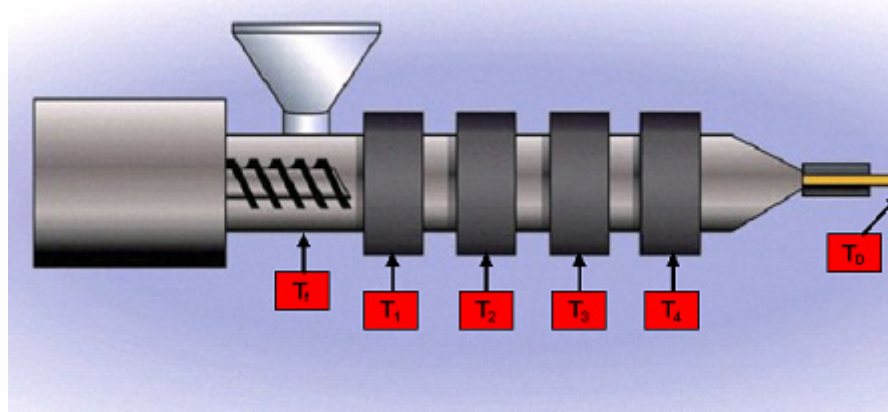


Processing Conditions for Extrusion

TOPAS[®] 5013X14 Blends



Processing temperatures:	T _f =	20-70 °C	68-158 °F *
	T ₁ =	220-240 °C	428-464 °F
	T ₂ =	220-240 °C	428-464 °F
	T ₃ =	220-240 °C	428-464 °F
	T ₄ =	220-240 °C	428-464 °F
	T _D =	220-240 °C	428-464 °F

* grooved feed zones hot (120 °C / 248 °F)

Head pressure:	P _{melt} > 140 bar / 2000 psi
	Fine screen packs as needed

Screw Speed	n _{screw} > 50% nominal
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Screw design:	Multi-purpose or barrier screw w/ mixing section
	Screw diameter > 60 mm / 2.5 in
	Preferred L/D ratio ≥28:1 where available

Note:

- Pure TOPAS 5013X14 can not be blown due to high rigidity, but can be cast. Processing recommendations given are valid for blends with polyethylene or TOPAS 8007 resins. Ensure that blend materials are compatible with recommended temperatures. These recommendations are the preferred start-up conditions and have to be optimized on the specific extrusion line. Please contact us for additional process recommendations.

IMPORTANT: This publication contains general advice for processing our products. It indicates typical processing conditions, and is not intended to cover individual cases. The properties of our products may change as a result of processing conditions or the inclusion of additives. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and to entrust the handling of such material to adequately trained personnel only. Please refer to the appropriate Safety Data Sheets before attempting to process our products.

TOPAS
Thermoplastic Olefin
Polymer of Amorphous
Structure (COC)