

ECO-FLEX™ RTPV

Extrusion Blow Molding Processing Tips

ECO-FLEX RTPVs combine the processability of a thermoplastic with the performance characteristics of thermoset rubber. They are processed using standard thermoplastic extrusion blow molding equipment.

Extrusion Blow molding guidelines for ECO-FLEX RTPV:

1. Temperatures (F):

	SA-65A	SA-75A	SA-85A	SA-40D
Feed	340	340	350	360
Transition	350	350	360	370
Metering	360	360	370	380
Upper Head	370	370	380	390
Lower Head	370	370	380	390
Die Tip	380	380	390	400
Melt	370	370	380	390
Blow Ratio	2	2.5	4	4.5

2. Pre-dry material for 3 to 5 hours at 65°C (150°F).

3. Run with lowest melt-temperature possible.

4. Extruder/screw recommendations:

- Minimum L/D of 24:1
- Screw compression ratio of 2.5 to 3.0:1

5. Die recommendations:

- Converging tooling is preferred.
- Parison swell at die exit will be $\leq 5\%$ for ECO-FLEX RTPV grades 85 Shore A and below.
- Parison swell at die exit will be 5% – 10% for ECO-FLEX RTPV grades above 85 Shore A.

6. Re grind can be used (recommend 20% regrind to 80% virgin).

DISCLAIMER OF WARRANTY AND LIABILITY:

The information and recommendations set forth herein are believed to be correct. Persons receiving same assume responsibility for determining the suitability of any recommendations mentioned herein before using the same. SYNESIS makes no representation or warranty, expressed or implied, as to the accuracy or completeness thereof, or of fitness for a particular purpose.

SYNESIS