

- ✓ Die
- ✓ Temperature and pressure controls.

❖ **Definition of terms**

Compression Ratio - is the ratio between the channel depth in the feed zone to that of the metering zone.

- Usually from 1.5 to 4:1

L/D ratio - Length to nominal dia of screw

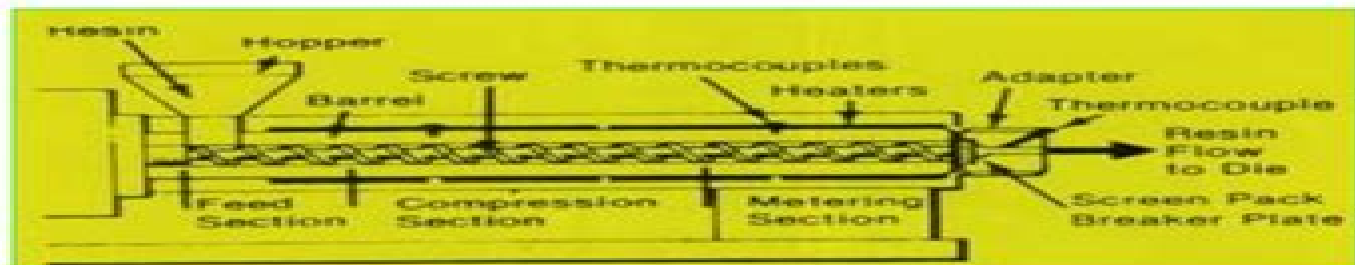
- usually 20 to 22:1

Important Specification

- ✓ Nominal dia of screw
- ✓ Output (kg/hr.)

❖ **Zones of Extruder & its Functions:**

- ✓ Feed Zone - Transport the material from hopper to compression zone.
 - Compacts, eliminates air gap
- ✓ Compression Zone - Transport the material from compression to metering zone.
 - Softens the material
- ✓ Metering zone - Melts, Mixes, the material pressurizes and pumps the melt.



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