

## PROCESSING GUIDE FOR EXTRUSION OF FLEXALLOY® COMPOUNDS

EQUIPMENT & CONDITIONS	SUGGESTIONS
<b>Compound Drying</b>	Typically not required. May be helpful for co-extrusion compounds. 160°F for 4 hours if desired.
<b>Color Concentrate</b>	PVC-based color concentrates used at 2% or less.
<b>Machine Type</b>	Typical PVC extrusion equipment. Extruder barrel should be bimetallic.
<b>Screw Design</b>	General Purpose or Barrier Type - Chrome plated Maddock mixer (spiral preferred) recommended when using color concentrate. <b>No Mixing Pins.</b>
<b>Compression Ratio</b>	2:1 to 3:1
<b>L/D Ratio</b>	20:1 to 24:1
<b>Screen Packs</b>	20/40 Stainless Steel
<b>Screw RPM</b>	30 RPM minimum (choose extruder size to accomodate this)
<b>Screw Cooling</b>	Not Recommended.
<b>Water Bath</b>	Cold Water; 40°F - 60°F
<b>Tooling</b>	<p><b>Cross-head:</b> Low inventory cross-heads.</p> <p><b>Die Design:</b> Streamlined, low inventory, chrome plated.</p>

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## EQUIPMENT & CONDITIONS

## SUGGESTIONS

### Machine Temperatures

Hardness Range	Typical Barrel Settings	Typical Die Settings	Melt Temperature Range
Shore A35 - 50	250°F - 310°F	310°F - 320°F	335°F - 345°F
Shore A50 - 60	270°F - 330°F	320°F - 340°F	345°F - 355°F
Shore A60 - 70	280°F - 340°F	340°F - 345°F	355°F - 365°F

\*\*Melt temperature should be measured using a pyrometer on the material exiting the cross-head.

### Purging

If necessary, use HD polyethylene.

### Regrind

Recyclable; mix up to 20% regrind with virgin.

### Additional Considerations

Never leave extruder at elevated temperature without purging.

Never process with an actual melt temperature > 400°F.

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