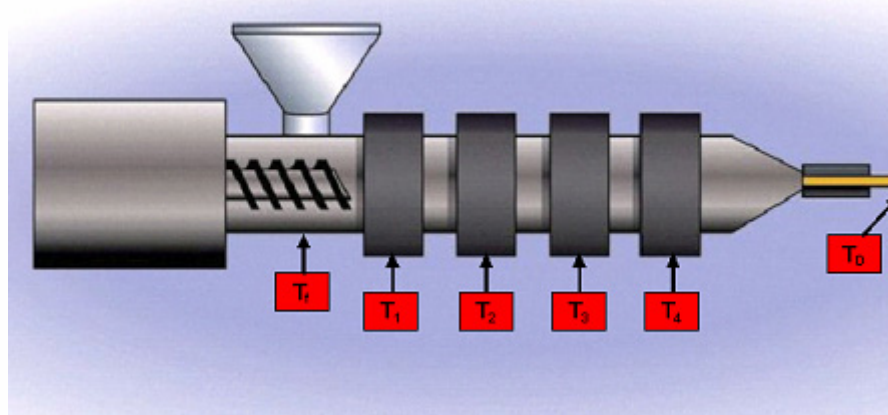


Processing Conditions for Extrusion

TOPAS[®] 9506F-04



Processing temperatures:

T _f =	20-60 °C *	68-140 °F *
T ₁ =	210-220 °C	410-428 °F
T ₂ =	230-240 °C	446-464 °F
T ₃ =	230-240 °C	446-464 °F
T ₄ =	230-240 °C	446-464 °F
T _D =	230-240 °C	446-464 °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:

- This grade of TOPAS[®] can be extruded on a variety of commercial blown and cast film lines. These recommendations are suggested start-up conditions and must be optimized on the specific extrusion line. Please contact us for further process recommendations.

TOPAS

Thermoplastic Olefin
Polymer of Amorphous
Structure (COC)

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.