

» PROCESSING GUIDE

Syncure™ XLPE

GENERAL EXTRUSION GUIDELINES

Syncure™ systems are two-part, polyethylene based, moisture crosslinkable compounds for wire and cable insulation.

EXTRUDER	
Screw	1½" to 6" Polyethylene type—Maddock; 3:1 compression ratio
Tooling	Pressure type
Die	On size with 1/8" or less land
L/D	24:1 or higher
Screen Pack	20/60/60/20 Mesh
Cooling Trough	Hot 120–150° F (50–65° C)
Feeder	Gravimetric type—3 compartment (for color)
Drying Conditions, Catalyst Only	Desiccant type, 4 hours at 140° F (60° C)

PROCESSING	
Temperature	
Wire Preheat	180–250° F (110–120° C)
Feed Zones	330° F (165° C)
Transition	340° F (170° C)
Metering	350° F (177° C)
Head/ Die	360° F (182° C)
Target Melt	350–380° F (177–190°C)
Flame at Die Tip	Yes
Line Speed	Higher line speed improves mixing and surface smoothness
Purge Compound	HDPE

Graft resin cannot be dried, has a 6 month shelf life when stored unopened in a cool dry location and must be consumed after opening. Precautions: the extruder should not be idle with the material in the barrel, bleed constantly when possible. If already degraded, a complete cleanout may be needed.

To learn more about Syncure XLPE wire and cable solutions, contact us at +1.844.4AVIENT (1-844.428.4368) www.avient.com



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