

SUPERNOVA

Cleaning amount needed with CONCENTRATES(*) in extrusion Equipment(**)

Single screw extruder, L/D 30

Twin screw extruder, L/D 40

Screw diameter in mm	SUPERNOVA Concentrate 25% (kg)	Polymer 75% (kg)	Total amount (kg)	Screw diameter in mm	SUPERNOVA Concentrate 25% (kg)	Polymer 75% (kg)	Total amount (kg)
40	0,20	0,60	0,80	30	0,20	0,60	0,80
50	0,35	1,05	1,40	40	0,50	1,50	2,00
60	0,60	1,80	2,40	50	0,95	2,85	3,80
70	1,00	3,00	4,00	60	1,65	4,95	6,60
80	1,50	4,50	6,00	70	2,70	8,10	10,80
90	2,00	6,00	8,00	80	3,90	11,70	15,60
100	2,80	8,40	11,20	90	5,90	17,70	23,60
120	4,80	14,40	19,20	100	7,80	23,40	31,20
150	9,50	28,50	38,00	120	13,50	40,50	54,00
200	22,50	67,50	90,00	130	17,20	51,60	68,80
				150	25,70	77,10	102,80

* This calculation is based upon material needed in regular use of SUPERNOVA (1,5 the Cylinder content). First time use of the material or extensive contamination normally requires larger amounts of material.

** In extrusion equipment the die represents a variable volume of material. Therefore the above indicated amounts must be multiplied with the following factors for different types of extrusion processes

Process	Multiplication factor
Compounding	1.0 - 1.2
Small sheet/film extruder	2.0
Large sheet/film extruder	1.5 - 1.7

Cost comparison

- Present Cleaning material :
 - Amount (kgs) needed :
 - Price/kg :
 - Material cost B X C :
 - Cleaning time (hrs) :
 - Hourly cost (machine+Labour) :
 - Machine/labour cost D X E :
 - TOTAL COST CLEANING :
- SUPERNOVA** Type :
 - Amount (kgs) needed :
 - Price/kg :
 - Material cost B X C :
 - Polymer** Type :
 - Amount (kgs) needed :
 - Price/kg :
 - Material cost E X F :
 - Cleaning time (hrs) :
 - Hourly cost (machine+labour) :
 - Machine/labour cost G X H :
 - TOTAL COST CLEANING :
 - Difference method 1 vs.2 : = %

**Engineering
Chemicals**

ENGINEERING CHEMICALS B.V.
Van Andelstraat 7
P.O.Box 59, 4650 AB Steenberg, Holland
Tel:+31(0)167 566984 Fax+31(0)167 561118
E-mail:e-chem@e-chem.nl