

## Technical specifications For CD and DVD manufacture

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# 1. Formats accepted as Master and Premaster

This section lists the types of formats accepted as Master and Premaster.

	DVD	Video (Betacam) Audio (DA88)...	
	CD-CARD	Any back-up system	With a maximum capacity of 32 Mb or 3,5 minutes
Master	CD-DA	CD-R	Quality control analysis will be performed
		8 mm. exabyte format	DDP code (format identifier) is required
		U-Matic	PQ codes are required
	CD-ROM CD-ROM/XA	8 mm. exabyte format	DDP code (format identifier is essential)
	CD-I CD-DIG.VIDEO	CD-R	Quality control analysis will be performed
	DVD-9, DVD-5, DVD-10	DLT	DDP 2.0 Format

## COMMENTS:

CD-R, when used as premaster, should comply with the following requirements:

- Reading surface (lower face) should be free from all types of mark, fingerprints, scratches and dust, etc.
- Time between recording and delivery to the factory should be as short as possible.
- The disk should be kept away from any heat sources.
- All CD-R will be analysed before using them as premaster in order to ensure that they are free from non-correctable errors (C2 o E32).
- The use of high quality support is recommended.
- We recommend you to record the Master at 1x.
- Please, do not forget closing session before burning the CD-R.

## 2. Screen printing specifications

Silk-screening	Offset
The film (photolith)	
<ul style="list-style-type: none"> <li>• Film in positive.</li> <li>• With registration marks and indications of each colour.</li> <li>• Reading straight.</li> <li>• Emulsion upward.</li> </ul>	<ul style="list-style-type: none"> <li>• Film in positive.</li> <li>• With registration marks and indications of each colour.</li> <li>• Reading straight.</li> <li>• Emulsion downward.</li> </ul>
Sizes	
<ul style="list-style-type: none"> <li>• The maximum size of the printing area is specified in silk-screening for CD, DVD-5, DVD-9 and DVD-10.</li> <li>• Any dimension included within the specified printing area will be considered correct.</li> </ul>	<ul style="list-style-type: none"> <li>• The size of the printing area is specified in Offset for CD, DVD-5 and DVD-9.</li> </ul>
Colours	
<ul style="list-style-type: none"> <li>• A film for each colour is required with a maximum of five colours (including the white).</li> <li>• If a white background is required, the film of the appropriate size must be supplied.</li> <li>• We can use any standard colour from the PANTONE range or four-colour reproduction colours.</li> <li>• Attach a colour test to monitor the printing, of cromalin, match-print type, etc. For tasks in four-colour reproduction and printer type for colours from the PANTONE range, taking into account that in the end, the PANTONE reference chart will prevail.</li> </ul>	<ul style="list-style-type: none"> <li>• A film in positive for each colour is required</li> <li>• Printing will always be done in four colour reproduction plus a fifth colour (optional) meant for corporate colours (PANTONE range) plus a white background and varnish (optional).</li> <li>• It is not necessary to submit the photolith of the white background</li> <li>• It is very important that the dimensions of the image to be printed adapt to the dimensions of the CD, DVD-5 and DVD-9.</li> <li>• Attach the colour test (cromalin or match-print type, etc.) for monitoring the printing. The colour test is a reference guide for monitoring and checking the printing. It is possible that minimum changes in tone, contrast and shine will appear in the printing. This is primarily due to printing on a support that is not shiny paper (as in the colour test) and to other production variables such as: the speed of the machine, temperature, pressure, etc.</li> </ul>

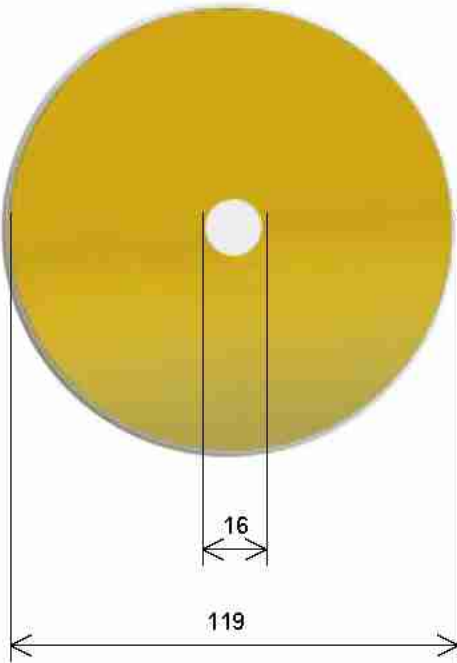
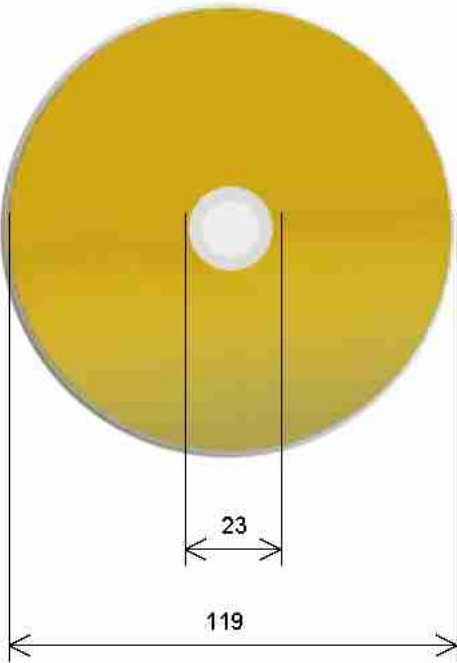
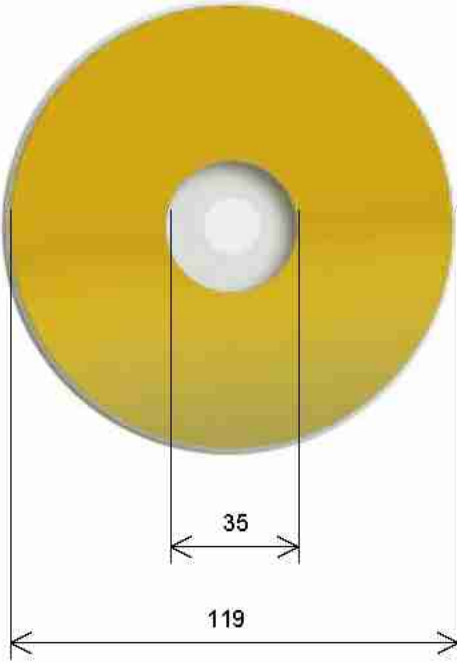
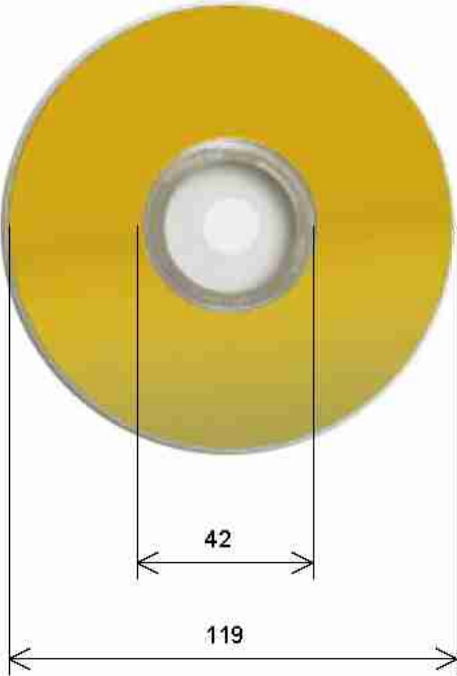
## Rasters

Shown below are the most commonly used rasters:

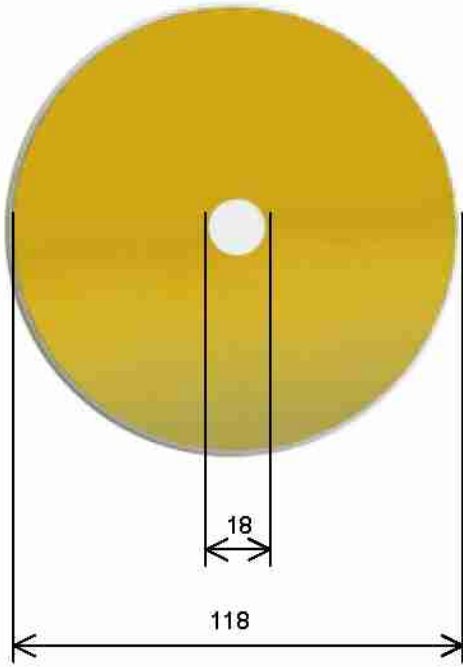
Lines/cm	Lines/inch
54	133
40	100
34	85
30	75
28	70

- The maximum is 54 lines/cm. 133 (lines/inch)
  - A higher number of lines/cm. causes faults in the reproduction and encourages the "moiré" effect due to the raster interfering with the weaving threads of the screen.
  - In the case of wishing to work with half tones in two or more colours, their inclination has to be separated by 30°.
  - For four-colour reproduction, the correct angle of the raster would be as follows:  
**YELLOW -0° / MAGENTA-45° / CYAN-75° / BLACK-15°.**
  - In flat rasters and medium tones, a density of between 20% and 80% is recommended Below around 20% means lack of colour. Above 80% means total fill.
- Conventional wefts, 70 lines/cm (175 lines/inch).
  - The point can be elliptical or circular. The elliptical point is recommended.
  - The raster angles are the usual ones for offset printing on paper.

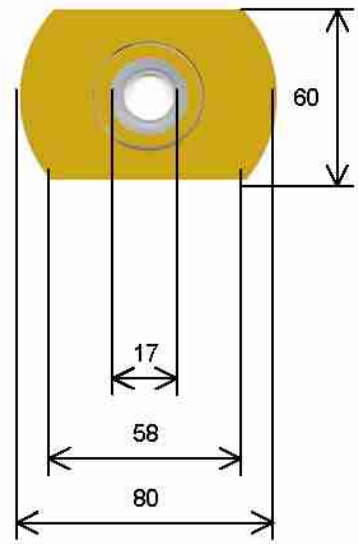
**Offset:**



### Silk-screening:



### Cd-card:

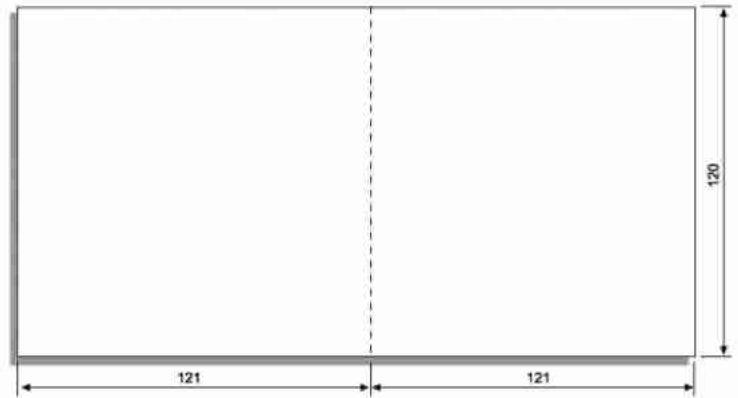


### 3. CD booklet specifications

The following should be taken into account when designing your booklet:

#### PAPER SPECIFICATIONS:

- The maximum thickness of the booklet should be 1,8 mm measured on the fold-out side.
- The maximum thickness of the fold should be 2,3 mm.
- The paper weight should lie between 140 and 180 g/square metre.
- The maximum paper thickness should lie between 0,15 mm and 0,16, once printed.
- These specifications are valid for the "Jewel Box", "Brillant Box" and "Multi Box" cases.

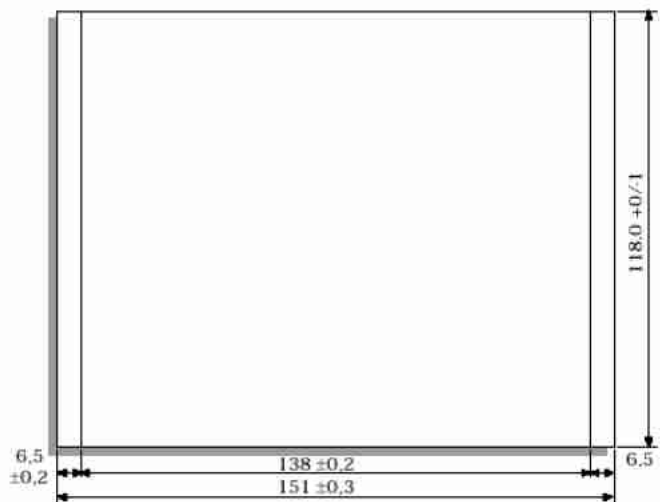


Booklet cover  
Units in millimetres

### 4. CD inlay specifications

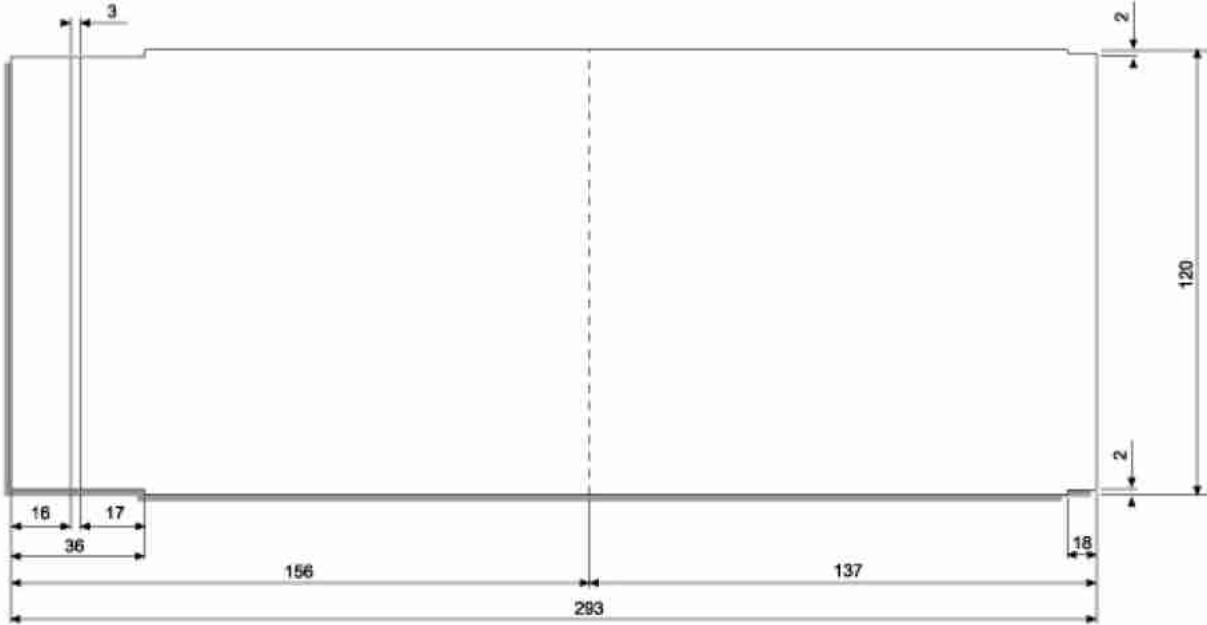
#### SPECIFICATIONS:

- These specifications are valid for the "Jewel Box", "Brillant Box" and "Multi Box" cases.
- The paper weight should lie between 140 and 180 g/square metre.
- The maximum paper thickness should lie between 0,15 mm and 0,16 mm, once printed.



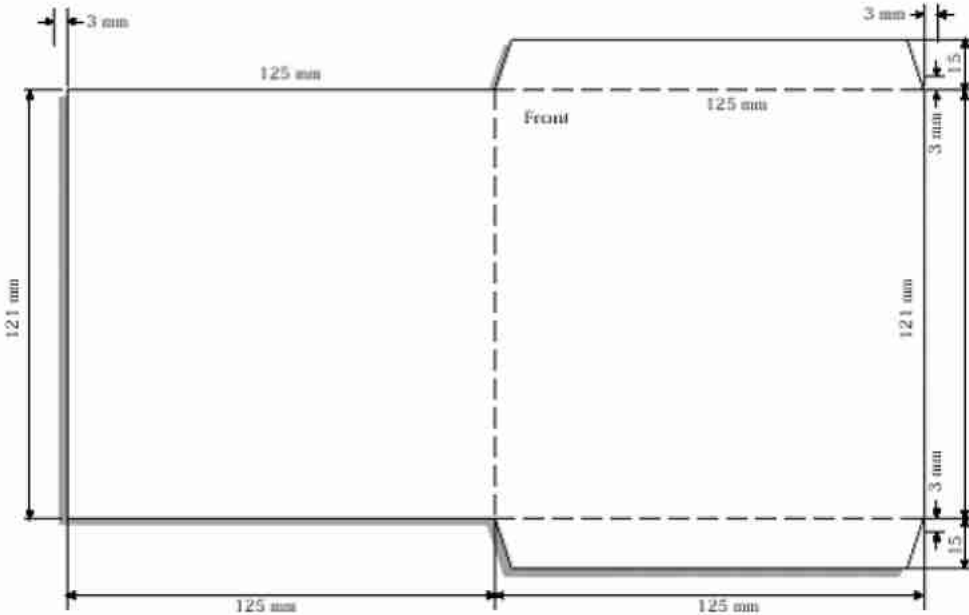
Inlay  
Units in millimetres

### 5. 2-pieces inlay specifications.



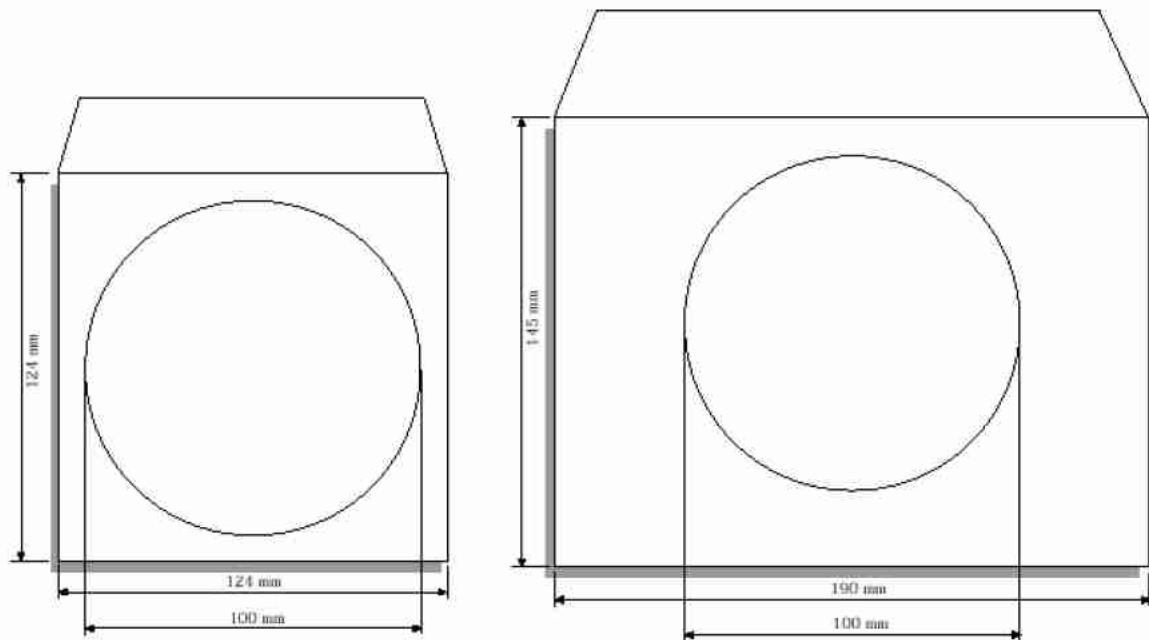
Units in millimetres

### 6. Carton Sleeve specifications

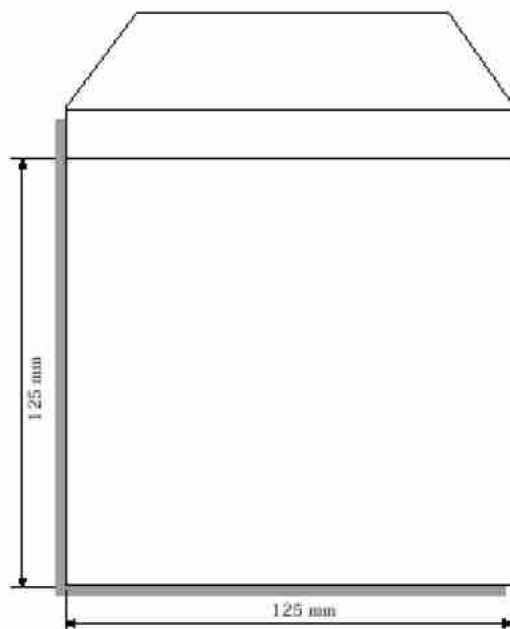




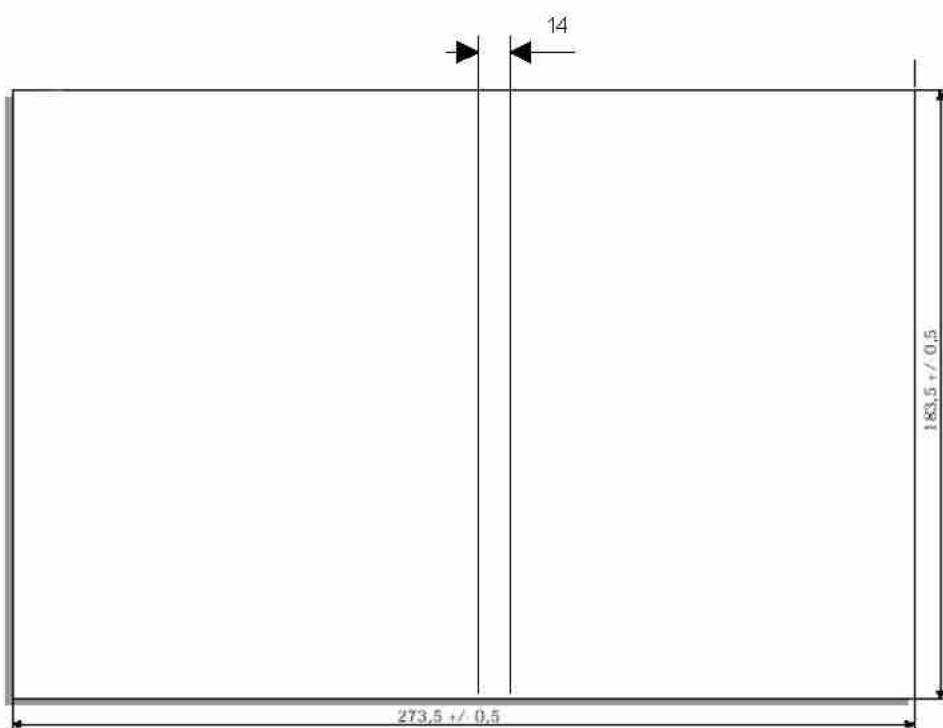
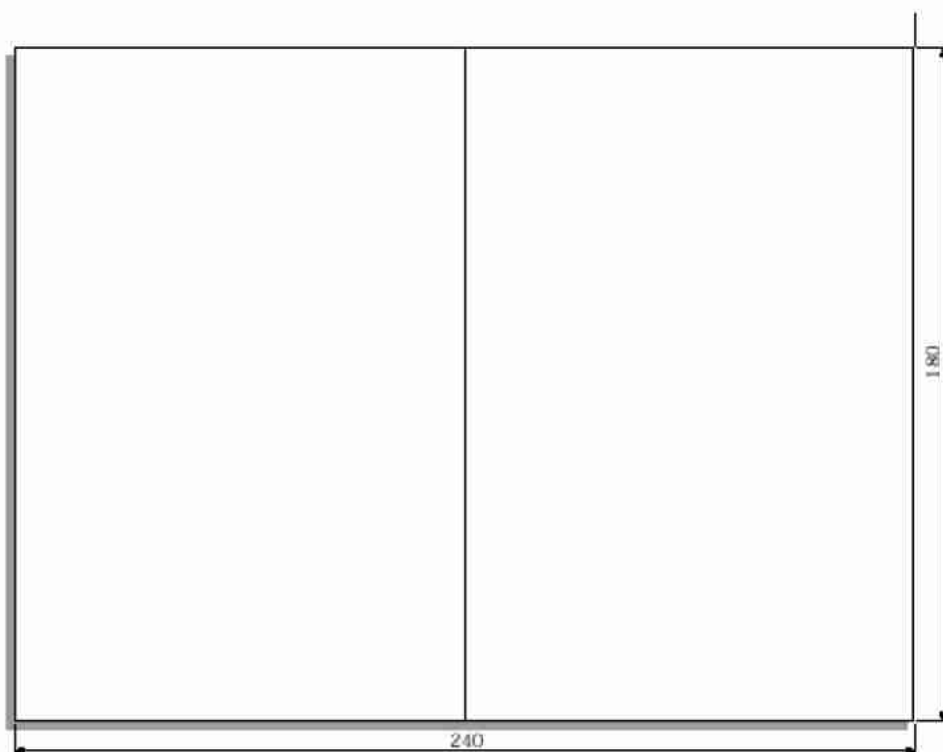
## 7. Paper envelop with self-adhesive flap and plastic window specifications



## 8. Plastic bag with flap specifications



## 9. DVD booklet and inlay specifications



## 10. CD and DVD logotypes.

We recommend that the CD-DA, CD-ROM and their derivatives appear on each CD in accordance with the following specifications.

- The logos should be clearly seen on the CD
- The logo should have maximum contrast against the background
- Under no circumstances should the contrast between the logo and the background be less than 50%



## 11. Anticopy systems.

DVD: CSS



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