



SHAKUN POLYMERS LIMITED



PROCESSING GUIDELINES FOR ZHFR MATERIALS (THERMOPLASTIC) MATERIALS:

Shakun's EcoTek Zero Halogen Flame Retardant (ZHFR) thermoplastic compounds are Halogen free, flame retardant & will not generate toxic gases during burning.

Following is the general processing guidelines details for Shakun's ZHFR thermoplastic materials.

Drying of material:

In general pre drying of material is not required.

However, if the compound is exposed to air for a long period then it is recommended to ~~for~~ PRE-DRY the material at 65-70°C for 2 hours in a dehumidifying dryer.

Colouring of material:

For colouring use of EVA or PE based masterbatch is recommended. Predry masterbatch at 65-70°C for 2 hrs in Hot Air Oven.

Screw and Compression Ratio:

For processing ZHFR materials, the use of a Low Compression Ratio is recommended with an ideal compression ratio in the range of 1.2-1.5:1 and L/D ratio (20-24:1). For other screw designs please feel free to contact us for an opinion.

Tooling :

Pressure , semi-pressure and tube on extrusion can be used depending on the type & design of cable being manufactured.

Draw Down ratio of 1.5 to 1 is recommended as a starting point.

**SHAKUN POLYMERS LTD, 501, Ivory Terrace, R.C.Dutt Road,
Baroda-390 007. Gujarat (India)**

Phone: (0265) 2330920, 2333807, 3058384 FAX : +91 265 2339402

Web Site: www.shakunpolymers.com , E-mail: sales@shakunpolymers.com



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Temperature profile:

The following temperature profile can be used as a useful starting point.

ATH (Aluminium TriHydroxide)based compounds

ZONES (1-5)	CROSSHEAD	DIE
130°C-155°C	160°C	165°C

Melt temperature:

A melt temperature of 170°C is ideal but care should be taken not to exceed 180°C.

MDH (Magnesium DiHydroxide)based compounds

ZONES (1-5)	CROSSHEAD	DIE
145°C-195°C	200°C	210°C

Screen Pack:

A wire mesh of 40-60 can be used depending on the applications. However, in general it is not required.

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