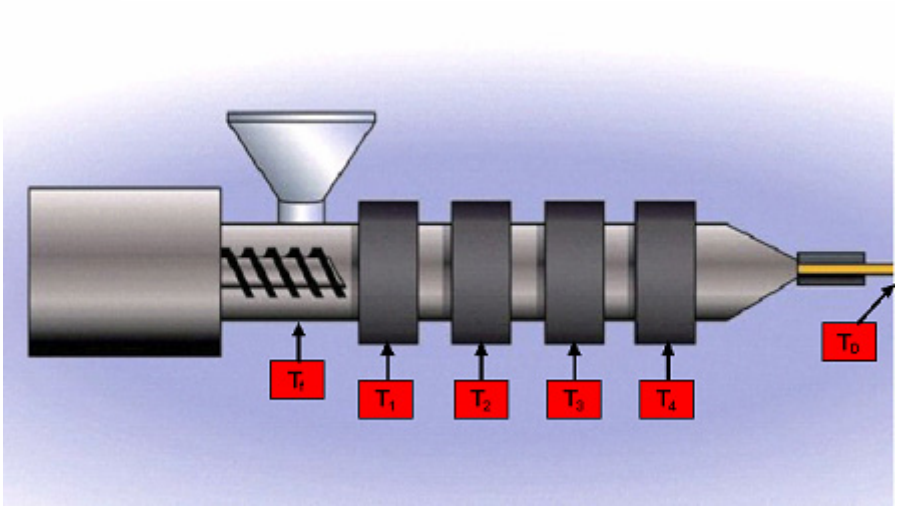
Processing Conditions for Extrusion

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		
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.

TOPAS
Thermoplastic Olefin Polymer of Amorphous Structure (COC)

TOPAS Advanced Polymers
Tel: +49 (0) 1805-1-86727 (Europe)
Tel: +1 (859) 746-6447 (North America)
email: info@topas.com
Internet: www.topas.com