

PROCESSING INFORMATION OF PVC COMPOUNDS

Please consider that PVC compound is an amorphous polymer, so it does not have a melting point. We can suggest an indicative thermal profile to apply on the equipment in order to extrude or inject the material.

Of course, the real working conditions depend on the kind of equipment (L/D ratio, diameter and configuration of the screw, etc.) so we strongly recommend to determine the related optimum working conditions “on site” as these will vary with each particular type of machine.

Granules of plasticized medical compound for extrusion:

As a general reference, typical temperatures are as follows:

	Zone 1 (Hopper End)	Zone 2	Zone 3	Die
Barrel Temperature °C	135	145	155	170

Granules of rigid medical compound for injection:

As a general reference, typical temperatures are as follows:

	Zone 1 (Hopper End)	Zone 2	Zone 3	Nozzle
Barrel Temperature °C	150	155	160	170
Injection pressure bar	120			
Back pressure bar	1-5			