

General Advice on Processing of “Soarnol™”

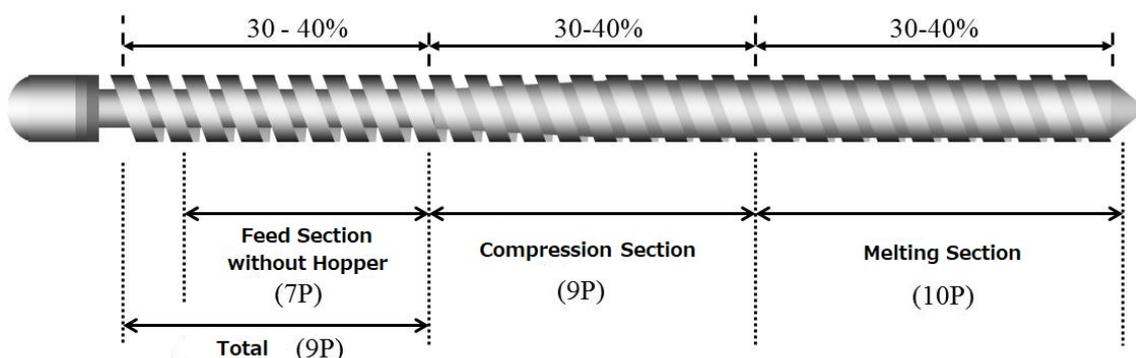
As for processing of “Soarnol™”, processing with an equipment shown below is recommended. When you use other type of equipment, please contact us accordingly.

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

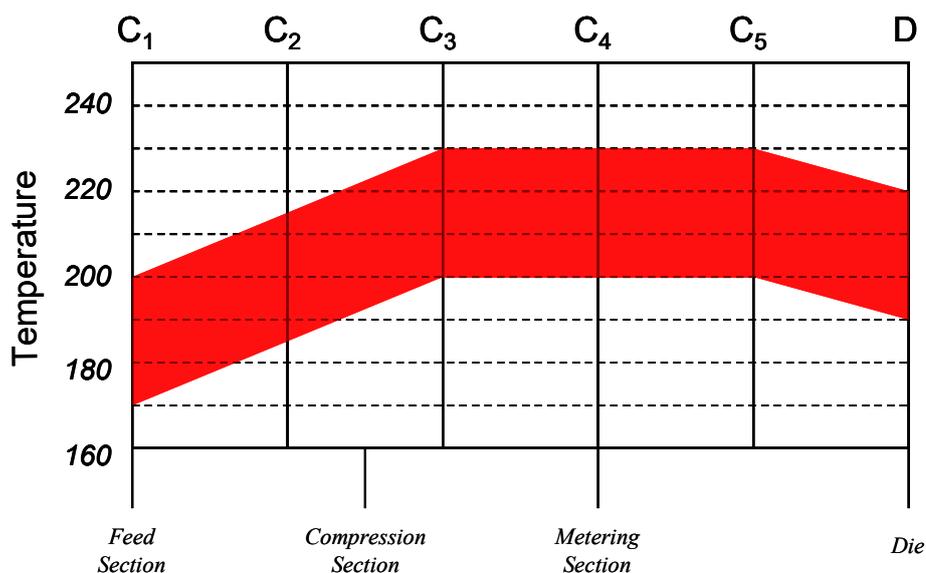
(2) Screw Design

C.R.=3.0-3.5

Plating: Chrome Plating or Nickel Alloy Plating



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



(4) Screen Pack

80/120 - 150/50 mesh

Example of Processing on “Soarnol™”

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™” 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/cm²)
 Motor load : 10-13 amp
 Line speed : 15-20 m/min
 Film size : Width = 370-380 mm, thickness = 20-30 μm

(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 (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 μm