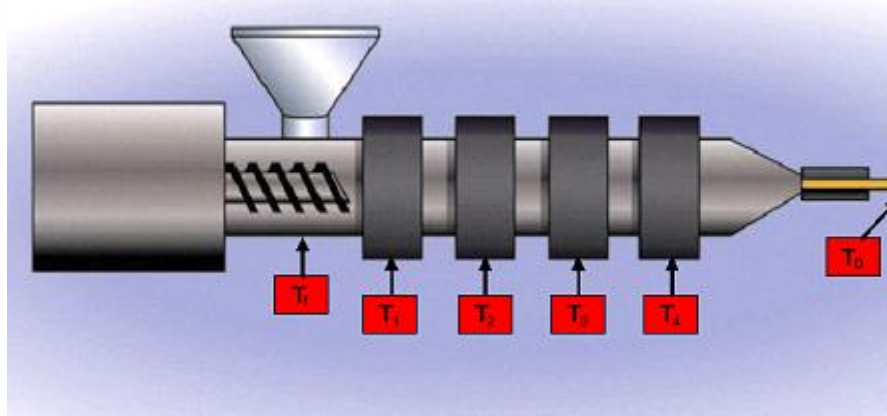


# Processing Conditions for Extrusion

## TOPAS<sup>®</sup> 5013F-04 Blends



Processing temperatures:	$T_f =$	20-70 °C	68-158 °F *
	$T_1 =$	220-240 °C	428-464 °F
	$T_2 =$	220-240 °C	428-464 °F
	$T_3 =$	220-240 °C	428-464 °F
	$T_4 =$	220-240 °C	428-464 °F
	$T_D =$	220-240 °C	428-464 °F

\* grooved feed zones hot (120 °C / 248 °F)

Head pressure:	$P_{melt} > 140$ bar / 2000 psi Fine screen packs as needed
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Screw Speed	$n_{screw} > 50\%$ nominal
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Screw design:	Multi-purpose or barrier screw w/ mixing section Screw diameter > 60 mm / 2.5 in Preferred L/D ratio $\geq 28:1$ where available
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Note:	<ul style="list-style-type: none"> <li>Pure TOPAS 5013F-04 can not be blown due to high rigidity, but can be cast. Processing recommendations given are valid for blends with polyethylene or TOPAS 8007 resins. Ensure that blend materials are compatible with recommended temperatures. These recommendations are the preferred start-up conditions and have to be optimized on the specific extrusion line. Please contact us for additional process recommendations.</li> </ul>
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**IMPORTANT:** This publication contains general advice for processing our products. It indicates typical processing conditions, and is not intended to cover individual cases. The properties of our products may change as a result of processing conditions or the inclusion of additives. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and to entrust the handling of such material to adequately trained personnel only. Please refer to the appropriate Safety Data Sheets before attempting to process our products.

**TOPAS**  
Thermoplastic Olefin  
Polymer of Amorphous  
Structure (COC)