

THERMOLAST K in Extrusion: Processing

1. Process Parameters

The following sections provide information and general recommendations for processing THERMOLAST K. Please keep in mind that your experience with your machines and the particular machine processed should always be taken into consideration as well. As THERMOLAST K compounds are frequently custom-developed to individual customer requirements, differences in processing can result.

Our applications engineers will be happy to provide any advice you may require and to come to your plant upon request to observe processing of sample materials.

2. Process Temperatures

Typical extrusion process parameters for THERMOLAST K are as follows:

Feed zone:	150° C – 170° C (300° F – 340° F)
Compression zone:	185° C – 200° C (365° F – 390° F)
Metering zone:	185° C – 200° C (365° F – 390° F)
Die:	185° C – 210° C (365° F – 410° F)

The maximum processing temperature should not exceed 250° C (480° F). Overheating, i.e. thermal decomposition of the material, is easily recognized as indicated by a distinctive odour.

Exact temperature recommendations for THERMOLAST K standard compounds are given in the processing instructions in the appendix.

3. Die Temperature

The die temperature should normally be between 185° C – 210° C (365° F – 410° F), depending on the compound processed. More information can be found in the appendix. Our applications engineering department will also be pleased to provide you further information upon request.

4. Calibration

Calibration is normally not required. Support elements may be required when extruding THERMOLAST K compounds with high hardness or when coextruding with standard thermoplastics.