

# ACTEGA Kelstar Technical Bulletin

## Calculate Coating Weight for In-line or Off-line

1. Take one foot square piece of foil. Fold in half. Tape to sheet of stock.
2. Run through coater / machine.
3. Cut through both layers of foil with 4" x 6" board.
4. Weigh both pieces of 4" x 6" coated and uncoated:

- Example: **Uncoated**      **Coated**  
                   .100 Grams      .130 Grams

Difference of 0.03 = 1.0 lbs. applied per thousand square feet

5. Difference determined on Coating Weight Conversion Chart

### Coating Weight Conversion Chart

For converting wet coating weight on a 4" x 6" coated foil versus a 4" x 6" uncoated foil.

| Weight / Grams<br>Difference of Foil | Lbs / M Square Feet<br>Dry Film Weight | Lbs / M Square Feet<br>Wet Film Weight |
|--------------------------------------|--|--|
| .010                                 | 0.13                                   | 0.33                                   |
| .020                                 | 0.26                                   | 0.65                                   |
| .023                                 | 0.29                                   | 0.731                                  |
| .025                                 | 0.32                                   | 0.812                                  |
| .028                                 | 0.35                                   | 0.93                                   |
| .030                                 | 0.39                                   | 0.99                                   |
| .035                                 | 0.44                                   | 1.16                                   |
| .037                                 | 0.48                                   | 1.20                                   |
| .040                                 | 0.52                                   | 1.30                                   |
| .045                                 | 0.58                                   | 1.45                                   |
| .050                                 | 0.65                                   | 1.65                                   |

The dry film weight should be 0.30 to 0.48. The wet film weight should be 0.75 to 1.20 lbs. per 1,000 square feet. Preliminary testing must be conducted to establish that each specific application may be accomplished acceptably.

If too little coating is being applied, there could be potential problems such as loss in gloss and rub resistance. If too much coating is applied, then there is a potential for picking and blocking.

Contact **ACTEGA Kelstar** at 856 829 6300 or [info.actega.kelstar@altana.com](mailto:info.actega.kelstar@altana.com) for additional information or technical assistance.