

Contents

Preface	V
Acknowledgements	VII
1 Single-Screw Extrusion: Introduction and Troubleshooting ..	1
1.1 Organization of this Book	3
1.2 Troubleshooting Extrusion Processes	5
1.2.1 The Injection Molding Problem at Saturn	5
1.3 Introduction to Screw Geometry	6
1.3.1 Screw Geometric Quantitative Characteristics	8
1.4 Simple Flow Equations for the Metering Section	11
1.5 Example Calculations	15
1.5.1 Example 1: Calculation of Rotational and Pressure Flow Components	15
1.5.2 Example 2: Flow Calculations for a Properly Operating Extruder	18
1.5.3 Example 3: Flow Calculations for an Improperly Operating Extruder	18
1.5.4 Metering Channel Calculation Summary	20
Nomenclature	20
References	22
2 Polymer Materials	23
2.1 Introduction and History	24
2.1.1 History of Natural Polymers	25
2.1.2 The History of Synthetic Polymers	26
2.2 Characteristics of Synthetic Polymers	28
2.3 Structure Effects on Properties	31
2.3.1 Stereochemistry	34
2.3.2 Melting and Glass Transition Temperatures	35
2.3.3 Crystallinity	37

2.4	Polymer Production and Reaction Engineering	40
2.4.1	Condensation Reactions	40
2.4.2	Addition Reactions	43
2.5	Polymer Degradation	46
2.5.1	Ceiling Temperature	49
2.5.2	Degradation of Vinyl Polymers	51
2.5.3	Degradation of Condensation Polymers	53
	References	54
3	Introduction to Polymer Rheology for Extrusion	57
3.1	Introduction to the Deformation of Materials	57
3.2	Introduction to Basic Concepts of Molecular Size	58
3.2.1	Size Distribution Example	59
3.2.2	Molecular Weight Distributions for Polymers	60
3.3	Basic Rheology Concepts	63
3.4	Polymer Solution Viscosity and Polymer Molecular Weight	68
3.4.1	Sample Calculation of Solution Viscosity	71
3.5	Introduction to Viscoelasticity	72
3.6	Measurement of Polymer Viscosity	80
3.6.1	Capillary Rheometers	81
3.6.2	Cone and Plate Rheometers	91
3.6.3	Melt Index and Melt Flow Rate	95
3.7	Viscosity of Polymers as Functions of Molecular Character, Temperature, and Pressure	98
3.8	Historical Models for Non-Newtonian Flow	103
3.9	Power Law and Viscosity Shear Rate Dependence	105
3.9.1	Shear Stress from Newtonian to Infinite Shear	105
3.9.2	Viscosity as a Function of Shear Rate	106
3.9.3	The Power Law and Process Dissipation	107
3.9.4	Viscosity, Shear Rate, and Dissipation	107
3.9.5	Percolation in Structured Systems	110
3.9.6	Tube Flow Data and Data Analysis	110
3.9.7	Dispersion Based Power Law Constant n	112
3.9.8	Rheological Implications for Extrusion and Molding Processes	126
	Nomenclature	130
	References	133

4	Resin Physical Properties Related to Processing	137
4.1	Bulk Density and Compaction	138
4.1.1	Measurement of Bulk Density	139
4.1.2	Measuring the Compaction Characteristics of a Resin	140
4.2	Lateral Stress Ratio	143
4.2.1	Measuring the Lateral Stress Ratio	144
4.3	Stress at a Sliding Interface	146
4.3.1	The Screw Simulator and the Measurement of the Stress at the Interface	147
4.4	Melting Flux	149
4.5	Heat Capacity	151
4.6	Thermal Conductivity and Heat Transfer	153
4.7	Melt Density	154
	Nomenclature	156
	References	156
5	Solids Conveying	159
5.1	Description of the Solids Conveying Process	160
5.2	Literature Review of Smooth-Bore Solids Conveying Models	162
5.2.1	Darnell and Mol Model	165
5.2.2	Tadmor and Klein Model	166
5.2.3	Clarkson University Models	167
5.2.4	Hyun and Spalding Model	170
5.2.5	Moysey and Thompson Model	171
5.3	Modern Experimental Solids Conveying Devices	171
5.3.1	Solids Conveying Devices at Clarkson University	172
5.3.2	The Solids Conveying Device at Dow	186
5.4	Comparison of the Modified Campbell-Dontula Model with Experimental Data	196
5.4.1	Solids Conveying Example Calculation	200
5.5	Grooved Bore Solids Conveying	202
5.5.1	Grooved Barrel Solids Conveying Models	206
5.6	Solids Conveying Notes	208
	Nomenclature	211
	References	213

6	The Melting Process	217
6.1	Compression Ratio and Compression Rate	219
6.2	The Melting Process	221
6.2.1	The Melting Process as a Function of Screw Geometry	222
6.2.2	Review of the Classical Literature	227
6.2.3	Reevaluation of the Tadmor and Klein Melting Data	228
6.3	Theory Development for Melting Using Screw Rotation Physics	231
6.3.1	Melting Model for a Conventional Transition Section Using Screw Rotation Physics	232
6.3.2	Melting Models for Barrier Screw Sections	246
6.4	Effect of Pressure on Melting Rate	255
6.5	One-Dimensional Melting	256
6.5.1	One-Dimensional Melting Model	260
6.6	Solid Bed Breakup	262
6.7	Melting Section Characteristics	266
	Nomenclature	268
	References	270
7	Fluid Flow in Metering Channels	275
7.1	Introduction to the Reference Frame	275
7.2	Laboratory Observations	278
7.3	Literature Survey	282
7.4	Development of Linearized Flow Analysis	287
7.4.1	Example Flow Calculation	303
7.5	Numerical Flow Evaluation	306
7.5.1	Simulation of a 500 mm Diameter Melt-Fed Extruder	308
7.5.2	Extrusion Variables and Errors	310
7.5.3	Corrections to Rotational Flow	316
7.5.4	Simulation of the 500 mm Diameter Extruder Using F_c	321
7.6	Frame Dependent Variables	322
7.6.1	Example Calculation of Energy Dissipation	325
7.7	Viscous Energy Dissipation and Temperature of the Resin in the Channel	326
7.7.1	Energy Dissipation and Channel Temperature for Screw Rotation	332
7.7.2	Energy Dissipation and Channel Temperature for Barrel Rotation	336

7.7.3	Temperature Increase Calculation Example for a Screw Pump	337
7.7.4	Heat Transfer Coefficients	342
7.7.5	Temperature Calculation Using a Control Volume Technique	343
7.7.6	Numerical Comparison of Temperatures for Screw and Barrel Rotations	346
7.8	Metering Section Characteristics	348
	Nomenclature	350
	References	354
8	Mixing Processes for Single-Screw Extruders	359
8.1	Common Mixing Operations for Single-Screw Extruders	360
8.1.1	Common Mixing Applications	361
8.2	Dispersive and Distributive Mixing Processes	363
8.3	Fundamentals of Mixing	365
8.3.1	Measures of Mixing	366
8.3.2	Experimental Demonstration of Mixing	368
8.4	The Melting Process as the Primary Mechanism for Mixing	376
8.4.1	Experimental Analysis of the Melting and Mixing Capacity of a Screw	379
8.4.2	Mixing and Barrier-Flighted Melting Sections	382
8.5	Secondary Mixing Processes and Devices	383
8.5.1	Maddock-Style Mixers	384
8.5.2	Blister Ring Mixers	393
8.5.3	Spiral Dam Mixers	395
8.5.4	Pin-Type Mixers	396
8.5.5	Knob Mixers	397
8.5.6	Gear Mixers	398
8.5.7	Dynamic Mixers	399
8.5.8	Static Mixers	401
8.6	Mixing Using Natural Resins and Masterbatches	408
8.7	Mixing and Melting Performance as a Function of Flight Clearance	409
8.8	High Pressures During Melting and Agglomerates	410
8.9	Effect of Discharge Pressure on Mixing	410
8.10	Shear Refinement	411
8.11	Direct Compounding Using Single-Screw Extruders	413
	Nomenclature	414
	References	416

9	Scaling of Single-Screw Extrusion Processes	421
9.1	Scaling Rules	422
9.2	Engineering Design Method for Plasticating Screws	423
9.2.1	Process Analysis and Simulations	427
9.3	Scale-Up from a 40 mm Diameter Extruder to an 80 mm Diameter Machine for a PE Resin	427
9.4	Rate Increase for an 88.9 mm Diameter Extruder Running a HIPS Resin	431
	Nomenclature	438
	References	439
10	Introduction to Troubleshooting the Extrusion Process	441
10.1	The Troubleshooting Process	442
10.2	Hypothesis Setting and Problem Solving	445
10.2.1	Case Study for the Design of a New Resin	446
10.2.2	Case Study for a Surface Blemish	448
10.2.3	Case Study for a Profile Extrusion Process	449
10.3	Equipment and Tools Needed for Troubleshooting	450
10.3.1	Maddock Solidification Experiment	452
10.4	Common Mechanical Problems	453
10.4.1	Flight Clearance and Hard Facing	454
10.4.2	Barrel and Screw Alignment	456
10.4.3	Extruder Barrel Supports	457
10.4.4	First-Time Installation of a Screw	459
10.4.5	Screw Breaks	460
10.4.6	Protection from High-Pressure Events	462
10.4.7	Gearbox Lubricating Oil	464
10.4.8	Particle Seals and Viscoseals	464
10.4.9	Screw Cleaning	466
10.5	Common Electrical and Sensor Problems	467
10.5.1	Thermocouples	467
10.5.2	Pressure Sensors	467
10.5.3	Electronic Filters and Noise	469
10.6	Motors and Drive Systems	470
10.6.1	Motor Efficiencies and Power Factors	473
10.7	Typical Screw Channel Dimensions	474
10.8	Common Calculations	474
10.8.1	Energy Dissipated by the Screw	475
10.8.2	Screw Geometry Indices	476

10.9	Barrel Temperature Optimization	477
10.10	Screw Temperature Profile	481
10.11	The Screw Manufacturing and Refurbishing Process	490
10.12	Injection-Molding Plasticators	498
10.12.1	Calculations for Injection-Molding Plasticators	500
10.13	New Equipment Installations	500
10.13.1	Case Study: A Large Diameter Extruder Purchase	504
10.13.2	Case Study: Extruder and Line Purchase for a New Product	505
10.13.3	A High-Density Foamed Sheet Product	506
10.13.4	Summary for New Equipment Installations	508
	Nomenclature	509
	References	511
11	Contamination in the Finished Product	515
11.1	Foreign Contaminants in the Extrudate	515
11.1.1	Melt Filtration	516
11.1.2	Metal Fragments in the Extrudate	521
11.1.3	Gas Bubbles in a New Sheet Line	521
11.2	Gels in Polyolefin Resins	522
11.2.1	Protocols for Gel Analysis	524
11.3	Resin Decomposition in Stagnant Regions of a Process	529
11.3.1	Transfer Lines	530
11.4	Improper Shutdown of Processing Equipment	533
11.5	Equipment Purging	534
11.6	Oxygen Exclusion at the Hopper	536
11.7	Flight Radii Size	537
11.8	Drying the Resin	540
11.9	Color Masterbatches	541
11.10	Case Studies for Extrusion Processes with Contamination in the Product	542
11.10.1	Intermittent Crosslinked Gels in a Film Product	542
11.10.2	Small Gels in an LLDPE Film Product	548
11.10.3	Degassing Holes in Blow-Molded Bottles	551
11.11	Contamination in Injection-Molded Parts	554
11.11.1	Splay Defects for Injection-Molded Parts	554
11.12	Injection-Molding Case Studies	557
11.12.1	Injection-Molded Parts with Splay and Poor Resin Color Purge	557

11.12.2	Black Color Streaks in Molded Parts: Case One	561
11.12.3	Black Streaks in Molded Parts: Case Two	566
11.12.4	Silver Streaks in a Clear GPPS Resin Injection-Molded Packaging Part	570
11.12.5	The Injection-Molding Problem at Saturn	577
11.13	Gels Caused by a Poorly Designed Transfer Line	578
11.14	The Incumbent Resin Effect	580
	Nomenclature	581
	References	582
12	Flow Surging	585
12.1	An Overview of the Common Causes for Flow Surging	586
12.1.1	Relationship Between Discharge Pressure and Rate at the Die	586
12.2	Troubleshooting Flow Surging Processes	587
12.3	Barrel Zone and Screw Temperature Control	588
12.3.1	Water- and Air-Cooled Barrel Zones	589
12.4	Rotation- and Geometry-Induced Pressure Oscillations	590
12.5	Gear Pump Control	592
12.6	Solids Blocking the Flow Path	595
12.7	Case Studies for Extrusion Processes That Flow Surge	595
12.7.1	Poor Barrel Zone Temperature Control	595
12.7.2	Optimization of Barrel Temperatures for Improved Solids Conveying	598
12.7.3	Flow Surging Due to High Temperatures in the Feed Section of the Screw	600
12.7.4	Flow Surging Due to High Temperatures in the Feed Casing ..	607
12.7.5	Flow Surging Due to a Poorly Designed Barrier Entry for GPPS Resin	609
12.7.6	Solid Blockage at the Entry of a Spiral Mixer	612
12.7.7	Flow Surging Caused by a Worn Feed Casing and a New Barrel ..	618
12.7.8	Flow Surging for a PC Resin Extrusion Process	627
	Nomenclature	631
	References	632
13	Rate-Limited Extrusion Processes	635
13.1	Vent Flow for Multiple-Stage Extruders	637
13.2	Screw Wear	639
13.3	High-Performance and Barrier Screws for Improved Rates	641

13.4	Case Studies That Were Rate Limited	641
13.4.1	Rate Limitation Due to a Worn Screw	641
13.4.2	Rate Limitation Due to Solid Polymer Fragments in the Extrudate	642
13.4.3	Rate Limited by the Discharge Temperature for a Pelletizing Extruder	647
13.4.4	Large Diameter Extruder Running PS Resin	655
13.4.5	Rate Limited by Discharge Temperature and Torque for Starch Extrusion	658
13.4.6	Vent Flow for a Two-Stage Screw Running a Low Bulk Density PS Feedstock	661
13.4.7	Increasing the Rate of a Large Part Blow-Molding Process	664
	Nomenclature	668
	References	668
14	Barrier and High-Performance Screws	671
14.1	Barrier Screws	673
14.2	Wave Dispersion Screws	679
14.2.1	Double Wave Screw	679
14.2.2	Energy Transfer Screws	681
14.2.3	Variable Barrier Energy Transfer Screws	687
14.2.4	Distributive Melt Mixing Screws	691
14.2.5	Fusion Screws	695
14.3	Other High-Performance Screw Designs	696
14.3.1	Stratablend Screws	696
14.3.2	Unimix Screws	698
14.4	Calculation of the Specific Rotation Rate	699
	Nomenclature	700
	References	700
15	Melt-Fed Extruders	703
15.1	Simulation Methods	703
15.2	Compounding Processes	704
15.2.1	Common Problems for Melt-Fed Extruders on Compounding Lines	707
15.3	Large-Diameter Pumping Extruders	707
15.3.1	Loss of Rate Due to Poor Material Conveyance in the Feed Section	717

15.3.2	Operation of the Slide Valve	719
15.3.3	Nitrogen Inerting on Vent Domes	720
15.4	Secondary Extruders for Tandem Foam Sheet Lines	720
15.4.1	High-Performance Cooling Screws	724
	Nomenclature	728
	References	728
	Appendix A1	
	Polymer Abbreviation Definitions	731
	Appendix A3	
	Rheological Calculations for a Capillary Rheometer and for a Cone and Plate Rheometer	733
A3.1	Capillary Rheometer	733
A3.2	Cone and Plate Rheometer	737
	References	739
	Appendix A4	
	Shear Stress at a Sliding Interface and Melting Fluxes for Select Resins	741
A4.1	Shear Stress at a Sliding Interface for Select Resins	741
A4.2	Melting Fluxes for Select Resins	745
	References	748
	Appendix A5	
	Solids Conveying Model Derivations and the Complete LDPE Solids Conveying Data Set	751
A5.1	Channel Dimensions, Assumptions, and Basic Force Balances	751
A5.2	Campbell-Dontula Model	753
A5.2.1	Modified Campbell-Dontula Model	754
A5.3	Hyun-Spalding Model	756
A5.4	Yamamuro-Penumadu-Campbell Model	758
A5.5	Campbell-Spalding Model	760
A5.6	The Complete Dow Solids Conveying Data Set	760
	References	765

Appendix A6	
Melting Rate Model Development	767
A6.1 Derivation of the Melting Performance Equations for a Conventional Channel	767
A6.2 Effect of Static Pressure on Melting	778
References	778
Appendix A7	
Flow and Energy Equation Development for the Metering Channel	779
A7.1 Transformed Frame Flow Analysis	779
A7.1.1 <i>x</i> -Directional Flow	781
A7.1.2 <i>z</i> -Directional Flow	782
A7.1.3 <i>z</i> -Directional Flow for Helix Rotation with a Stationary Screw Core and Barrel	788
A7.1.4 <i>z</i> -Directional Flow Due to a Pressure Gradient	790
A7.2 Viscous Energy Dissipation for Screw Rotation	795
A7.2.1 Viscous Energy Dissipation for Screw Rotation: Generalized Solution	795
A7.2.2 Viscous Energy Dissipation for Screw Rotation for Channels with Small Aspect Ratios ($H/W < 0.1$)	801
A7.3 Viscous Energy Dissipation for Barrel Rotation	803
A7.3.1 Viscous Energy Dissipation for Barrel Rotation: Generalized Solution	804
A7.3.2 Viscous Energy Dissipation for Barrel Rotation for Channels with Small Aspect Ratios ($H/W < 0.1$)	807
References	808
Author Index	809
Subject Index	817