

ECO-FLEX™ RTPV

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 extrusion equipment.

Extrusion processing guidelines for ECO-FLEX RTPV:

1. Temperatures (F):

	SA-45A	SA-55A	SA-65A	SA-75A	SA-85A	SA-40D
Feed	320	330	340	340	350	360
Transition	330	340	350	350	360	370
Metering	340	350	360	360	370	380
Front	350	360	370	370	380	390
Head	350	360	370	370	380	390
Die	360	370	380	380	390	400
Melt	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. Extruder RPM 30-80 RPM. Size extruder depending on cross-sectional area.

5. Extruder/screw recommendations:

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

6. Die design recommendations:

- Keep land length to a minimum.
- Streamline flow channels in the head and die.
- Oversize die opening by 5 to 10% for length and width depending on material hardness.
- Oversize die opening by 3 to 5% for thickness depending on material hardness.

7. 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