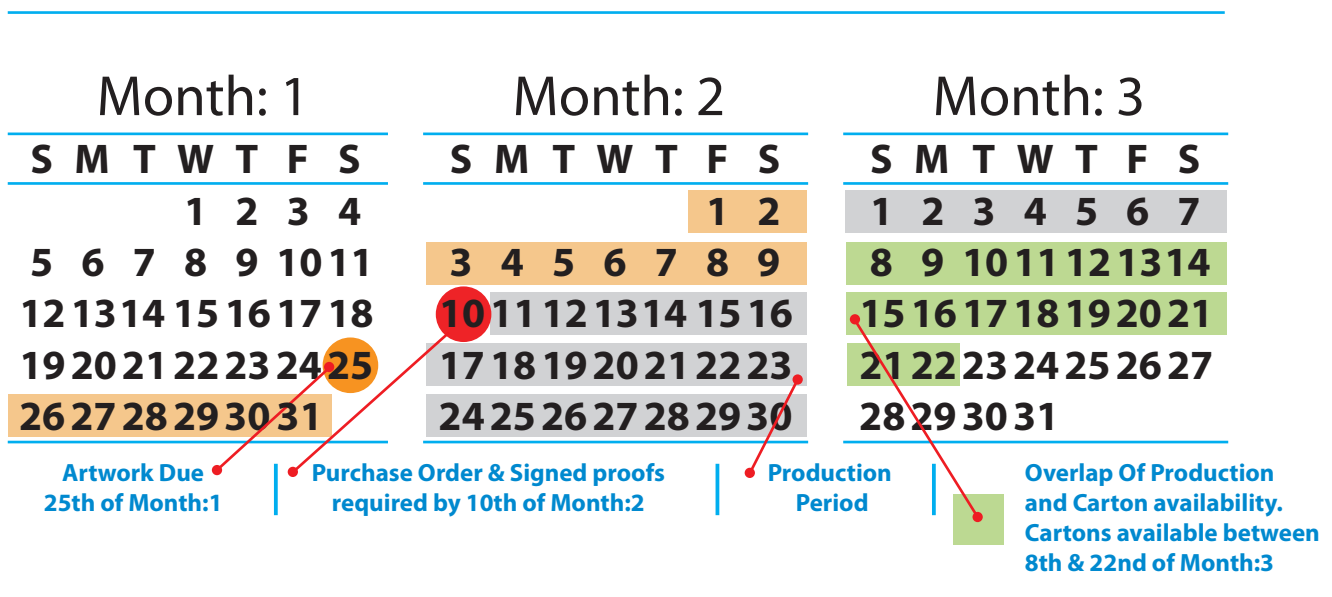
#### Artwork for New & Revised Designs required by 25th of Month:1

- Artwork received after the 25th of month one may not be ready for delivery in Month:3.

#### Order & Signed Proofs are required by 10th of Month:2

- Signed proofs for New & revised Designs received after the 10th of Month:2 will not be produced in the next months production.

#### Sleeves available for delivery between 8th & 22nd of Month:3

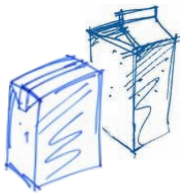


For *combibloc* or Gable Top cartons artwork questions please contact -

Charlie Pongrac  
E-mail: [charlie.pongrac@visy.com.au](mailto:charlie.pongrac@visy.com.au)  
Direct line: 03 9301 0310  
Facsimile: 03 9302 3537

Peter Moulas  
E-mail: [peter.moulas@visy.com.au](mailto:peter.moulas@visy.com.au)  
Direct line: 03 9301 0258  
Facsimile: 03 9302 3537





### Pure Pak (Gable Top - Cycle:2)

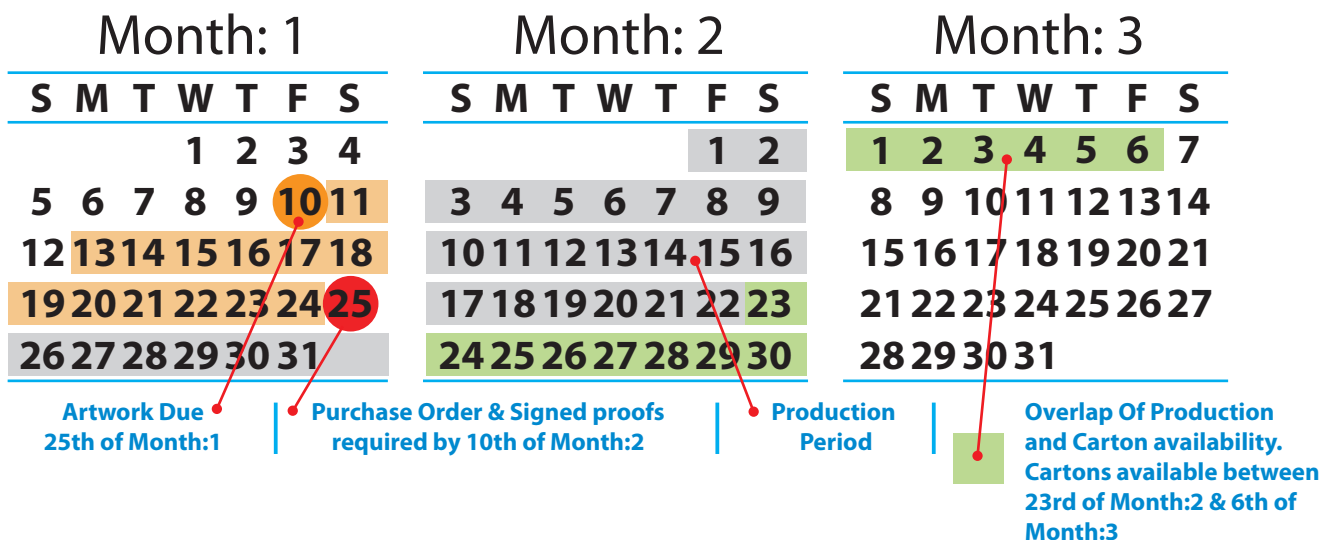
#### Artwork for New & Revised Designs required by 10th of Month:1

- Artwork received after the 25th of month one may not be ready for delivery in Month:2 & 3.

#### Order & Signed Proofs are required by 25th of Month:1

- Signed proofs for New & revised Designs received after the 25th of Month:1 will not be produced in the next months production.

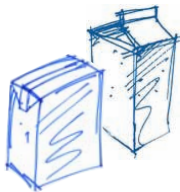
Sleeves available for delivery between 23rd of Month:2 & 6th of Month:3



For *combibloc* or Gable Top cartons artwork questions please contact -

Charlie Pongrac  
E-mail: [charlie.pongrac@visy.com.au](mailto:charlie.pongrac@visy.com.au)  
Direct line: 03 9301 0310  
Facsimile: 03 9302 3537

Peter Moulas  
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Direct line: 03 9301 0258  
Facsimile: 03 9302 3537



# Press Approvals

## Customer Information



### This document must be read before arriving at VISY

VISY strongly recommend that customers attend all press approvals.

VISY allows Customers/Visitors to be in the vicinity of the printing press and work directly with the printing supervisor. As VISY have a very strict Workplace Occupational Health & Safety policy. VISY requires all visitors to adhere to the Occupational Health & Safety policy at all times when visiting our site.

All visitors must wear the following attire to be granted permission to enter the manufacturing areas. The customer must wear Safety Footwear, preferably Leather, **no runners or sandals**. The customer will also be provided by VISY with a Safety Vest, Ear Plugs and Hair Net that must be worn at all times when visiting any of the manufacturing areas.

All visitors must use the “**Green**” painted walkways at all times unless supervised by a VISY employee. Only visitors wearing safety footwear will be able to leave the “**Green**” painted walkways.



Safety Footwear



Safety Vest



Hair Net



Ear Plugs

#### ■ Before Going to the Press

Customers will be provided with a brief rundown on our printing process, including an explanation of our light and dark printing standards.

#### ■ At the Press

The VISY proof standard is a digital Kodak Approval XP4 proof on our substrate and provides a colour target only for our printers. As with all industrial process certain deviations will occur at the press and the print will not be exactly as the proof provided.

Please be aware that our press's can get as much as .3mm movement from colour to colour. Colours will be printed as specified and only minor variations will be permitted during the press approval.

If VISY is to match corporate colours, special colour or printed samples, colour samples and information must be supplied with the original artwork supplied to VISY.

**Please Note:** VISY will endeavour to match the Kodak proof as close as possible.

#### ■ VISY Factory Address

Maldon Street Broadmeadows, Melb, Vic 3047  
(15 minutes from airport)

All visitors must be accompanied by a VISY employee

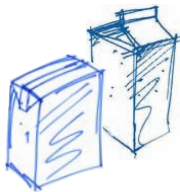
To obtain entry into office area please call:

254 - Reception

202 - Kevin McConchie

310 - Charlie Pongrac

258 - Peter Moulas



# Press Approvals

## Customer Non Attendance form



**This document must be read and completed by  
Non Attending customer prior to the press approval.**

Dear .....

Since you have advised that neither, you or a nominated representative will be attending the press approval of ..... VISY requires a written response to this email that authorises VISY to approve the ..... design(s) in your absence.

As there is a certain degree of subjectiveness to any press approval you need to be aware of and agree to VISY's policy for press approvals without customer representation before we can proceed with your job:

1. VISY will endeavour to achieve the best possible result based on any instructions you provide prior to the press approval.
2. VISY will create colour guides and send a copy to you after the print run. You will receive your own copy of the colour guide VISY will use its copy for all future print runs. Light and Dark examples will be supplied as well. Please note: light and dark samples **ARE NOT** light and dark standards. They are merely a representation of the natural print variation experienced during a print run.
3. VISY will not accept any unreasonable sleeve rejections regarding end result of the press approval that are rejected due to a design compromise that was made during the press approval process. This also includes subjective criteria like customer artistic expectations of the design such as the "look" or "feel" of it. Clearly, Note: if VISY has supplied product that is of inferior quality, e.g.: missing print, poor registration, acceptance of sleeves will fall under normal quality assurance practices.
4. After the first print run, should you wish to make minor adjustments, please feel free to advise us on those changes. If they are achievable VISY will ensure they are carried out in the next print run and you will be required to attend this Press Approval.
5. If the result achieved is not to your satisfaction and is deemed to fall under an unreasonable rejection as highlighted in point 3, VISY will organise for a second press approval on the next print run that you will be required to attend. Sleeves already supplied will not be credited.

If you still wish for VISY to approve ..... on your behalf please copy the statement and send (via email) the statement below:

(Please Print Name)

I ..... have read and agree to adhere to VISY's policy for customer approvals without customer representation and therefore authorise a VISY Beverage representative to approve ..... on my behalf.

(Job Name)