

# ECO-FLEX™ RTPV

## Sheet Extrusion Processing Tips

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

### Sheet Extrusion processing guidelines for ECO-FLEX RTPV:

1. Temperatures (F):

	SA-45A	SA-55A	SA-65A	SA-75A	SA-85A	SA-40D
<b>Feed</b>	320	330	340	340	350	360
<b>Transition</b>	330	340	350	350	360	370
<b>Metering</b>	340	350	360	360	370	380
<b>Front</b>	350	360	370	370	380	390
<b>Melt</b>	350	360	370	370	380	390

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

3. Run with lowest melt-temperature possible.

4. Die temperatures profile (F): 330 320 300 300 320 330.

5. Set die lips 50% over desired gauge.

6. Coat hanger dies preferred.

7. Roll Temperatures (F): Top 170, Center 150, Bottom 130. Run product upstack.

8. Screen pack: 20/60/20

9. Extruder/screw recommendations:

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

10. Regrind 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