

## THERMOLAST K in Extrusion: Machines

### 1. Machine Specifications

Extrusion of THERMOLAST K normally does not require use of special extruders. Standard extruders (e.g. universal or polyolefin extruders) designed for conventional plastics can be used to process THERMOLAST K in most cases. Some restrictions apply to PVC extruders.

### 2. Cleaning of Machines

Before processing THERMOLAST K, purge the extruder with polyethylene or polypropylene. Purge particularly thoroughly if the material run beforehand was PVC.

If another material is to be processed afterwards, run system until empty and purge again with PE or PP.

### 3. Screws, Screens, Breaker Plate

Experience has shown that 3-zone screws are best suited for processing THERMOLAST K. The screw length should be at least 25 D. The compression ratio should be at least 3.5 : 1. The screw must be able to provide sufficient shearing. A breaker plate and a screen pack are normally recommended in the extruder configuration in order to increase pressure.