



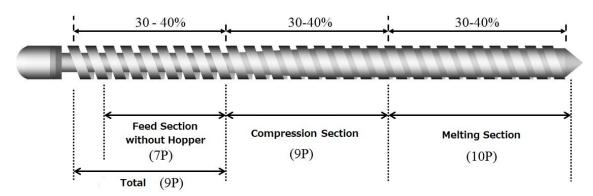
General Advice on Processing of "SoarnoLTM"

As for processing of "SoarnoL™", processing with an equipment shown below is recommended. When you use other type of equipment, please contact us accordingly.

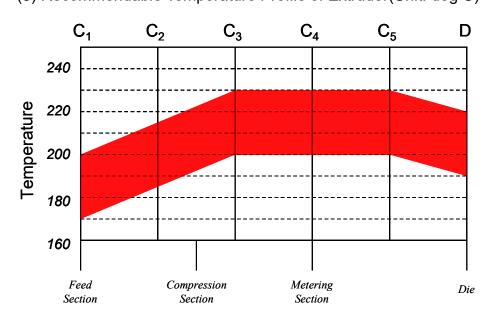
(1) Extruder: L/D=24-30

(2) Screw Design C.R.=3.0-3.5

Plating: Chrome Plating or Nickel Alloy Plating



(3) Recommendable Temperature Profile of Extruder(Unit: deg C)



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(4)Screen Pack 80/120 - 150/50 mesh

Example of Processing on "SoarnoLTM"

Examples of processing on "SoarnoL™" with medium-sized equipment and large-sized equipment are shown in the following.

(1) Medium-sized Equipment

Extruder : 40mmφ,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_1	C_2	C_3	C_4	C_5	Head	Die
"SoarnoL™"	170	190	210	220	220	220	190-220
E, ET, A, AT	(338)	(374)	(410)	(428)	(428)	(428)	(374-428)
"SoarnoL™"	180	200	220	230	230	230	200-220
D, DT, DC	(356)	(392)	(428)	(446)	(446)	(446)	(392-428)

Screw rotation: 30 rpm

Output : 9-11 kg/hr

Resin pressure: $6.9 \sim 9.8 \text{MPa}$ (70-100 kg/cm²)

Motor load : 10-13 amp Line speed : 15-20 m/min

Film size : Width = 370-380 mm, thickness = 20-30 µm

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(2) Large-sized Equipment

Extruder : 90 mmφ 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 mmφ, mirror

Processing temperature : deg. C (deg F)

Grade	C_1	C_2	C_3	C_4	C_5	Head	Die
"SoarnoL™" E	170	190	210	220	220	220	190-220
	(338)	(374)	(410)	(428)	(428)	(428)	(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 µm

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