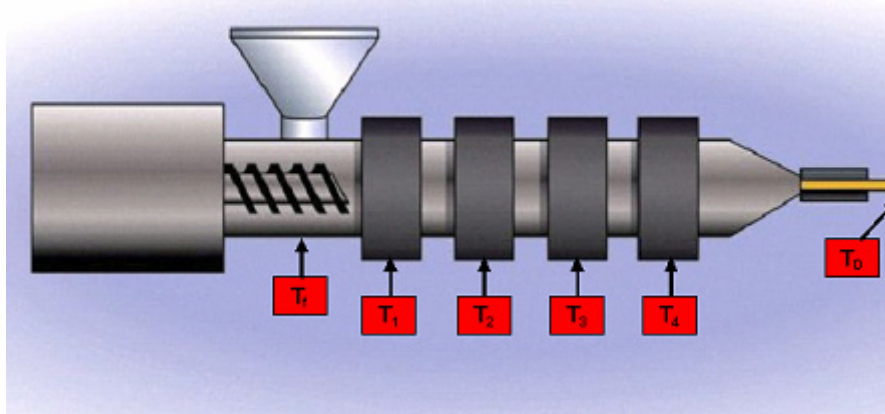


Processing Conditions for Extrusion

TOPAS[®] 6013F-04



| | | | |
|--------------------------|---------|------------|--------------|
| Processing temperatures: | $T_f =$ | 20-70 °C | 140-158 °F * |
| | $T_1 =$ | 230-240 °C | 446-464 °F |
| | $T_2 =$ | 250-260 °C | 482-500 °F |
| | $T_3 =$ | 250-260 °C | 482-500 °F |
| | $T_4 =$ | 250-260 °C | 482-500 °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 $\geq 28:1$ where available

Note:

- This grade can be extruded on a variety of commercial cast film lines, and on blown film lines in blends or thin discrete layers. These recommendations are the preferred start-up conditions and have to be optimized on the specific extrusion line. Please contact us for further process recommendations. See our processing guide for polyolefin blends if such blends are planned.

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)