SANNER

Protecting Health.

IN-MOLD

In-Mold Labeling (IML)

Printing Guide



Guide to process reliability in the IML process

What is IML?

In addition to the classic offset printing process, we also offer **in-mold labeling**. It opens up design options that cannot be realized with letterset printing.

Unlike offset printing, IML is not direct printing onto the tube. We work with **pre-printed labels in your design**, which are inserted directly into the injection mold.

When the plastic is injected, the label bonds with it and forms an **inseparable unit** – impact- and scratch-resistant.

IML is currently available for two tubes of **143.5 mm and 165 mm** length, for tablets with a diameter of 25 mm. Other tubes on request.

01 General

Parameter	Specification
Tube formats	T-IML 165 (length 165 mm) · T-IML 143 (length 143.5 mm)
Printing process	Sheet-fed offset, max. 8-coloreway & paint
Colors – standard	Max. 8 colors
Colors – metallic IML foil	Max. 6 colors + foil
Varnish / finish	Gloss paint, high-gloss, matt, special finish metallic IML foil

02 Guidelines for creating 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

- Correctly used tube drawing including compliance with the safety zones specified therein
- Format / layout and colorfulness
- Texts: spelling and legibility (minimum font size)
- EAN code

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.

Colors

We recommend designing in **CMYK** – more cost-efficient and freely combinable on the printed sheet.

- Standard: max. 8 colors (CMYK + 4 other Pantone colors)
- Metallic IML foil: max. 6 colors + foil
- Max. ink coverage: 270 %

Minimum text sizes & line widths

Text:
- Positive/negative single color – 6 pt
- Positive/negative multicolor – 7 pt

Lines:
- Single color positive/negative – 0.15 mm
- Multicolored positive/negative – 0.25 mm

Accepted print data formats

- Esko AE 20.1.0 (incl. ArtPro files)
- Adobe CC 2021 (Photoshop, Illustrator, InDesign)
- Neo 10.1.2
- Print-ready PDF/X-4

No Excel or Word files for security reasons – please convert to PDF.

Accepted image formats

- PSD in CMYK mode
- Photoshop DCS
- TIFF, EPS
- JPG / JPEG

Image resolution: 300 dpi at 100 %

EAN / UPC & barcode

EAN/UPC code from SC0 – **The following points all contribute to perfect legibility of the code:**

- Minimum height 82 % (from SC 0)
- High contrast to background – ideally black or a dark color
- „Bright Zone“ – Consider at least 3 mm when creating the print image for the code
- Deliver code as a separate file, not embedded in the print image
- Do not scale after creation; ideally place perpendicular to print
- direction

03 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.





3 mm distance to tube bottom

No-text zone

Do not place important elements here. The plug will also cover all top elements in this area.

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 that punches the label out of the foil sheet.

Tip: Suitable software clearly visualizes the individual security zones on the tube label drawing. Illustrations in this PDF guide are compressed and not in print quality.

04 Data transfer

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

By e-mail to your Sanner contact person

By download link e.g. WeTransfer

05 Print approval process

1 **Request**
The customer requests the corresponding punch template from Sanner for creating the print data, or your Sanner contact person provides it.

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

3 **Review**
The customer receives a release PDF ("OK for printing" PDF) to check and approve.

4 **Approve**
The customer confirms print approval via email by sending a scanned print image with a signature and date to Sanner.

4.2 **Proof (optional)**
If a color-binding proof (GMG) was requested, the customer must approve it after receiving it from Sanner. The customer must scan, sign, and date the proof and send it back to Sanner by email.

Sanner Printing Team

Questions or ambiguities? Our printing team is happy to help!



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