

STANDARD SLIP LEVELS

Slip Level/COF Chart

Low Slip	COF greater than 0.4
Medium Slip	COF between 0.25 – 0.39
High Slip	COF less than 0.25

When extruding films, achieving a specific slip level is not an exact science. An exact number can be specified as a target or measured on a sample but not achieved on a regular basis. Therefore, ranges are a more acceptable way to communicate needs for Slip Levels (COF).

Slip additive is infused into the extrusion barrel as the resins are being melted. Once the film is blown and cooled, the slip additive "blooms" throughout the film and comes to the surface where it allows the film to slide easily through processing equipment, or not, depending on the properties desired. Many factors affect the COF level during this process.

Generally, slip is added only to the Polyethylene (PE) layer on the inside which comes into contact with the forming tube on a VFFS machine. Other, outer layer materials such as, Polyester (PET), have only a natural slip which is Medium. It is not modified with slip additive during manufacture but does gain some slip while in contact with the PE, in roll form.

As you can see from the chart above, a Low Slip = a Higher COF number. Conversely, a High Slip = a Lower COF number.



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