

THERMOLAST K in Extrusion: Moulds

1. Extrusion Dies

Simple matrix dies will suffice for processing THERMOLAST K in many applications. The die land should be as short as possible, i.e. max. 3 - 4 mm (0.12 - 0.16 in.), particularly if the surfaces of the die are not finely polished.

More elaborate multi-component dies with flow correction capability provide benefits including reduced machine direction shrinkage and reduced profile distortion. They also allow attainment of higher production rates. When extruding hollow profiles, internal air support can be advantageous.

2. Die Temperature

Optimum finished product properties are normally attained at die temperatures between 185° C (365° F) and 210° C (410° F).

For more information, e.g. with regard to coextrusion, please refer to the processing overview in the appendix. In addition, our application engineers will be happy to provide you additional information relative to your specific application.