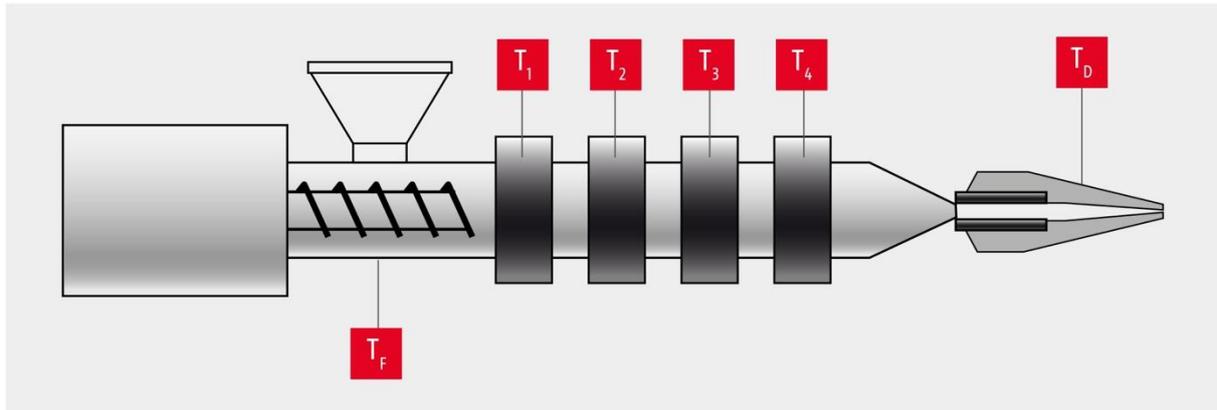


TOPAS[®] 5013F-04 Blends

Cyclic Olefin Copolymer

Processing Conditions for Extrusion



Processing Temperatures

T_F	T_1	T_2	T_3	T_4	T_D
20-70 °C *	220-240 °C				
68-158 °F *	428-464 °F				

* for grooved feed zones: T_F : approx. 120°C / 248°F

Head Pressure	$P_{melt} > 140 \text{ bar} / 2000 \text{ psi}$ Fine screen packs as needed
Screw Speed	$n_{screw} > 50\% \text{ nominal}$
Screw Design	Multi-purpose or barrier screw w/ mixing section Screw diameter $> 60 \text{ mm} / 2.5 \text{ inch}$ Preferred L/D ratio $\geq 28:1$ where available

Note

Pure TOPAS 5013F-04 cannot be blown due to high rigidity, but can be cast. Processing recommendations given are valid for blends with polyethylene or TOPAS 8007 resins. Ensure that blend materials are compatible with recommended temperatures. These recommendations are the preferred start-up conditions and have to be optimized on the specific extrusion line. Please contact us for additional process recommendations.

