

Processing Guide

▶ Printing on DuraJet™ Open Pored Aluminum

- ◆ Set up your printer and print file using the instructions provided by your printer's manufacturer
- ◆ When using a Direct Color Systems printer, visit <http://www.horizonsISG.com/DuraJet> to download and save the DuraJet™ print modes
 - ◆ In the Mfr supplied RIP software, click on **Printers** menu and select **Manage Print Modes...** Click the **Import Print Mode Package** icon and select a downloaded print mode to import. This only needs to be done once for each mode

- ◆ To print, remove from sealed pouch
 - ◆ The printable surface has an even finish (anodized side). The unprintable surface produces a rainbow effect when held under light at an angle; print on the anodized side
- ◆ Aluminum sheets should be flat on the print bed. Apply graphic art tape or other non-aggressive adhesive tape if necessary. Do not use any tacky hold-down mats. These may adhere to DuraJet™

DuraJet Print Profile	Recommended Images	%Ink Laydown	Production Time (one 12x20 sheet)
Ultra High-Resolution Mode	Solid color printing & small font/fine-line detail; may oversaturate photographs	High	~30 minutes
High-Resolution Mode	Satisfactory for most jobs; best Mode for photographic reproductions	Medium	~20 minutes
Normal Mode	For images with large text or where production time is critical; also for adding spot color to Metalphoto	Low	~10 minutes
High-Speed Mode	Lowest resolution mode; add spot color to Metalphoto or solid color printing	Low	~2 minutes

- ◆ Use the DuraJet Print Modes listed above based on your printing application
 - ◆ If bleeding or running of the ink occurs before sealing, adding dry time between passes or lowering the print head assembly should alleviate the problem. If noticed after sealing, check for proper temperature of the bath, and that the ink is dry before sealing
- ◆ When using other dye-based solvent printers, print speeds and times will vary

from DuraJet™ print modes. Print modes from other manufacturers have not been tested with DuraJet™ for optimal performance

▶ Adding Color to Metalphoto®

- ◆ Image, develop and rinse the Metalphoto® plate but do not seal
- ◆ Register the plate on the printer and print using a print mode as previously described, then seal and rinse

- 💧 See *Printing on Metalphoto*[®] guide for detailed instructions

▶ Sealing DuraJet™

- ◆ To prepare sealing bath, mix 1 part Sealing Concentrate with 24 parts distilled or de-ionized water in a 10X12 or 12X20 Sealing Tank
 - 💧 Do not use tap water for solution as it contains minerals which interfere with the sealing process
- ◆ Heat the solution to a rolling boil. Using stainless steel clips and rods, immerse a dry DuraJet™ or Metalphoto[®] plate for 15 minutes in the solution, maintaining a rolling boil and cover
 - 💧 If adding color to a Metalphoto[®] plate, rinse the plate after developing using cool tap water and hang to let dry, or dry with a heat gun before immersing in boiling solution or printing on
- ◆ Remove the plates after sealing, and rinse using cool tap water. Hang the plates to dry or dry with a heat gun. The plates are now sealed
- ◆ If desired, sealed plates may be polished to add a sheen or attractive luster to any signage where aesthetics are most important. To polish, pour a small amount of Metalphoto[®] Polish to a clean soft rag and let dry to a white film, then buff with a clean soft rag

▶ How to Order

- ◆ Call 1-800-482-7758 or visit our website at HorizonsISG.com

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▶ Replenishing Sealing Baths

- ◆ The volume of the sealing bath decreases due to evaporation as it boils. Replenish the volume with distilled or de-ionized water to restore the bath to the proper level
 - 💧 Do not add tap water or sealing concentrate to replenish the sealing bath
- ◆ The sealing bath will normally last for 1 to 2 weeks of use. How long the sealing bath lasts should depend on the number of plates actually sealed. One gallon of working strength (1:24) sealing solution will seal 30-10X12 plates or 15-12X20 plates assuming no contamination
- ◆ The solution from the sealing bath is environmentally-friendly, and requires no special disposal method when mixing a new bath

▶ Handling

- ◆ When handling a DuraJet™ plate, avoid touching the print surface until after it has been sealed. The unsealed plate will permanently accept fingerprints, dirt and other contaminants. Handle by the sides of the plate

▶ Storage

- ◆ DuraJet™ has a shelf life of at least 5 years when left in its sealed package at room temperature (70°F) and relative humidity of 50%

