



**SANNER**

Protecting Health.



## Sanner – In-Mould-Labeling-Printing (IML)

Guide to process reliability in the IML process



# Sanner – In-Mould-Labeling-Printing (IML)

## What is IML?

In addition to the classic offset printing process, we also offer what is known as in-mould labelling.

In-mould labeling offers additional options that cannot be realized with letterset printing.

Unlike offset printing, this type of decorati-

on is not a classic direct printing onto the tube.

Here we work with pre-printed labels in your design, which are inserted directly into the injection mold.

When the plastic is injected into the mould, the labels are directly connected to the

plastic and form an inseparable unit.

We currently offer the IML process for 2 tubes: 143.5mm and 165mm in length for tablets with a diameter of 25mm.

Other tubes on request.

## 1. General

### Current tube formats

T-IML 165 (Länge 165mm)

T-IML 143 (Länge 143,5mm)

### Printing

Bogenoffset  
max. 8-colorway + Paint

### Colors

Standard: max. 8 colors

Metallic IML foil:  
max. 6 colors + foil

### Paints

Gloss paint, high-gloss, matt,  
special finish metallic IML foil

## 2. Guidelines for creating the print data

The customer is responsible for the correct, print-ready data delivery in accordance with the points below. In particular, when checking the GzD PDFs (OK for printing PDF) specially prepared for this purpose and, if requested, the associated color proofs (GMGs), the customer checks for correctness as a final check.

### General review

format / lay-out

Correctly used tube drawing including compliance with the safety zones specified therein

colourfulness

Texts (e.g. spelling) legibility  
(e.g. minimum font size) EAN code

### Permissible formats for print data delivery

Esko AE 20.1.0 (also ArtPro files)

Adobe CC Cloud 2021 (Photoshop, Illustrator, In-Design)

Neo 10.1.2

Print-ready data in PDF X-4

*Caution: for security reasons, no Excel and/or Word files will be accepted. (Please convert to PDF)*

### Colours

We recommend creating the designs in CMYK. This is cheaper and can be combined as desired on the printed sheet. In addition, please note:

Standard: max. 8 color  
(CMYK + 4 other Pantone colors)

Metallic IML film:  
max. 6 colors + foil

Max. ink coverage: maximum 270%.

### Data / print design preparation

Please always supply the data in accordance with the guidelines specified here in the document in order to ensure process and printing security.

Please use current tube drawings to create the print design. These will be sent to you by Sanner.

### Acceptable formats for images

PSD in CMYK model Photoshop DCS

Tiff EPS

JPG/JPEG

*Warning: image resolution: 300 dpi at 100%*

### Text size

Positive/negative single color 6pt

Positive/negative multicolor 7pt

### Lines

Single color positive/negative 0.15 mm

Multicolored positive/negative 0.25 mm

### Specifications for EAN & barcode

EAN / UPC code From SC 0: all of the following points contribute to the perfect legibility of the code:

Min height 82%

Create high contrast between EAN and background

Ideally create in black or dark color

„Bright Zone“ - Consider at least 3 mm when creating the print image for the code

Deliver code as a separate file and not embedded in the print image

Do not scale codes after creation

Ideally place the code perpendicular to the print direction

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## 3. Data transfer

If you have observed all the points listed above and now want to transmit the data to Sanner, please do so:

By email (to your contact person)

By download link (WeTransfer)

## 4. Print Approval Process

### Step 1

The customer requests the corresponding punch template for creating the print data from Sanner or your Sanner contact person provides it to you.

### Step 2

The customer delivers the print data to Sanner in accordance with the above guidelines.

### Step 3

The customer receives a release PDF („OK for printing“ PDF) for checking and approval.

### Step 4

The customer confirms the print approval by email with a scanned print image with signature and date to Sanner.

### Step 4.2

If a colour-binding proof (GMG) was requested, this must be approved by the customer after it has been sent by Sanner, scanned, signed and dated and sent back to Sanner by e-mail.

## Safety Zones

In contrast to letterset printing, IML cannot technically allow labels to overlap on the tube. Instead, there is a narrow, minor label gap (tube shines through). Please note this already in the layout. Do not use designs where the layout was created for an overlap or requires this effect.

### No-Text Zone

Please do not place important elements in the no-text zone. Please note that the plug will also cover all of the top elements in this area.

### Bleed

The bleed refers to the edge that protrudes beyond the final format of the printed matter and is removed by the die-cutting machine during further processing.

Without the added bleed, white flashes of the film can remain at the edge after punching. To avoid this, all elements that reach the edge of the final format (cutting contour) should protrude beyond it and also fill in the bleed.

### Punching Contour

Visualizes the punching contour which punches the label out of the foil sheet.

In particular, with suitable software, you can clearly visualize the different security zones on the label on this page. Please note that this PDF guide has been compressed, so various elements are not in print quality.



3 mm Distance to tube bottom

# Sanner Printing Team

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If you have any questions or ambiguities,  
do not hesitate to contact one of our printing team.



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This guide and the recommendations given in no way replace  
the advice and control or processing by an expert.

The information does not claim to be complete.

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