



Thermoplastic Elastomers. Effective compounding with highest dispersion and maximum throughput rates.

»» Individual solutions for maximum productivity. With our long-term experience and comprehensive know-how we design every process step of a compounding plant according to the used cross-linking agent and the base material. Hence processing thermoplastic elastomers allows to profit out of highest throughput rates.

Thermoplastic elastomers TPE are characterized by their elastic usage and thermoplastic processing properties. Based on the chemical-morphological structure, they are divided into TPE-S, TPE-O, TPE-E, TPE-A and TPE-V. Different methods are applied for the compounding of thermoplastic elastomers such

as pelletizing or direct extrusion in film or sheet. Numerous ZSK twin screw extruders of Coperion are worldwide successfully in operation for the processing of thermoplastic elastomers in a very wide range of forms and recipes.

01 | ZS-B TWIN SCREW SIDE FEEDER (MOBILE)

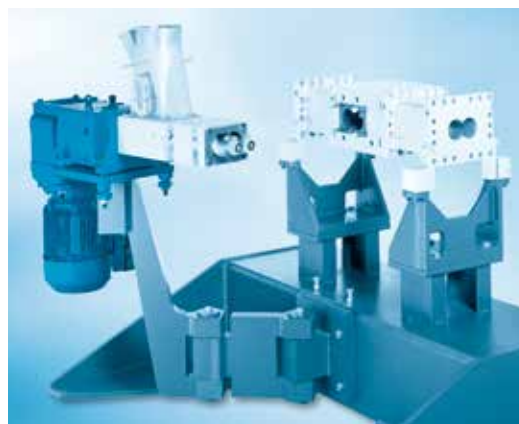
02 | ZS-B TWIN SCREW SIDE FEEDER (SWIVELLABLE)

03 | ZS-EG SIDE DEVOLATILIZATION UNIT

>01

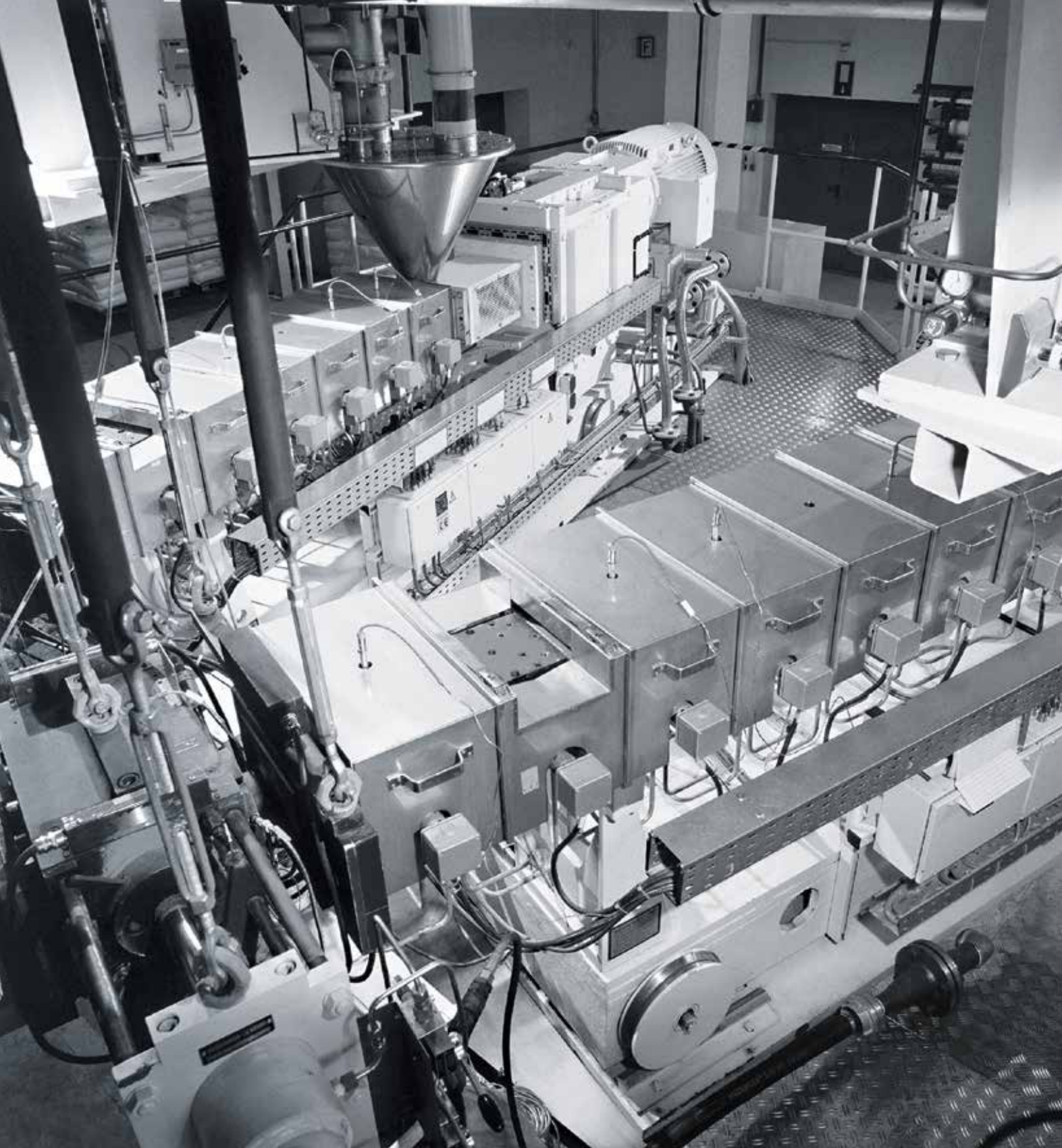


>02



>03





>TPE-O DIRECT EXTRUSION FILM PLANT

› TPE

TPE refers to elastomer alloys which consist of different quantities of thermoplastics and elastomers.

Typical process steps for the production of TPE

- › Gravimetric feeding of all recipe ingredients as a dry pre-mix
- › Alternatively: Separate gravimetric feeding of the individual components
- › Addition of softener along the process section by an injection nozzle
- › Alternatively: Feeding of mineral fillers or a portion of the thermoplastics into the process section via the ZS-B twin screw side feeder

- › Plasticizing, alloying, homogenization, mixing and dispersing
- › Degassing of volatile components by a vacuum dome or via the ZS-EG twin screw side devolatilization unit
- › Optional: Gear pump
- › Optional: Screen pack changer
- › Underwater pelletizer

Recipe ingredients

- › Elastomer: SBS, SEBS, SEPS, etc.
- › Thermoplastic: PS, PP, PE, PA, PPE etc.
- › Softener
- › Mineral fillers

› TPE-V

Thermoplastic elastomers with a cross-linking rubber component are specified as TPE-V. The cross-linking and dispersing of the EPDM as well as the addition of larger quantities of softener require twin screw extruders with a process section length at an average of $L/D = 56$. Each process section is designed individually according to the used cross-linking agent and the base material.

Typical process steps for the production of TPE-V in a single-step process

- › Gravimetric feeding of ground, powdered and conveyed EPDM into the feed barrel
- › Gravimetric feeding of additives, fillers and thermoplastics into the feed barrel
- › Gravimetric feeding of the softener at one or more points along the process section

- › Plasticizing, dispersing, cross-linking, mixing, phase reversal
- › Degassing of volatile components, preferably by a ZS-EG side devolatilization unit
- › Pressure build-up by gear pump for highly viscous melts
- › Screen pack changer
- › Underwater pelletizer

Recipe ingredients

- › PP
- › EPDM
- › Softener
- › Fillers
- › Additives, pigments
- › Cross-linking agent, accelerator, activators
- › Reclaim

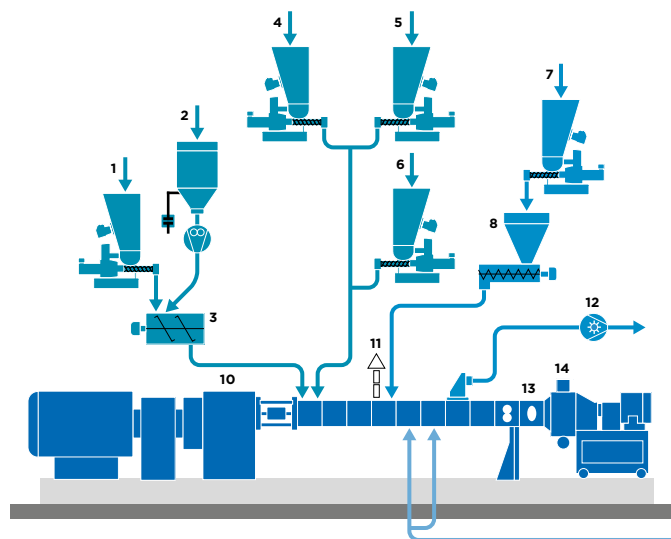
› DIRECT EXTRUSION OF TPE-O FILM

Decorative film which is used for vehicle interiors for instance, can be produced with ZSK twin screw extruders in a single-step process. The intermediate pelletizing typical for plastics and other products is omitted in this in-line compounding. This considerably reduces the investment and running costs as well as the energy requirement of the production process. The example on the right shows the production of a multilayered film of TPE-O on two twin screw extruders: One ZSK processes the base layer and the other the decorative layer. Discharge takes place through a melt filter, a gear pump and an adapter to the co-channel nozzle in which the layers are merged, followed by the transfer onto a three roll finishing calendar.

Plant data by example of two ZSK 70 Mc¹⁸

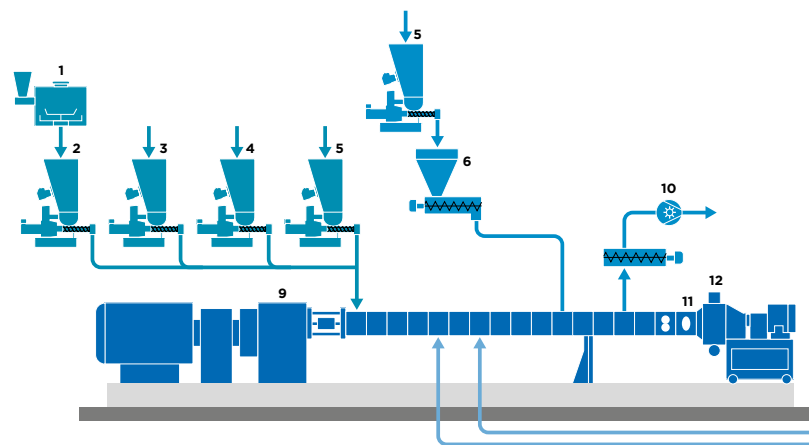
Machine data		
Screw diameter	mm	70
Number of barrel sections		8
Screw length		32 D
Operating data		
Screw speed	rpm	400
Troughput rate	kg/h	up to 700
Melt temperature	°C	230
Melt pressure	bar	up to 100
Plant data		
Sheet width	mm	up to 1,700
Sheet thickness (total)	mm	0.5 to 1.8
Take-off speed	m/min	bis 20

> TYPICAL PLANT STRUCTURE FOR THE PRODUCTION OF TPE



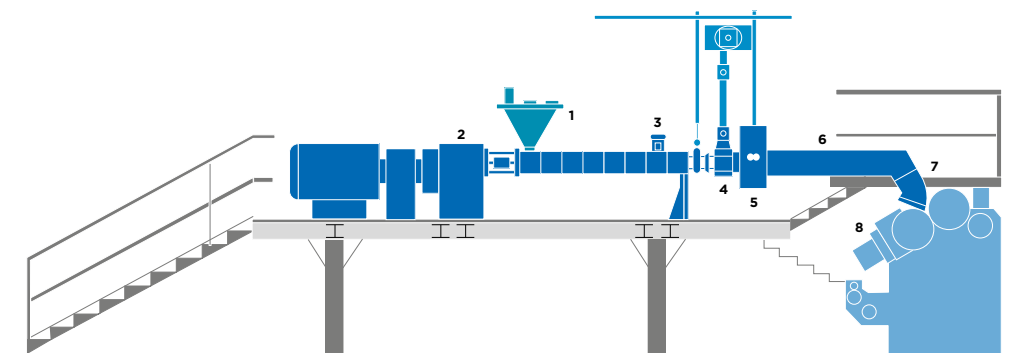
- 1 Elastomers
- 2 Softener
- 3 Continuous mixer
- 4 Thermoplastics
- 5 Fillers
- 6 Additives
- 7 Fillers or thermoplastics
- 8 Twin screw side feeder ZS-B
- 9 Alternatively: Softener
- 10 ZSK twin screw extruder
- 11 Atmospheric venting
- 12 Vacuum degassing
- 13 Screen pack changer
- 14 Underwater pelletizer

> TYPICAL PLANT STRUCTURE FOR THE PRODUCTION OF TPE-V IN A SINGLE-STEP PROCESS



- 1 Rubber mill
- 2 EPDM ground product
- 3 PP
- 4 Fillers
- 5 Additives
- 6 ZS-B twin screw side feeder
- 7 Softener, cross-linking agent
- 8 Alternatively: Softener
- 9 ZSK twin screw extruder
- 10 Vacuum degassing via ZS-B
- 11 Screen pack changer
- 12 Underwater pelletizer

> TYPICAL PLANT STRUCTURE FOR THE PRODUCTION OF TPE-O FILM



- 1 Feed hopper for taking up several components from the gravimetric feeder
- 2 ZSK twin screw extruder
- 3 Devolatilization port
- 4 Melt filter
- 5 Gear pump
- 6 Adapter
- 7 Co-channel nozzle with merger of base and decorative layers as well as a nozzle lip with heat expansion bolt for thickness adjustment
- 8 Three roll finishing calender

Coperion GmbH

Theodorstrasse 10
70469 Stuttgart, Germany
Tel.: +49 711 897-0
Fax: +49 711 897-3999

Coperion GmbH

Niederbieger Strasse 9
88250 Weingarten, Germany
Tel.: +49 751 408-0
Fax: +49 751 408-200

info@coperion.com
www.coperion.com

> Europe

Belgium, Luxembourg, Netherlands
Coperion N.V.
Industrieweg 2, 2845 Niel, Belgium
Tel.: +32 3 870-5100
Fax: +32 3 877-0710

France

Coperion S.a.r.l.
56 boulevard de Courcerin
77183 Croissy-Beaubourg, France
Tel.: +33 164 801 600
Fax: +33 164 801 599

Germany

Coperion GmbH
Germany West Office
Industriestrasse 71a
50389 Wesseling, Germany
Tel.: +49 2232 20700-10
Fax: +49 2232 20700-11

Coperion Pelletizing Technology GmbH

Heinrich-Krumm-Strasse 6
63073 Offenbach, Germany
Tel.: +49 69 989 5238-0
Fax: +49 69 989 5238-25

Coperion K-Tron Deutschland GmbH

Heinrich-Krumm-Strasse 6
63073 Offenbach, Germany
Tel.: +49 69 8300 899-0
Fax: +49 69 8300 9498

Italy

Coperion S.r.l.
Via E. da Rotterdam, 25
44122 Ferrara, Italy
Tel.: +39 0532 7799-11
Fax: +39 0532 7799-80

Coperion S.r.l.

Milan Office
Via XXV Aprile, 49
20091 Bresso (MI), Italy
Tel.: +39 02 241 049-01
Fax: +39 02 241 049-22

Russian Federation, CIS

OOO Coperion
Proezd Serebryakova 14,
Bld. 15, Office 219
129343 Moscow, Russian Federation
Tel.: +7 499 258 4206
Fax: +7 499 258 4206

Spain, Portugal

Coperion, S.L.
Balmes, 73, pral.
08007 Barcelona, Spain
Tel.: +34 93 45173-37
Fax: +34 93 45175-32

Switzerland

Coperion K-Tron (Schweiz) GmbH
Lenzhardweg 43/45
5702 Niederlenz, Switzerland
Tel.: +41 62 8857-171
Fax: +41 62 8857-180

United Kingdom

Coperion Ltd.
Coperion K-Tron Great Britain Ltd.
Unit 4, Acorn Business Park
Heaton Lane
Stockport, SK4 1AS, United Kingdom
Tel.: +44 161 209 4810
Fax: +44 161 474 0292

> Asia

China

Coperion (Nanjing) Machinery Co. Ltd.
No. 1296 Jiyin Avenue
Jiangning District
Nanjing 211106, PR China
Tel.: +86 25 5278 6288
Fax: +86 25 5261 1188

Coperion International Trading (Shanghai) Co. Ltd.

Coperion Machinery & Systems (Shanghai) Co. Ltd.
Bldg. A2, 6000 Shenzhuan Road
Dongjing Town, Songjiang District
Shanghai 201619, PR China
Tel.: +86 21 6767 9505
Fax: +86 21 6767 9108

Coperion K-Tron (Shanghai) Co. Ltd.

Building A2-A3
No. 6000 Shen Zhuan Gong Road
Songjiang District
201619 Shanghai, PR China
Tel.: +86 21 6375 7925
Fax: +86 21 6375 7930

India

Coperion Ideal Pvt. Ltd.
Ideal House, A-35, Sector 64
201307 Noida (U.P.), India
Tel.: +91 120 4299 333
Fax: +91 120 4308 583

Japan

Coperion K.K.
4F, Leaf Square Shin-Yokohama Bldg.
3-7-3, Shin-Yokohama,
Kohoku-ku Yokohama,
Kanagawa 222-0033, Japan
Tel.: +81 45 595 9801
Fax: +81 45 595 9802

Saudi Arabia

Coperion Middle East Co. Ltd.
Street # 327, Sector G, Block 2, Lot # 31
Jubail 2 Industrial City,
Kingdom of Saudi Arabia
Tel.: +966 13 510 4420
Fax: +966 13 510 4421

Singapore

Coperion Pte. Ltd.
Coperion K-Tron Asia Pte. Ltd.
8 Jurong Town Hall Road
#28-01/02/03 The JTC Summit
Singapore 609434
Tel.: +65 641 88-200
Fax: +65 641 88-203

Taiwan

Coperion (Nanjing) Machinery Co. Ltd.
Taiwan Branch Office
5F, No. 43, Alley 115
Chung San North Road Sec. 2
Taipei, Taiwan
Tel.: +886 2 2521 3580
Fax: +886 2 2521 1604

> America

South America

Coperion Ltda.
R. Arinos, 1000
RBCA - Royal Business Center
Anhanguera, Módulo 4
Parque Industrial Anhanguera
06276-032 Osasco - SP, Brazil
Tel.: +55 11 3874-2740
Fax: +55 11 3874-2757

USA, Canada, Mexico, NAFTA

Coperion Corporation
590 Woodbury Glassboro Road
Sewell, NJ 08080, USA
Tel.: +1 201 327-6300
Fax: +1 201 825-6494

Coperion Corporation Wytheville Office

196 Appalachian Drive
Wytheville, VA 24382, USA
Tel.: +1 276 228-7717
Fax: +1 276-227-7044

Coperion Corporation Houston Office

7900 North Sam Houston Pkwy, West
Suite 202
Houston, TX 77064, USA
Tel.: +1 281 449-9944
Fax: +1 281 449-4599

Coperion K-Tron Pitman, Inc.

590 Woodbury Glassboro Road
Sewell, NJ 08080, USA
Tel.: +1 856 589-0500
Fax: +1 856 589-8113

Coperion K-Tron Salina, Inc.

606 North Front Street
Salina, KS 67401, USA
Tel.: +1 785 825-1611
Fax: +1 785 825-8759

For more information about
the worldwide Coperion network,
visit www.coperion.com