

Flexible Extrusion Processing Guidelines

The following is a general setup for processing Georgia Gulf PVC flexible extrusion and wire and cable compounds. **Note:** this information is supplied as a good standard starting point and depending on product, machine and die type may need to be varied or customized.

Before you begin processing; reference Georgia Gulf data sheets for the recommended melt temperature for the particular product you are using.

Screws

Georgia Gulf recommends the use of a standard 24 to 1 L/D screw with a 3 ½" inch Barrier Maddock mixer. General-purpose 24/1 L/D screws are also successfully used with compression ratios in the range of 2.5 - 3.0 to 1.

Screens

Georgia Gulf recommends using a 3-screen pack system consisting of a 40-60-40 mesh.

Temperature Profile

Georgia Gulf recommends a ramping up profile from feed section to metering section with the last zone at 10 degrees below the recommended melt temperature.

Example: For a 350 F degree melt temperature product the following set up can be used.

300F > 310F > 320F > 330F > 340F The adapter and die heats should be equal to the last zone or 10 degrees below the recommended melt temperature at 340F.

Note: If using a General Purpose single flight screw, all temperatures should be raised approximately 10 degree F.

For any problems or question concerning the processing of Georgia Gulf PVC compounds. Please call Georgia Gulf Technical Services @ **601-206-3236**