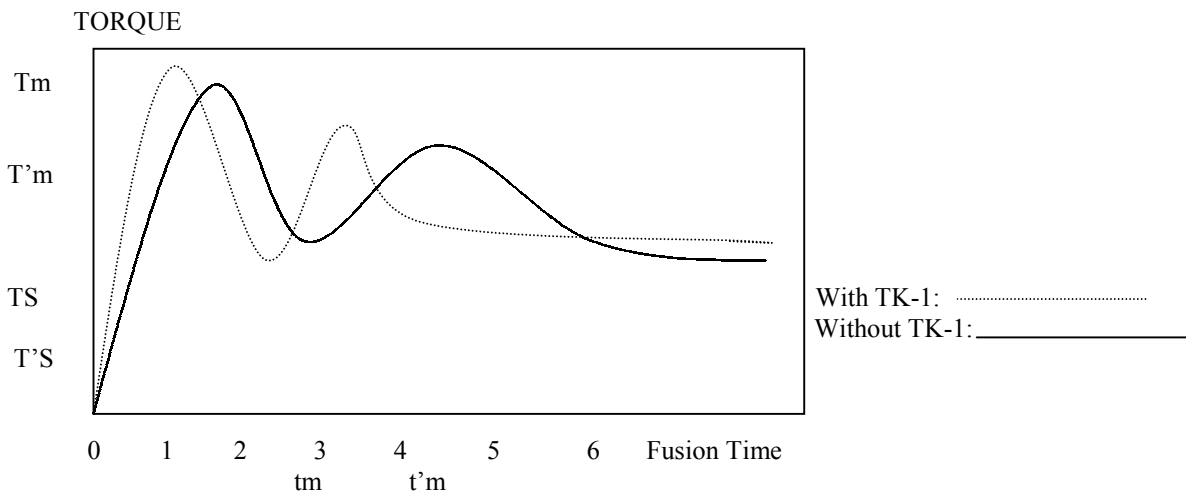


Function of TK-1 (extrusion)

1. What effect does TK-1 have on fusion or gelatinoids of a dry blend powder compound?

When the processing aid is added with TK-1, it makes the time fast in reaching the fusion time, raises the Equilibrium Torque. This means the reduction of time for fusion of mixture.



$T_m, T'm$ = Maximum Torque $T_s, T's$ = Equilibrium Torque $t_m, t'm$ = Fusion time

2. What effect does it have on the compound's melt viscosity?

The good flow properties of TK-1 is due to the highly efficient lubricants that minimize the internal and external friction of PVC particles to each other and to metal surface, to reach the ideals melting temperature of 185°C. it prevents the pinhole, air streak on the surface and melt fracture at fusion point.

3. What effect does TK-1 have on "Vacate softening"? Or "Heat Distortion" temperature of PVC compound?

It secures the excellent fusion effect and good process ability of PVC. It improves the properties of the fusion time in PVC processing.

4. During extrusion, what power consumption (Amperes) and back-pressure differences are seen with or without TK-1?

	With TK-1	Without TK-1
Amps (MD, main drive)	65% - 70% MD	75% - 95% MD
Back Pressure (KN, Kilo Newtons)	320 - 350 KN	380 - 400 KN
Production Output	30% - 50% increase for w/TK-1 over w/o TK-1	