Contents

Preface ..... **V**

The Authors ..... **VII**

The Editor VII

The Coauthors VIII

1 Functional Zones in the Extruder **1**

1.1 Transport of Solids into and in the Extruder, Feed Limits 1

1.1.1 Characteristic Values and Calculation Possibilities 2

1.1.2 Feed Limitations 8

1.1.2.1 Granulates 8

1.1.2.2 Powder 9

1.1.2.3 Flakes 11

1.1.2.4 Low-Melting Components 11

1.2 Melting of Thermoplastics 12

1.2.1 Tasks of the Melting Zone 12

1.2.2 Screw Elements and Screw Configuration 13

1.2.3 Measuring Techniques 14

1.2.4 Essential Steps of Melting 16

1.2.5 Calculation Models 18

1.3 Mixing and Dispersion 23

1.3.1 Overview, Principles, and Experiments 23

1.3.1.1 Distributive Mixing – Mixing in Laminar Flow 23

1.3.1.2 Dispersive Mixing 29

1.3.1.3 Determining the Mixing Quality 36

1.3.1.4 Symbols Used in Section 1.3.1 38

1.3.2 Three-Dimensional Calculations of Mixing and Residence Time Behavior 40

1.3.2.1 Summary 48

1.4 Devolatilization of Polymer Melts 49
1.4.1 Phase Interfaces and Surface Renewal 49
1.4.1.1 Liquid Distribution and Degree of Filling 49
1.4.1.2 Devolatilization Times 62
1.4.2 Concentration in the Devolatilization Zone 70
1.4.2.1 Influence of Dimensionless Groups 70
1.4.2.2 Bubble-Free Liquids 71
1.4.2.3 Influence of Surface Expansion by Bubbles 76
1.4.3 Design of the Devolatilization Zone 76
1.4.4 Numerical Simulation of Film Degassing 79

2 Scale-up and Scale-down 87

2.1 Introduction and Basis Rules for Thermally Sensitive Products 87
2.1.1 Dissimilarity 88
2.1.2 Comparison of Production Machines 88
2.1.3 Scale-down and Ways of Design 89
2.1.3.1 Product Temperature 90
2.1.3.1.1 Product Cooling via the Housing Wall 91
2.1.3.1.2 Temperature Change by a Pressure Difference 92
2.1.3.1.3 Temperature Increase by Power Input 93
2.1.3.1.4 Thermal Product Degradation 94
2.1.3.1.5 Temperature Increase and Internal Friction . . 96
2.1.3.1.6 Relevance of the Shear Rate 97
2.1.3.1.7 Basis Rules for Scale-up/down 99
2.1.3.1.8 Basis Equations for the Examples 99
2.1.4 Summary/Prospects 104

2.2 Scale-up and Scale-down by Model Laws 106
2.2.1 Basic Problem 106
2.2.2 Simple Scaling Approach 107
2.2.3 Model-Based Scaling Approach 108
2.2.3.1 Model Theory 108
2.2.3.2 Model Exponents 118
2.2.3.2.1 Lengths Exponent 118
2.2.3.2.2 Screw Speed Exponent 119
2.2.3.2.3 Channel Depths Exponent 120
2.2.3.2.4 Pitch Exponent 120
2.2.3.2.5 Relationship between Channel Depths Exponent, Selected Boundary Condition, and Resulting Throughput 120
2.2.3.3 Heat Flows via the Barrel 122
2.2.4 Experimental Results 123

2.3 Scale-up and Scale-down with Characteristic Numbers 126
2.3.1 Characteristic Numbers of the Whole Machine 127
2.3.1.1 Dimensionless Throughput 127
2.3.1.2 Specific Energy Input 128
2.3.2 Geometric Scale Transfer 128
2.3.2.1 Geometrically Similar Machines 128
2.3.2.2 Extruder Speed and Torque 129
2.3.2.3 Scale Transfer with Different Geometries 130
2.3.2.3.1 Partially Filled Zones 130
2.3.2.3.2 Pressure Buildup 133
2.3.2.4 Dimensional Analysis for Real Product Behavior 134
2.3.2.4.1 Influence of Non-Newtonian Behavior of the Liquid 134
2.3.2.4.2 Temperature Distribution in the Fluid 135
2.3.2.4.3 Influence of Varying Temperature on Viscosity 136
2.3.2.5 Simple Example of a Scale-up 137

3 Machine Technology 139

3.1 ZSK Series and Applications 139
3.1.1 Development up to High Torques, Volumes, and Rotations 139
3.1.2 Torque- and Volume-Limited Throughputs 143
3.1.3 Examples of Applications for the Plastics Industry 145
3.1.3.1 High Torque for Glass Fiber Reinforcement of Plastics 145
3.1.3.2 High Torque for Film Extrusion of Non-Dried PET or PLA 147
3.1.3.3 High Torque with Previously Volume-Limited Applications 147
3.1.3.4 Processing of Temperature- and Shear-Sensitive Products 149
3.1.3.4.1 Compounding and Pelletizing of PVC-P and PVC-U 149
3.1.3.4.2 Compounding of Thermoplastic Elastomers . . 150
3.1.4 Examples of Applications for the Chemical Industry 152
3.1.4.1 Adhesive and Sealing Materials 152
3.1.4.1.1 Continuous Manufacture of Adhesive Materials 152
3.1.4.1.2 Continuous Manufacture of Sealing Materials 154
3.1.4.2 Chemical Reactions in Twin-Screw Extruders 155
3.1.4.2.1 Manufacture of Thermoplastic Polyurethane (TPU) 155
3.1.4.2.2 Peroxidic Degradation of Polypropylenes 156

3.2 Barrel Units 156
3.2.1 Introduction 156
3.2.2 Design Types 157
3.2.2.1 Tie Rod Version for ZSK 18 - 54 157
3.2.2.2 Flange Version for ZSK 58 - 320 158
3.2.2.3 Clamp Version for ZSK 350 - 420 158
3.2.3 Variants 159
3.2.3.1 Closed Screw Barrel 159
3.2.3.2 Closed Screw Barrel with Bore 159
3.2.3.3 Open Screw Barrel 160
3.2.3.4 Combination Screw Barrel 160
3.2.3.5 Special Forms 160
3.2.4 Wear/Corrosion Protection 161
3.2.4.1 Solid Barrels: Nitrided or Through-Hardened 161
3.2.4.2 Barrel with Liner (Oval Bushing) 161
3.2.4.3 Directly Coated Screw Barrels 162
3.2.5 Heating of Screw Barrels 162
3.2.5.1 Heating Cartridges 162
3.2.5.2 Heater Shells, Heater Plates 163
3.2.6 Cooling and Tempering 163
3.2.6.1 One Cycle 163
3.2.6.2 Two Cycles 164

3.3 Increasing the Twin-Screw Extruder's Availability Using Targeted Material Selection for Components that Come into Contact with Product 164
3.3.1 Introduction 164
3.3.2 Wear Phenomena in Twin-Screw Extruders in Practice 165
3.3.2.1 Abrasive Wear 166
3.3.2.2 Adhesive Wear 169
3.3.2.3 Corrosion 171
3.3.3 Measurement and Assessment of Wear Parameters 173
3.3.3.1 Measuring Resistance to Abrasive Wear 174
3.3.3.2 Measurement of Adhesive Wear 175
3.3.3.3 Measuring Corrosion 176
3.3.4 Design Forms and Materials for Extruder Housings and Screw Elements 177
3.3.4.1 Housing Design Forms 177
3.3.4.2 Screw Element Design Forms 178
3.3.4.3 Material Design of Extruder Housings and Liners 181
3.3.4.4 Material Design of Screw Set Elements 185
3.3.5 Outlook 187

3.4 Dynamic Structural Analysis of Twin-Screw Extruders and Single-Screw Discharge Extruders 188
3.4.1 Structural Model Description 188
3.4.2 Vibration Analysis on a ZSK 189
3.4.3 Optimizing Single-Shaft Extruders 195
3.4.4 Structural Vibration Engineering Design 198
3.4.5 Summary 203
3.5 Measurement Technology and Process-Integrated Quality Assurance 204
3.5.1 Metrological Basics 204
3.5.2 Measuring Pressure and Temperature 205
3.5.2.1 Temperature 205
3.5.2.2 Pressure 207
3.5.3 Rheological Measurement Technology 210
3.5.3.1 Laboratory Rheometers 210
3.5.3.2 Process Rheometers 211
3.5.4 Color Measurement 213
3.5.5 Customized Systems 213
3.5.5.1 Ultrasonic Measurement Technology 214
3.5.5.2 Model Predictive Control and Virtual Sensors 214

4 Applications of Co-Rotating Twin-Screw Extruders 217

4.1 Compounding in Practice 217
4.1.1 Throughput Limitation 217
4.1.1.1 Torque Limitation 218
4.1.1.2 Volume Limitation 218
4.1.1.3 Further Limitations 218
4.1.1.4 Limitation by Peripherals 219
4.1.2 Premixing 220
4.1.3 Melt Degassing 221
4.1.3.1 Influencing Factors 221
4.1.3.2 Technical Design 222
4.1.4 Strand Die Head 224
4.1.5 Process Control 225
4.1.5.1 Process Monitoring 225
4.1.5.2 Caution, Trap! 226
4.1.6 Extruder Screws 226
4.1.6.1 Screw Design 226
4.1.6.2 Wear 227
4.1.7 Scale-up 227
4.1.7.1 The Ideal Case 227
4.1.7.2 Reality 228

4.1.7.3 Special Features of New Developments 229
4.1.7.4 Conclusion 229
4.1.8 Simulation 229
4.2 Color Masterbatches 230
4.2.1 Basic Process Idea 231
4.2.2 Materials 232
4.2.2.1 Pigments 233
4.2.2.1.1 Color Index and Particle Sizes: Pigments at First Glance 235
4.2.2.1.2 Qualitative Description of the Dispersion Quality in a Masterbatch 236
4.2.2.1.3 Dispersion Properties of Organic Pigments . . . 237
4.2.2.1.4 Correlation between Dispersion Properties and Process Parameters 238
4.2.2.2 Complex Tasks 239
4.2.2.2.1 Effect Pigments 239
4.2.2.2.2 Organic Pigments with Different Dispersion Characteristics 240
4.2.2.3 Selection of the Polymer 240
4.2.2.4 Additives and Dispersing Agents 241
4.2.3 Mixing 242
4.2.3.1 Gravity Mixer 242
4.2.3.2 Low-Speed Stationary or Mobile (Container) Mixer 242
4.2.3.3 High-Speed Stationary or Mobile (Container) Mixer 243
4.2.3.4 Application Example: Production of Blends for Masterbatch in the Hot Process for Staple Fiber and Film Quality 243
4.2.4 Dosing 244
4.2.5 Extruder 244
4.2.5.1 Premix 245
4.2.5.2 Split-Feed 246
4.2.5.3 Downstream Units 247
4.2.5.4 Process Parameters 248
4.2.6 Quality Determination 248
4.2.6.1 Color Measurement 249
4.2.6.2 Filter Pressure Test 250
4.2.6.3 Agglomerates and Gel Particles 251
4.3 Preparation of TPV by Dynamic Vulcanization on Co-Rotating Twin-Screw Extruders 252
4.3.1 Classification of TPE 252
4.3.2 Preparation of TPV Based on EPDM/PP 252

4.3.2.1 Basic Raw Materials for TPV (EPDM/PP) 253
4.3.2.2 Curing Agents 254
4.3.2.3 Manufacturing Process for TPV (EPDM/PP) 254
4.3.2.4 The Challenge of Dwell Time 256
4.3.2.5 Properties of TPV (EPDM/PP) 258
4.3.3 TPV Based on Renewable Raw Materials ("Bio-TPV") 258
4.3.3.1 Basic Raw Materials for Bio-TPV 258
4.3.3.2 Production Process for Bio-TPV 259
4.3.3.3 Properties of Bio-TPV 260
4.4 Devolatilization of Polymer Melts Using Co-Rotating Twin-Screw Extruders 263
4.4.1 Devolatilization Tasks 263
4.4.2 Design of Devolatilizing Extruders 265
4.4.2.1 Material Feeding and Flash Devolatilization 267
4.4.2.2 Staggered Vacuums 269
4.4.2.3 Fill Level 270
4.4.2.4 Residual Devolatilization and Use of Stripping Agents .. 271
4.4.2.5 Design of Extruder and Devolatilization Sections 276
4.4.3 Scale-up of Devolatilization Extruders 279
4.4.4 Process Examples 281
4.4.4.1 Devolatilization of Solvents from LLDPE Melt Solutions 281
4.4.4.2 Devolatilizing Solvents from Synthetic Rubber (Styrene-Butadiene Compounds) 282
4.4.4.3 Devolatilizing Vinyl Acetate from LDPE/EVA Copolymer 282
4.4.4.4 Devolatilization of POM 283
4.4.4.5 Devolatilization of PC 284
4.4.4.6 Devolatilization of PMMA 284
4.4.4.7 Devolatilization of PES and PSU 285
4.4.4.8 Devolatilization of ABS 287
4.4.4.9 Devolatilization of Non-Dried PET 287
4.4.5 Summary 289
4.5 Reactive Extrusion 290
4.5.1 Introduction 290
4.5.2 Influence of Parameters Using Selected Application Examples .. 291
4.5.2.1 Activated Anionic Polymerization of Lactams 293
4.5.2.2 Polymerization of Acrylates 294
4.5.2.3 Ring-Opening Polymerization of ε-Caprolactone 296
4.5.3 Economically Relevant Example: Thermoplastic Polyurethane ... 297
4.5.4 Modeling 299
4.5.5 Scale-up 301
4.6 Food Extrusion 304

4.6.1 Extrusion of Breakfast Cereals 307
4.6.1.1 Raw Materials and Mixing 309
4.6.1.2 Preconditioning and Extrusion 313
4.6.1.3 Short-Time Tempering and Flaking 318
4.6.1.4 Roasting, Spraying, and Drying 321
4.6.2 Products 323
4.6.3 Food Safety in Food Extrusion 325
4.6.4 Summary 328
4.6.5 List of Abbreviations 329
4.7 Extrusion of Pharmaceutical Masses 331
4.7.1 Introduction 331
4.7.2 Fundamentals of Melt Extrusion 331
4.7.3 Machine Design 332
4.7.4 System Layout 334
4.7.5 Containment Requirements 339
4.7.6 Summary and Outlook 339

Index 341