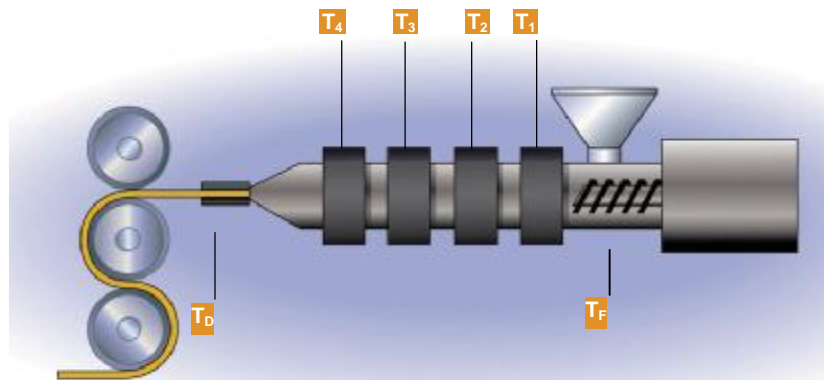


Processing Conditions for Cast Film Extrusion

TOPAS[®] 8007F-04



Processing temperatures:	T _f =	60 – 70 °C *
	T ₁ =	210-220 °C
	T ₂ =	230-240 °C
	T ₃ =	230-240 °C
	T ₄ =	230-240 °C
	T _D =	230-240 °C

* grooved feed not recommended

Head pressure:	P _{melt} >	140 bar
		fine screen packs as needed

Screw speed:	n _{screw} >	50% nominal
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Typical screw design:	barrier flight screw with shear/mixing section	
	screw diameter >	
	60 mm	
	L/D-ratio 30:1	
	Low compression ratio 2:1	

Note: This grade can be extruded on a variety of commercial cast film lines. 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.

TOPAS
Thermoplastic Olefin
Polymer of Amorphous
Structure (COC)