

Equipment & Suggestions

Compound Drying	This series of TPVs will absorb moisture which may result in material degradation, therefore requires drying before use. Use a desiccant dryer for a minimum of 3 hours at 180°F.
Colorant	Polyolefin-based concentrates
Screw Design	General Purpose
L/D Ratio	24:1 minimum
Compression Ratio	2.5 to 4.0
Die Design	Typical draw down ratio is 1.1:1 to 2:1. Die swell averages from 0 to 15% and typically increases by increasing shear rate or decreasing melt temperature.
Screen Packs	20/40/60/40/20 (or tighter) Tighter screen packs (up to 200 mesh) will result in higher pressure and lower output.
Use of Regrind	100% Recyclable; use up to 20% regrind with virgin material
Purging	High density polyethylene (HDPE) or polypropylene (PP); grades with lower melt flow purge more efficiently

Start-Up Conditions

Temperature Settings

Feed Throat	Water Cooled	
	Feed Zone	280 to 300°F
Transition Zone	320 to 340°F	160 to 170°C
Metering Zone	370 to 390°F	188 to 200°C
Adapter/Die	400 to 475°F	204 to 246°C
Melt Temperature	400 to 475°F	204 to 246°C

These parameters are for a typical machine of generic design. The actual parameters may vary depending on your specific injection molding equipment and part design.

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