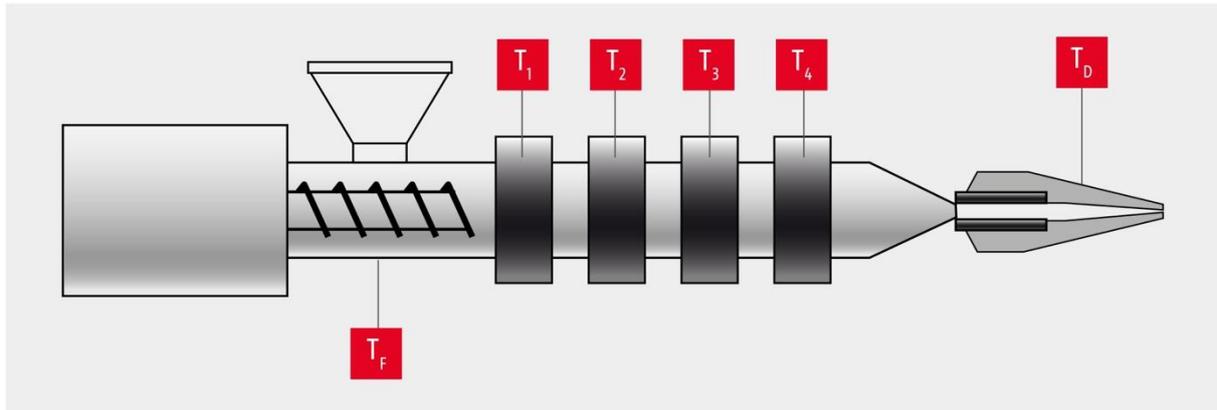


TOPAS[®] 8007F-04

Cyclic Olefin Copolymer

Processing Conditions for Extrusion



Processing Temperatures

T_F	T_1	T_2	T_3	T_4	T_D
20-60 °C *	210-220 °C	230-240 °C	230-240 °C	230-240 °C	230-240 °C
68-140 °F *	410-428 °F	446-464 °F	446-464 °F	446-464 °F	446-464 °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

This grade of TOPAS is the preferred 8007-series product for cast films, and can be extruded on a variety of commercial cast and blown film lines. These recommendations are suggested start-up conditions and must be optimized on the specific extrusion line. Please contact us for further process recommendations.

