

PROCESSING GUIDELINES FOR ZHFR CROSSLINKABLE (THERMOSET)  
MATERIALS:

**Drying of material:**

**Caution:** Not to PRE-DRY the material.

**Colouring of material:**

For colouring use Polyolefin based masterbatch only. Predry masterbatch at 65-70°C for 2 hrs in Hot Air Oven.

**Screw and Compression Ratio:**

For processing ZHFR materials, use a ZHFR Screw with Low Compression Ratio 1.2-1.5:1 and L/D ratio (20-24:1)

Screw cooling is preferred.

**Draw Down ratio:**

The Draw Down ratio recommended is 1.8:1 for Tube-On Extrusion.

**Temperature profile:**

PROCESSING TEMPERATURES recommended are as under:

ZONES	CROSSHEAD	DIE
130°C-160°C	165-170°C	175°C

**Extrusion speed:**

Start up speed should be minimum 5 rpm and during production at a minimum of 20 to 30 rpm.

**Screen Pack:**

A wire mesh of 40-60 can be used depending on the applications.

**NOTES :**

- (1) All the Mechanical Properties are tested on Extruded Tape.
- (2) The Test Results were obtained on samples taken during the time of production and/or packing of the Product using National / International Procedures.
- (3) The Buyer shall inspect the Product immediately after receipt. Failure to inform the company of any Alleged defect shall be treated as conclusive evidence that the company has satisfactorily performed its obligations and that the products have been accepted.