

PROCESSING GUIDE FOR EXTRUSION OF FLEXALLOY® JACKETING COMPOUNDS

EQUIPMENT & CONDITIONS	SUGGESTIONS						
Compound Drying	Typically not required. 160°F for 4 hours if desired.						
Color Concentrate	PVC-based color concentrates.						
Machine Type	Typical PVC extrusion equipment. Chrome plated screw and bimetallic barrel.						
Screw Design	<p>A) General Purpose Metering Type</p> <table style="margin-left: 40px;"> <tr> <td>Metering Section</td> <td>33%</td> </tr> <tr> <td>Transition Section</td> <td>33%</td> </tr> <tr> <td>Feed Section</td> <td>33%</td> </tr> </table> <p>B) Barrier Maddock screw designed for PVC.</p>	Metering Section	33%	Transition Section	33%	Feed Section	33%
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Transition Section	33%						
Feed Section	33%						
Compression Ratio	3:1 target (2.5:1 to 3.5:1 range)						
L/D Ratio	24/1 target (30/1 also OK)						
Screen Packs	20/40/60 typical (up to 80 mesh OK)						
Screw RPM	30 RPM minimum (choose extruder size to accommodate this)						
Screw Cooling	Not Recommended						
Water Bath	Cold Water; 40°F - 60°F						
Tooling	<p>Cross-head: Low inventory cross-heads.</p> <p>Die Design: Tube (Sleeving) or Pressure Type. Streamlined, low inventory chrome plated. Matched tip and die angles, fairly tight together for optimum die pressure.</p> <p>Pressure Die: Size die 5% over final diameter for optimum speed and physicals with pressure set-up.</p> <p>Tubing Die: 2.0 - 3.0:1 DDR target for tubing set-up.</p>						

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SUGGESTIONS

Machine Temperatures

Hardness Range	Typical Barrel Settings	Melt Temperature Range
65A to 75A	330°F - 365°F	370°F - 380°F
75A to 85A	340°F - 370°F	380°F - 390°F
85A to 95A	345°F - 375°F	385°F - 395°F

**Melt temperature should be measured using a pyrometer on the material exiting the die.

Purging

If necessary, use HD polyethylene.

Regrind

Recyclable; mix up to 20% regrind with virgin.

Additional Considerations

Care must be taken to avoid excessive temperatures or delays during extrusion; material should not sit for more than 15 minutes under any circumstances.

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