

	PRINTING PROCESS												OTHER PROCESSES					
	All Data in dynes/cm																	
PROCESS	Flexo and Gravure			Litho/Ink Jet			Offset/Letterpress			Screen and Pad			Laminating			Coating		
Coating Type	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV
Substrate 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
Substrate PP(3)	38-44	36-40	40-50	40-46	38-42	40-50	40-46	37-42	40-54	42-48	38-44	44-60	42-50	38-44	42-54	42-48	38-45	44-54
Substrate PVC(4)	38-44	36-40	36-50	40-45	37-42	36-52	40-45	38-42	40-52	42-48	38-44	42-60	42-50	38-44	42-54	40-48	38-45	42-54
Substrate PET(5)	44-52	40-46	42-54	46-56	42-46	44-56	46-56	42-46	46-60	48-60	42-48	44-62	46-60	42-48	44-62	42-52	42-48	46-60
Substrate PS	38-44	35-40	42-48	40-45	37-42	42-50	40-46	38-44	42-58	42-48	38-44	42-56	42-52	37-44	42-54	42-50	38-46	44-54
Substrate PVDC	40-46	38-42	42-52	42-46	40-42	42-52	42-48	38-44	42-54	42-50	40-45	42-58	42-50	38-44	44-52	42-48	40-46	44-54
Substrate PU	40-46	38-42	38-50	40-46	38-42	38-52	40-45	38-44	42-56	42-50	38-44	42-58	42-50	38-44	42-56	42-48	38-46	44-54
Substrate ABS	42-46	40-44	40-52	42-46	40-45	42-52	42-48	38-46	45-52	42-48	40-45	46-56	42-52	40-15	42-56	42-48	38-46	44-54
Substrate PTFE	40-44	34-39	36-52	40-50	35-40	38-52	40-48	38-44	42-60	42-52	38-46	42-60	42-56	38-46	42-56	42-50	40-48	42-54
Substrate Silicone	40-44	35-40	40-50	40-45	38-42	38-52	40-48	38-44	40-56	42-50	38-46	42-60	42-56	38-46	42-56	42-50	40-48	42-54
NOTES																		

PDC Ltd acknowledges data supplied by Russ Smith CEO Accudyne.

Comments to chart;

- (1) Some values theoretical.
- (2) Any density, any type, including films, coated board, and molded products.
- (3) All types, cast or molded.
- (4) More plasticizer generally requires levels at the high end of these ranges.
- (5) Uncoated.
- (6) For heat sealing, the surface energies of the mating PE surfaces should match closely; if both faces are treated, heat sealing can usually be accomplished over a broader and lower temperature range.

In most cases jobs can be run if the substrate at run-time is somewhere between the low and high dyne levels cited.

For demanding runs (high web speeds and/or critical quality process work) it is safest to aim for the top of the range.

Use this chart as a general guideline only. These data are for flame or corona treatment in an oxygen containing atmosphere.

