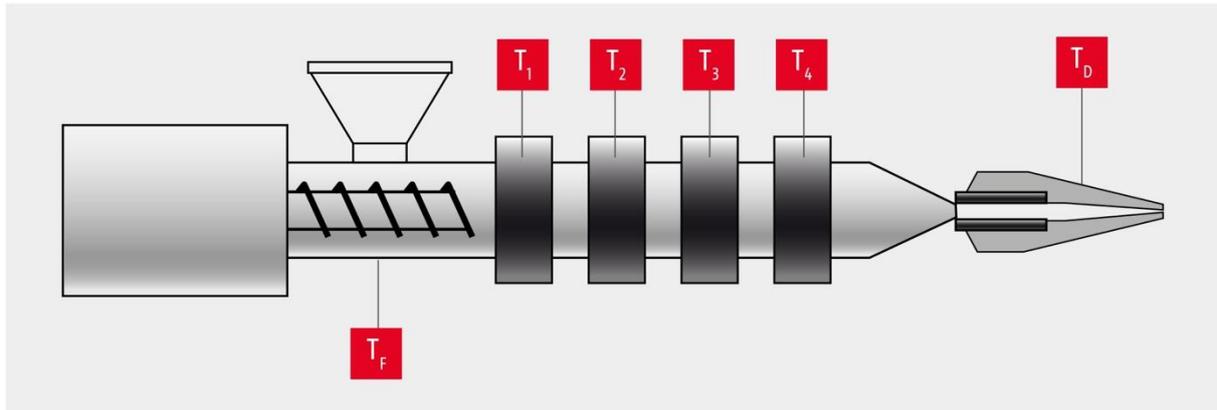


## TOPAS<sup>®</sup> 6013F-04

Cyclic Olefin Copolymer

### Processing Conditions for Extrusion



#### Processing Temperatures

$T_F$	$T_1$	$T_2$	$T_3$	$T_4$	$T_D$
20-70 °C *	230-240 °C	250-260 °C	250-260 °C	250-260 °C	230-240 °C
68-158 °F *	446-464 °F	482-500 °F	482-500 °F	482-500 °F	446-464 °F

\* for grooved feed zones:  $T_F$ : approx. 120°C / 248°F

Head Pressure	$P_{melt} > 140 \text{ bar} / 2000 \text{ psi}$ Fine screen packs as needed
Screw Speed	$n_{screw} > 50\% \text{ nominal}$
Screw Design	Multi-purpose or barrier screw w/ mixing section Screw diameter $> 60 \text{ mm} / 2.5 \text{ inch}$ Preferred L/D ratio $\geq 28:1$ where available

#### Note

This grade can be extruded on a variety of commercial cast film lines, and on blown film lines in blends or thin discrete layers. These recommendations are the preferred start-up conditions and have to be optimized on the specific extrusion line. Please contact us for further process recommendations. See our processing guide for polyolefin blends if such blends are planned.

