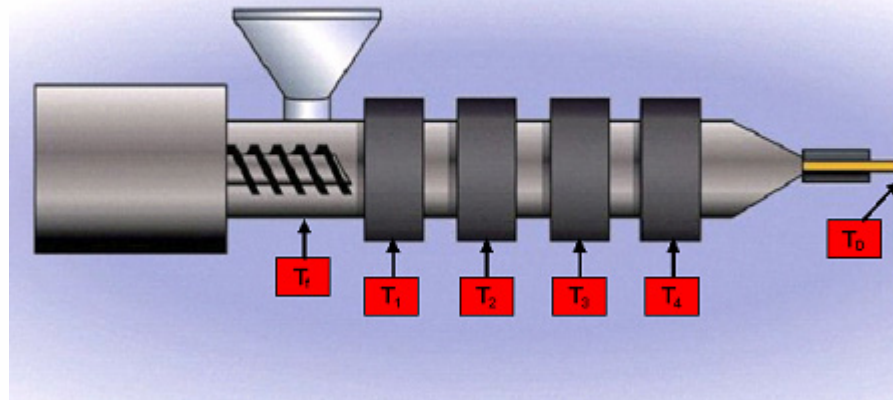


Processing Conditions for TOPAS[®] in Blends with Polyolefins (<30% COC)



Processing temperatures:

Regardless of usual settings, extrusion temperatures must be set high enough to melt the TOPAS[®]. Refer to the processing guide to determine recommended settings for the specific grade of TOPAS[®] under consideration. Lower extrusion temperatures can result in incomplete TOPAS[®] melting, creating gel-like unmelts in the finished product. Ensure that blend materials are compatible with recommended temperatures

Head pressure:

$P_{melt} > 140 \text{ bar} / 2000 \text{ psi}$
Fine screen packs as needed

Screw Speed

$n_{screw} > 50\% \text{ nominal}$

Screw design:

Multi-purpose or barrier screw w/ mixing section
Screw diameter $> 60 \text{ mm} / 2.5 \text{ in}$
Preferred L/D ratio $\geq 28:1$ where available
Compression ratio 2:1

Note:

- Most grades of TOPAS[®] can be extruded in blends 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.

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)