

## Example of Processing on “Soarnol<sup>®</sup>”

Examples of processing on “Soarnol<sup>®</sup>” with medium-sized equipment and large-sized equipment are shown in the following.

### (1) Medium-sized Equipment

- Extruder : 40mm  $\phi$  ,L/D=28
- Screw : Full-flighted, constant pitch type, CR=3.5
- Screen pack : 80/120/50 mesh
- Die : Manifold type, die width = 450 mm, lip distance = 0.2 mm
- Cooling roll : Metal roll cooled by water
- Processing temperature :deg C (deg F)

Grade	C <sub>1</sub>	C <sub>2</sub>	C <sub>3</sub>	C <sub>4</sub>	C <sub>5</sub>	Head	Die
Soarnol E, ET, A, AT	170 (338)	190 (374)	210 (410)	220 (428)	220 (428)	220 (428)	190-220 (374-428)
Soarnol D, DT, DC	180 (356)	200 (392)	220 (428)	230 (446)	230 (446)	230 (446)	200-220 (392-428)

Screw rotation : 30 rpm

Output : 9-11 kg/hr

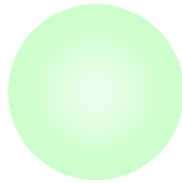
Resin pressure: 6.9~9.8MPa (70-100 kg/cm<sup>2</sup>)

Motor load : 10-13 amp

Line speed : 15-20 m/min

Film size : Width = 370-380 mm, thickness = 20-30  $\mu$  m



**(2) Large-sized Equipment**

- Extruder : 90 mm  $\phi$  screw type, L/D = 26  
Screw : Full-flighted, constant pitch type, CR=3.5  
Screen pack : 50/80/150/60 mesh  
Die : Manifold type, die width = 1000 mm, lip distance = 0.7 mm  
Cooling roll : 400 mm  $\phi$ , mirror  
Processing temperature : deg C (deg F)

Grade	C <sub>1</sub>	C <sub>2</sub>	C <sub>3</sub>	C <sub>4</sub>	C <sub>5</sub>	Head	Die
Soarnol E	170 (338)	190 (374)	210 (410)	220 (428)	220 (428)	220 (428)	190-220 (374-428)

- Screw rotation : 30 rpm  
Motor load : 80 amp  
Output : 82 kg/hr  
Line speed : 70 m/min  
Film size : Width = 850 mm, thickness = 20  $\mu$  m

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