



Necessary dyne-levels in different processes and materials

Surface adhesion

Process: Pad/Screen Printing			
Material/Ink	Solvent	Water	UV
LDPE	38-44	42-48	46-60
HDPE	38-44	42-48	46-56
PET	38-44	48-60	44-62
PP	38-44	42-48	44-60
PVC	38-44	42-48	42-60
EPDM	N/A	N/A	N/A
EVA	38-44	42-48	42-60

Process: Offset Printing			
Material/Ink	Solvent	Water	UV
LDPE	38-40	38-44	40-50
HDPE	38-40	38-44	38-50
PET	40-46	38-44	38-50
PP	38-40	38-44	40-50
PVC	38-40	38-44	38-44
EPDM	N/A	N/A	N/A
EVA	38-40	38-44	38-50

Process: Coating/Laminating			
Material/Ink	Solvent	Water	UV
LDPE	38-45	42-50	48-56
HDPE	38-44	42-50	48-56
PET	42-48	42-60	48-56
PP	38-44	42-50	48-56
PVC	38-45	40-48	48-56
EPDM	N/A	N/A	N/A
EVA	38-40	38-44	38-50