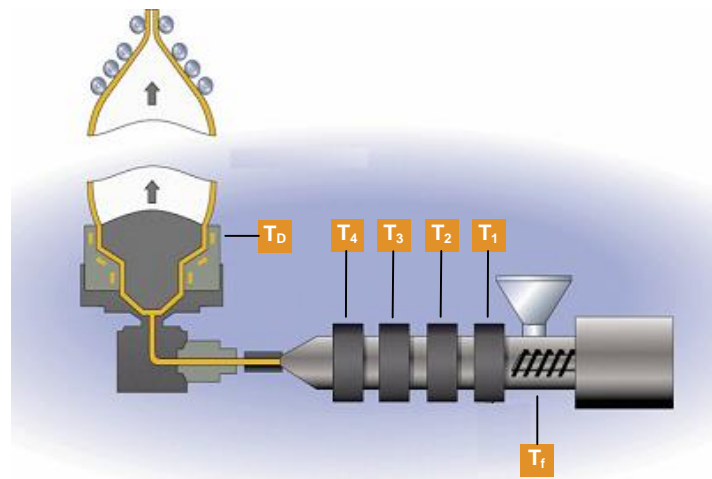


# Processing Conditions for Blown Film Extrusion

## TOPAS® 8007F-400



Processing temperatures:	T <sub>f</sub> =	cold *
	T <sub>1</sub> =	200-210 °C
	T <sub>2</sub> =	200-210 °C
	T <sub>3</sub> =	200-210 °C
	T <sub>4</sub> =	200-210 °C
	T <sub>D</sub> =	220-230 °C

\* grooved feed zones hot (120°C)

Head pressure:	P <sub>melt</sub> > 140 bar
	fine screen packs as needed

Screw speed:	n <sub>screw</sub> > 50% nominal
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Typical screw design:	standard polyolefin or barrier flight screw
	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 blown 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)