



1373 Melt Tubing Extrusion Fluoropolymer

Standard tubing Conductive PFA

WR No : Date : Aug. Nov. 2001  
 Customer: Operator : RH

Resin	Tube 12 x 10	Tube 25.4 x 0.2	Resin	Convoluted tube
Type	Type	Type	Type	Type
Teflon® Grade Lot number MFR resin (on bag) MFR before / after by ETC Density	PFA Conductive C 980 0106NVFB02 2.3 2.46 2.19 1.49	PFA Conductive C 980 0106NVFB02 2.3 2.46 2.26 2.15 1.49	PFA Conductive C 980 (TE 5327A) 0106NVFB02 2.3	PFA Conductive C 980 (TE 5327A) 0106NVFB02 2.3 2.15 1.49

Extrusion equipment

Extruder / Screw	Reifenhäuser Ø 50 mm		Reifenhäuser Ø 50 mm	
Head	Straight Head/No breaker/No screen		Straight Head/No breaker/No screen	
Die diameter mm	30.00	50.00	Die diameter mm	35.00
Tip diameter mm	24.50	48.00	Tip diameter mm	30.00
DDR	6.63 Shear rate	8.69 Shear rate	Sealing ring mm	25.70
DRB	1.02 13.41	1.02 44.76	Sizer diameter mm	21.00

Sizer Ø, length, description

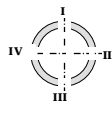
Temperatures	Set	Real	Set	Real
Barrel Zone 1 °C	300	297	300	298
Zone 2 °C	320	318	320	318
Zone 3 °C	340	338	340	339
Zone 4 °C	350	348	350	348
Clamp °C	340	339	340	340
Flange °C				
Head °C	360	360	360	360
Die Holder °C				
Die °C	380	380	380	380
Stock °C	362	Before spider	362	Before spider
Melt °C				

Line parameters	Set	Real	Set	Real
Barrel Zone 1 °C	300	297	300	297
Zone 2 °C	320	318	320	318
Zone 3 °C	340	338	340	338
Zone 4 °C	360	358	360	358
Clamp °C	350	349	350	349
Head °C	370	370	370	370
Die °C	380	380	380	380
Stock °C				
Melt °C				392

Line parameters	Set	Real	Set	Real
Screw speed RPM	9.00		6.50	
Amperage A	12.50		11.00	
Pressure Adaptor bar				
Pressure Head bar	100.00		61.00	
Cone length mm	30.00		30.00	
Total output kg/h	7.76		6.16	
Vacuum Bar	0.35		0.10	
Line speed m/min	1.70		2.70	

Tube

Tube	Real	Theoretic	Real	Theoretic
Tube weight g/m	76.20		38.40	
OD mm	12.15		25.00	
ID mm	10.12		24.55	
Wall thickness mm	1.02		0.23	
Concentricity %	93.40		91.67	
I mm	1.00		0.22	
II mm	1.06		0.24	
III mm	0.99		0.23	
IV mm	1.01		0.22	
Melt aspect	Good Melt		Good Melt	



REMARKS: Centering is more difficult with this resin