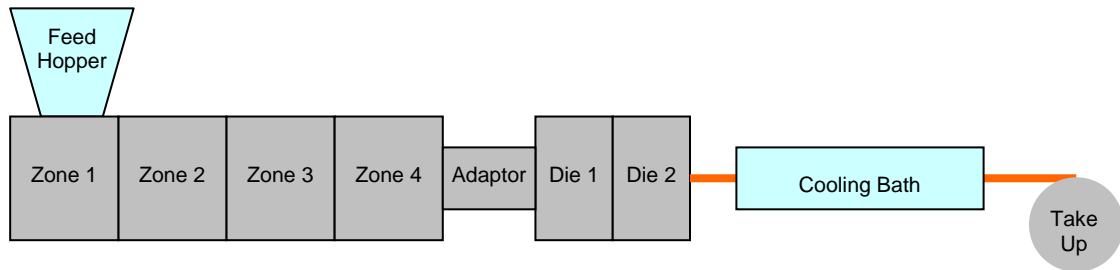


Listed below are general processing recommendations for coating wire and cable with Xtel[®] XE Series compounds. Please contact our technical service staff if you have additional questions.



Wire Coating Line Schematic

Extruder Set-Up

- 24:1 to 28:1 L/D
- 3:1 compression metering screw with straight or spiral Maddock mixing head
- 20/60/100 Screen-pack
- Rupture disk
- Heated die clamp

Cross-Head Die

- Die head suitable for low viscosity materials
- Pressure coating or tube coating acceptable

Pressure Extrusion

- Die diameter should be between 0.95 and 1.05 times the diameter of the finished wire.
- Die land lengths 0.025" to 0.080" (0.63mm to 2.0 mm) are preferred for most wire sizes.
- Gradual entry taper dies are preferred to abrupt contraction dies.

Tube Extrusion

- A draw down ratio less than 10:1 (die to wire coating cross-section) is recommended for tubing type dies.

Material Drying

- Dry at 275°F to 300°F (135°C to 150°C) for a minimum of 4 hours prior to processing.

Temperature Profile for Start-Up

Extruder Zone 1	560°F (295°C)
Extruder Zone 2	560°F (295°C)
Extruder Zone 3	560°F (295°C)
Extruder Zone 4	560°F (295°C)
Adaptor/Clamp	580°F (305°C)
Die 1	580°F (305°C)
Die 2	580°F (305°C)

Temperature Profile for Production

Extruder Zone 1	550°F (290°C)
Extruder Zone 2	560°F (295°C)
Extruder Zone 3	560°F (295°C)
Extruder Zone 4	560°F (295°C)
Adaptor	550°F (290°C)
Die 1	550°F (290°C)
Die 2	550°F (290°C)

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Processing Considerations:

Allowing sufficient extruder heating soak time on start-up is vital to ensure breaker plate and screen-packs are up to processing temperature. Cold breaker plates can result in freezing off of the extrudate at the screen-pack resulting in blocking of the extruder output and generating unacceptably high extruder pressures.

Xtel[®] XE Series compounds process better at higher extruder rates where the shear from the screw does more of the melting rather than the heaters. Extruders should be sized to run above 50% capacity for the process to generate sufficient shear heating while minimizing residence time.

Bubbles, smoke or gels are indications of the material being too hot for too long in the extruder. Temperatures may be adjusted as appropriate, but dies should not be set below 540°F (282°C). If melt temperatures need to be lowered, it is preferred to adjust the extruder temperature profile rather than lowering die temperatures.

Sustained melt temperatures above 610°F (321°C) for prolonged time periods can lead to thermal degradation of the compound on the screen-pack and result in unacceptably high extruder pressures.

Purging Procedure: Equipment used for processing Xtel[®] XE Series compounds is best purged at processing temperatures using a fractional melt flow HDPE (Marlex[®] HHM 50100). After purging with HDPE, run the extruder dry, and with the extruder and die still at temperature, break down the die and clean hot. The screw should be pulled and cleaned hot. The barrel should be cleaned hot as well.

OFF-GAS PRODUCTS PRODUCED DURING PROCESSING CAN BE IRRITANTS TO THE MUCOUS MEMBRANES, THEREFORE ADEQUATE VENTILATION IS RECOMMENDED.

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