



EXTRUSION GUIDE FOR PLEXTENE AND PLEXLINK HFFR COMPOUND

EQUIPMENT

SCREW

- Low compression and low shear screw is recommended.
- Maximum screw compression ratio is 1.2.
- No mixing section required.
- Conventional design with single flight or twin flight acceptable.
- Screw cooling preferable.

BREAKER PLATE AND SCREEN PACK

- Breaker plate is not necessary and can replace by spacer ring.
- Screen pack is not necessary.

DIE

- Head and die should have no stagnant area.
- The head and tools design should give a smooth and streamlined flow.
- Both pressure and tubing die are recommended.
- For tubing die should be have flat land about 3 mm for both die and pin.
- Draw Down Ratio (DDR) preferably below 2, higher DDR may be possible depend on customer machine condition.
- Draw Ratio Balance (DRB) : 1.0

PROCESSING CONDITION

TYPICAL TEMPERATURE SETTING, °C

Product Grade	Feed	Compression	Metering	Head	Die
Plexlene 2035	115 –130	125 – 140	135 – 150	145 - 160	145 - 160
Plexlink 2135X	115 –130	125 – 140	135 – 150	145 - 160	145 - 160

- Maximum Melt Temperature is below 180 °C.
- Low melt pressure is recommended.
- If the product is stored in a cool and dry area, pre-drying is not necessary.

MASTERBATCHES

- EVA base color masterbatches are recommended and color masterbatches be thoroughly dried before use i.e. at 60oC to 80 oC for 2-4 hours.
- The masterbatches should be halogen free.
- Typical addition rates vary from 0.5% to 2% would be satisfactory for color masterbatches.
- For carbon black masterbatch depend on carbon content. Typical addition rates vary from 1% to 5%

PLEXCHEM TECHNOLOGIES



DELIVERY

Form : Granules
Package : 25 kg bags

MATERIALS HANDLING

A clean, cool and dry storage area is recommended

SAFETY

Above mentioned compounds are not classified as a dangerous compound.

The product is supplied in form of free-flowing granules of about 3 - 4 mm in size and can be readily handled with commercially available equipment. All handling and transport of the product may generate some dust and fines that constitute a potential risk for dust explosion.

Inhalation of any type of dust may irritate the air passage and should be avoided.

NOTICE: The information and data contained herein serves only as a guide. No liability, warranty or guarantee of the product is created by this document. It is the user's responsibility to ascertain the appropriate operation conditions based on the user's own equipment and experiences.

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Do you have the safety data sheet for this product? Please contact you service representative for one or E-mail us at: plexchem@plexchem.com.sg

