Recommended Inks

Our ink recommendations are based on trials conducted by Avery Dennison. If you prefer to use a specific ink supplier, it is recommended you test for performance.

> Liner printing (mask):
  - Actega Optifilm Jet Black water-based ink with density of 2.0+
  - Flint Inks Hydrofilm ACE water-based ink with density of 2.0+
> Adhesive printing:
  - Actega Optifilm Jet Black water-based ink with catalyst minimum 3.4 bcm
  - Flint Inks Flexocure FORCE UV ink
> Facestock printing:
  - Majority of standard film inks are compatible; test for adhesion

Plates

Standard photopolymer flexographic plates.

Dies

Standard rotary dies are recommended. Dies should be tooled to a 40# BG liner. Engraved or magnetic dies have both been used successfully.

Web Tension

The below recommended tension starting points have proven successful in our development trials. Variations of these set-points may be required for particular presses and applications.

> When running a narrower web width, an unwind tension of 30#, mid-press tension (when available) of 30# and an outfeed tension of 35# are recommended.
> When running a wider web width, an unwind tension of 35#, mid-press tension (when available) of 35# and an outfeed tension of 40# are recommended.
> Unwind/rewind tension: no special settings are required for unwind. Please refer to whatever standard break and tension settings are for the width of material being processed. Rewind tensions may vary given the size of the finished press roll. As always, it is recommend winding your finished rolls with the least amount of tension possible while enabling you to build a good roll.

UV Lamps

UV dose can be measured by test strips or dosimeter. In most cases, Avery Dennison can have a technician on site to measure this for you.

> A minimum density of 2.0K is recommended for the liner/mask print.
> It is recommended to run UV lamps on the high setting. Ensure the bulb is within the manufacturer recommended hours of use and to clean and polish shutters. When the lamps are set too high, the dose is affected by press speed (the slower the line speed the higher the dose).
> A minimum UV dose of 50 mJ/cm^2, as measured by the Tesa Tape and Honle UV Scan Device, should be achieved. Please note that the wattage of a bulb does not necessarily correlate to the UV output of the lamp. This is dependent on the bulb type, bulb age, reflector material, reflector condition and many other factors.
> Photo-reactive adhesive technology is not suggested for use with LED UV lamps.

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