

EXTRUSION OUTPUT RATES

RATIO L/D	COMPOUND	DENSITY	SCREW TYPE	SCREW DIAMETER																				PRESSURE AT BREAKER PLATE		MAX MELT TEMP		
				1.25 IN / 32 MM			1.50 IN / 38 MM			2.00 IN / 51 MM			2.50 IN / 63 MM			3.50 IN / 89 MM			4.50 IN / 114 MM			6.00 IN / 152 MM						
				RPM	OUTPUT/HR LBS	KG	RPM	OUTPUT/HR LBS	KG	RPM	OUTPUT/HR LBS	KG	RPM	OUTPUT/HR LBS	KG	RPM	OUTPUT/HR LBS	KG	RPM	OUTPUT/HR LBS	KG	RPM	OUTPUT/HR LBS	KG	RPM	OUTPUT/HR LBS	KG	PSI
24/1	XLPE UNFILLED	0.92	DSBM										70	150	68	55	300	136	45	490	222	35	870	393	2000-2500	146-183	280-290	138-143
			SSMM											70	120	54	55	240	109	45	390	178	35	695	295	2000-2500	146-183	280-290
24/1	XLPE 30% FILLED	1.09	DSBM										80	240	109	60	470	213	50	780	354	40	1380	626	2000-2500	146-183	280-290	138-143
			SSMM											80	190	87	60	375	171	50	625	283	40	1105	500	2000-2500	146-183	280-290
24/1	FPVC	1.35	DSBM	100	40	18	100	65	29	150	200	91	150	380	172	115	750	340	100	1230	558	80	2180	989	2000-2500	146-183	395	202
			SSMM	100	36	16	100	59	26	150	180	82	150	342	155	115	675	306	100	1100	499	80	1960	889	2000-2500	146-183	280-290	138-143
24/1	LOPE 2.0 MELT INDEX	.925	DSBM	100	30	13.6	100	55	25	140	165	75	120	250	113	90	500	227	75	630	376	60	1475	669	3500-4000	256-292	415	213
			SSMM	100	26	12	100	47	21	140	140	64	120	212	96	90	425	193	75	705	320	60	1255	569	2000-2500	146-183	280-290	138-143
24/1	NYLON	1.1	DSBM	50	40	18	150	70	32	130	130	59	110	205	93	85	410	186							3500	256		
			SSM	150	30	14	150	53	24	130	98	44	110	154	70	85	308	140							3500	256		
24/1	FEP FLURO POLYMER	2.18	SSM	50	25	11	40	40	18	30	65	29	25	100	45	20	200	91										
20/1	XLPE SEMI-CON FILLED	1.3	SSM										40	115	32	30	230	104	25	380	172		3000	2193	280-290	138-143		
20/1	ELASTOMER NITRATE	1.3-1.4	CONS. PTCH DBL. LEAD DIM. DEPTH				75	70	32	60	140	64	50	215	98	40	425	193	35	700	318	25	1200	544	4800	850	295	146
			DSB RUBBER				75	84	38	60	168	76	50	258	117	40	510	231	35	863	392	25	1440	653	4800	850	295	146

DSBM - Davis Standard Barrier Maddock
 SSMM - Single Stage Maddock Mixing
 SSM - Single Stage Metering

Notes: Outputs will vary with changes in running conditions, screw design, compounds and acceptable quality standards. Tables are intended to be used only as a guide. NO GUARANTEE of output is intended or implied. Some heat sensitive compounds will be restricted in output and screw RPM by the melt temperature. For estimates on a 20:1 L/D instead of a 24:1, reduce rate by 15%.