

SUPERNOVA

Quantities needed for cleaning

Single screw extruder, L/D 30

Twin screw extruder, L/D 40

screw diameter in mm	Quantity of SUPERNOVA (kg)		screw diameter in mm	Quantity of SUPERNOVA (kg)
40	0,80		30	0,80
50	1,40		40	2,00
60	2,40		50	3,80
70	4,00		60	6,60
80	6,00		70	10,80
90	8,00		80	15,60
100	11,20		90	23,60
120	19,20		100	31,20
150	38,00		120	54,00
200	90,00		130	68,80
			150	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

Costcomparison

- A. Current cleaning compound :.....

B. Used quantity :.....

C. Price/kg :.....

Total material cost B X C :.....

D. Cleaning time (hours) :.....

E. Cost/hour (machine+labour) :.....

Machine/labour cost cleaning D X E :.....

TOTAL COST CLEANING : €.....
- A. **SUPERNOVA** grade :.....

B. Used quantity :.....

C. Price/kg :.....

Total material cost B X C :.....

D. Cleaning time (hours) :.....

E. Cost/hour (machine+labour) :.....

Machine/labour cost cleaning D X E :.....

TOTAL COST CLEANING : €.....

Difference 1 and 2 : €..... =%

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