

MATERIAL / PROCESS TYPES	DYNE LEVEL (mN/m)				WATT DENSITIES (Watt-min/ft ²)
	38-40	43-45	50-60	60+	
LDPE (No additives)	0.8	1	1.25	1.5	
LDPE (Low Slip)	1.25	1.5	2	2.5	
LDPE (Med Slip)	1.5	1.75	2.5	3	
LDPE (High Slip)	2	2.5	3	4	
HDPE	1.25	1.5	2	2.5	
LLDPE	1.25	1.5	2	2.5	
Styrene	0.8	1	1.25	1.5	
Nylon	0.8	1	1.25	1.5	
Nylon High Density	1	1.25	1.5	2	
PET	1	1.25	1.5	2	
PP	1.5	2	2.5	3	
OPP	2	2.5	3	4	
BOPP	2.5	3	3.75	4.25	
Metallized	1.5	1.75	2.5	3	
Foil	2	2.5	3	4	

MATERIAL / PROCESS TYPES	DYNE LEVEL (mN/m)				WATT DENSITIES (Watt-min/m ²)
	38-40	43-45	50-60	60+	
LDPE (No additives)	8.61	10.76	13.45	16.14	
LDPE (Low Slip)	13.45	16.14	32.52	26.90	
LDPE (Med Slip)	16.14	18.83	26.90	32.28	
LDPE (High Slip)	21.52	26.90	32.28	43.04	
HDPE	13.45	16.14	21.52	26.90	
LLDPE	13.45	16.14	21.52	26.90	
Styrene	8.61	10.76	13.45	16.14	
Nylon	8.61	10.76	13.45	16.14	
Nylon High Density	10.76	13.45	16.14	21.52	
PET	10.76	13.45	16.14	21.52	
PP	16.14	21.52	26.90	32.28	
OPP	21.52	26.90	32.28	43.04	
BOPP	26.90	32.28	40.35	45.73	
Metallized	16.14	18.83	26.90	32.28	
Foil	21.52	26.90	32.28	43.04	