

RECOMMENDED TREATMENT LEVELS

		PRINTING PROCESSES											OTHER PROCESSES						
Process:		Flexo and Gravure			Litho			Offset/Letterpress			Screen and Pad			Laminating			Coating		
SUBSTRATE	Coating Type:	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV	Water	Solvent	UV
		PE	38	36	38	40	37	40	40	37	42	42	38	44	42	38	42	42	38
PP	44	40	50	46	42	50	46	42	54	48	44	60	50	44	54	48	45	54	
	38	36	40	40	38	40	40	37	40	42	38	44	42	38	42	42	38	44	
PS	44	40	50	46	42	50	46	42	54	48	44	60	50	44	54	48	45	54	
	38	35	42	40	37	42	40	38	42	42	38	42	42	37	42	42	38	44	
ABS	44	40	48	45	42	50	46	44	58	48	44	56	52	44	54	50	46	54	
	42	40	40	42	40	42	42	38	45	42	40	46	42	40	42	42	38	44	
	46	44	52	46	45	52	48	46	52	48	45	56	52	45	56	48	46	54	

- NOTES:**
- *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, it is safest to shoot for the top of the range.
 - *Chart should be used as a general guideline only, each operation has slightly different requirements.

- TIPS:**
- *Remember that dyne level decay is extremely rapid directly after corona treatment. A virtually immediate loss of 10 dynes/cm is possible. This is due to contact with process rolls (especially heated metal ones), surface blooming of additives, and interfacial transfers between treated and untreated surfaces within the finished, wound roll.
 - *Printers, coaters, and laminators should pull samples and perform the test as soon before the print station as possible. It may be worthwhile to dyne test the roll before it goes on the machine, and compare these results to material which has run through the web handling process to the print station.

Natural Dyne Levels: PE 30-32 PP 30-32 PS 36-38 ABS 35-42

*Natural dyne level represents the surface tension present on untreated sheet material.