Recommended Tension Value

				Breaking Tension (N/cm)		Recommended Tension Value (N/cm)		
Mesh Code	/cm	/inch	Thread Dia.	Warp	Weft	Standard Tension Breaking Value x60%	Advanced Tension Breaking Value x70%	Expert Tension Breaking Value x90%
200-024/508TW	200	508	24 µm	28.2	27.7	16	19	25
200-027/508TW	200	508	27 µm	39.9	37.2	22	26	33
180-027/460PW	180	460	27 µm	30.5	30.6	18	21	27
165-027/420PW	165	420	27 µm	31.6	29.4	18	21	27
165-030/420PW	165	420	30 µm	41.8	39.9	24	28	36
150-027/380PW	150	380	27 µm	30.0	30.7	18	21	27
150-030/380PW	150	380	30 µm	34.0	39.0	22	26	33
150-033/380PW	150	380	33 µm	40.9	42.7	25	29	38
150-035/380TW	150	380	35 µm	50.0	50.0	30	35	45
140-027/355PW	140	355	27 µm	27.4	25.0	16	18	24
140-030/355PW	140	355	30 µm	36.0	36.7	21	25	32
140-035/355PW	140	355	35 µm	45.3	46.0	27	31	40
130-027/330PW	130	330	27 µm	26.3	24.7	15	17	22
130-030/330PW	130	330	30 µm	32.7	33.0	20	23	30
130-035/330PW	130	330	35 µm	45.3	43.1	26	30	38
124-027/315PW	125	315	27 µm	26.2	25.6	15	18	23
124-030/315PW	125	315	30 µm	33.8	31.0	18	21	28
120-030/305PW	120	305	30 µm	30.2	30.5	18	21	27
120-033/305PW	120	305	33 µm	35.6	36.0	21	25	32
120-035/305PW	120	305	35 µm	41.7	43.0	25	30	38
120-040/305PW	120	305	40 µm	50.0	50.0	30	35	45
110-035/280TW	110	280	35 µm	38.5	36.7	22	26	33
106-040/270PW	106	270	40 µm	45.4	46.2	27	31	40
100-035/255PW	100	255	35 µm	37.8	36.4	22	26	33
100-040/255PW	100	255	40 µm	42.3	42.0	25	29	37
90-040/230PW	90	230	40 µm	40.4	38.0	23	27	34
90-045/230PW	90	230	45 µm	50.0	50.0	30	35	45
90-048/230PW	88	225	48 µm	50.0	50.0	30	35	45
79-045/200PW	79	200	45 µm	42.2	43.6	25	29	38
79-048/200PW	79	200	48 µm	47.1	46.0	27	32	41
79-055/200PW	79	200	55 µm	44.0	43.3	26	30	39
71-048/180PW	71	180	48 µm	42.4	42.4	25	29	38
71-055/180PW	71	180	55 µm	43.5	43.7	26	30	39
63-048/160PW	63	160	48 µm	38.0	40.0	22	26	34
63-063/160PW	63	160	63 µm	44.0	43.5	26	30	39
59-045/150PW	59	150	45 µm	30.8	31.9	18	21	28
59-048/150PW	59	150	48 µm	33.3	32.5	19	22	29
59-055/150PW	59	150	55 µm	44.6	44.6	27	31	40
55-063/140PW	63	140	63 µm	41.0	44.4	24	28	37
53-045/135PW	53	135	45 µm	26.6	26.2	15	18	23
53-048/135PW	53	135	48 µm	29.3	29.0	18	20	26
53-055/135PW	53	135	55 µm	33.5	35.5	21	24	31
49-071/125PW	49	125	71 µm	42.2	42.1	25	29	38
47-045/120PW	47	120	45 µm	21.6	23.8	12	14	19
47-048/120PW	47	120	48 µm	30.4	28.1	17	20	25
47-055/120PW	47	120	55 µm	28.8	30.0	18	21	26
47-063/120PW	47	120	63 µm	44.6	43.7	26	31	40
43-080/110PW	43	110	80 µm	43.8	43.3	26	30	39
39-055/100PW	39	100	55 µm	27.7	29.4	17	20	26
39-071/100PW	39	100	71 µm	45.3	45.3	27	32	41
27-071/070PW	27	100	71 µm	36.3	36.5	22	25	33
35-071/090PW	35	90	71 µm	44.0	42.7	26	30	39
35-080/090PW	35	90	80 µm	44.4	44.3	27	31	40
31-071/080PW	31	80	71 µm	43.2	43.2	26	30	39
31-100/080PW	31	80	100 µm	45.3	45.5	27	32	41
24-120/060PW	24	60	120 µm	53.2	51.2	27	32	41
24-125/060PW	24	60	125 µm	45.4	46.2	27	32	41
24-150/060PW	24	60	150 µm	50.0	50.0	30	35	45

Standard Tension:
Good for all printers using mechanical stretching device, or less sophisticated printing machine without necessary controls that a high modulus polyester mesh would require.
This is also the correct tension for most large format screen.

Advanced Tension:
Requires stable frames, an experienced technician and excellent stretching device. Operators will need to use minimum off-contact during printing process.

Expert Tension:
Expert screen makers and machine operators can achieve these levels with state-of-the-art equipment and great care. Minimum off-contact is required during printing process.
Some printers experiment at these tensions then use lower tension on their production screens.

The above breaking tensions are measured value in 1000mm x 1000mm sized mechanical stretching device.