

### General Information – Sheetfed Anilox Recommendations

#### Scope

- Below are general recommendations for anilox volume for use with respective Waterbased and Energy-Cured coating product types.
- These commonly used recommendations were determined to create reliably successful results for achieving the desired coating characteristics during press applications and should be used as a general guideline only.
- Specific anilox engraving specifications for engraving pattern/type, cell structure, screen ruling, screen angle, opening/depth and cell-wall ratio will determine actual transfer characteristics and achievable wet/dry coat-weight.
- Actual anilox roll condition for wear and contamination should be taken into consideration – regular roll audits to verify actual condition and volume/capacity is a good general practice.
- Equipment, material and process variations can cause the actual coating results to not achieve expected results.
- To discuss anilox recommendations for specific coating and/or applications, please contact your INXCAC Technical Sales Representative.

	WATERBASED COATING		ENERGY-CURED COATING	
	BCM	cm3/m2	BCM	cm3/m2
Gloss	9 - 11	14 - 17	11 - 14	17 - 22
Satin	9 - 11	14 - 17	11 - 14	17 - 22
Dull/Matte	9 - 11	14 - 17	11 - 14	17 - 22

Softfeel	10 – 13	15 - 20	11 – 14	17 - 22
Strike-Thru	8 – 10	12 - 16	8 – 10	12 - 16
Blister/Heatseal	14 - 18	17 - 28	-	-
Reticulation	-	-	11 – 14	17 - 22
Grit Texture #1 (35 µm)	>12	>19	>12	>19
Grit Texture #2 (50 µm)	>25	>40	>25	>40
Grit Texture #4 (80 µm)	-	-	>40	>62
Effect Pigment (5 – 25 µm)	>11	>17	>11	>17
Effect Pigment (10 – 60 µm)	>14	>22	>14	>22
Effect Pigment (10 – 125 µm)	>20	>31	>25	>40
Effect Pigment (20 – 200 µm)	-	-	>25	>40
Effect Pigment (45 – 500 µm)	-	-	>40	>62
Effect Pigment (100 µm)	-	-	>40	>62
Effect Pigment (200 µm)	-	-	>60	>93
UV Silver Foil	-	-	11 – 14	17 – 22
Raised Image – Fine Detail	-	-	>30	>46
Raised Image – Course Detail	-	-	>50	>77