

Required treatment levels:

The following chart offers general guidelines regarding the required surface treatment levels (as measured by the Dyne test) for various process/material combinations. Please note it is critical that you determine the appropriate specification for each job, based on actual empirical results from functional finished product testing. The ranges shown here can be used to expedite surface analysis by suggesting a reasonable range within which to test.

All data in mN/m	Printing Process												Other Process					
	Flexo & Gravure			Litho			Offset/ Letterpress			Screen / Pad			Laminating ⁽⁶⁾			Coating		
Coating Type:	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV
PE ⁽²⁾	38 44	36 40	38 50	40 46	37 42	40 50	40 46	37 42	42 54	42 48	38 44	44 60	42 50	38 44	42 54	42 48	38 45	44 54

IMPORTANT: this chart is for general guidance only.

In most cases, jobs can be run if the substrate at run-time is somewhere between the low and high Dyne levels indicated. For demanding runs (e.g., high web speeds and/or critical quality process work), it is safest to aim for the top of the range shown. This data is based on corona treatment in an oxygen containing atmosphere e.g. air.

FOR A LIST OF RECOMMENDED TREATMENT LEVELS FOR A WIDE RANGE OF OTHER MATERIALS PLEASE LOG ON TO OUR MEMBERS AREA.