

Contents

The Authors	V
In Memoriam	IX
Preface	XI
PART A Introduction to the Processing of Polymers	1
1 Introduction	3
<i>Klemens Kohlgrüber, Michael Bierdel</i>	
1.1 Plastics and Their Importance	3
1.2 Processing and Compounding	4
1.3 Recycling of Plastics	5
1.4 Guide to the Individual Chapters of this Book	7
2 Polymer Processing – Process Technology of Polymer Production	9
<i>Klemens Kohlgrüber</i>	
2.1 Introduction	9
2.2 Polymer Processing during the Polymer Synthesis in the Primary Production	14
2.3 Polymer Processing after the Polymer Production – Compounding	17
2.3.1 Main Temperature Window when Compounding for Finish Mixture	18
2.3.2 Mixing in the Extruder	19
2.3.3 Temperature and Time Limits for Compounding	22
2.3.4 Challenges when Compounding	25
2.3.5 Energy Requirement when Compounding	28
2.3.6 Range of Performance of Extruder	32
2.3.7 Throughput and Performance Density	35

2.3.8	Performance Density in the Melt Area	39
2.3.9	Energy Balance and Product Discharge Temperature	40
2.3.10	Static Mixers	46
2.3.11	Mixing Performance, Mixing Quality, Cross Mixing, Longitudinal Mixing	49
2.3.11.1	Mixing Performance	49
2.3.11.2	Mixing Performance and Mixing Quality	51
2.3.11.3	Cross and Longitudinal Mixing	53
2.3.11.4	Residence Time Distribution	54
2.3.11.5	Mean Residence Time	58
PART B Processing in Polymer Production		61
3	Devolatilizing Devices	63
3.1	Fundamentals of Devolatilization	63
	<i>Heino Thiele</i>	
3.1.1	Phase Equilibrium	65
3.1.2	Macroscopic Mass and Energy Balance	68
3.1.3	Quantities Influencing the Change in Concentration	69
3.1.4	General Conclusions	79
3.2	Polymer Production and Degassing Tasks	81
	<i>Klemens Kohlgrüber</i>	
3.2.1	General Challenges at the Degassing of Volatiles from Polymers	82
3.2.2	Special Features at the Degassing of Polymers with High Content of Volatiles and Limitation of Finish Degassing ..	83
3.3	Overview of Devices and Machines for Compounding with Polymer Degassing	84
	<i>Klemens Kohlgrüber</i>	
3.3.1	Introduction	84
3.3.2	Devices with Rotating Components and Machines	86
3.4	Apparatus-Based Polymer Evaporation	90
	<i>Klemens Kohlgrüber</i>	
3.4.1	Tube Evaporator	91
3.4.2	Process and Devices for Finish Degassing for Very Low Residual Contents in the Polymer	98
3.4.3	General Scheme of an Apparatus-Based Evaporation Stage	103
3.4.4	Product Quality	104
3.5	Degassing of Polymers in Purge Bins	108
	<i>Harald Wilms, Hans Schneider</i>	
3.5.1	Introduction	108

3.5.2	Process Requirements for Degassing of Solids	109
3.5.3	Basics of Particle Degassing	110
3.5.4	Determination of Degassing Process Parameters	112
3.5.4.1	Oven Tests	114
3.5.4.2	Batch Trials	114
3.5.4.3	Pilot Plant Tests	114
3.5.4.4	Criteria for the Gas Flow Rate for Degassing	116
3.5.5	Design Requirements for the Degassing Silo	116
3.5.6	Heating of Bulk Solids	119
3.5.7	Energy-Efficient Plant Concepts	120
3.5.8	Comparable Applications	121
3.5.9	Summary	121
PART C Processing after Polymer Production – Compounding ...		123
4	Requirements, Product Development, Additives, Sources of Faults	125
4.1	Compounding Requirements from the Compounder's Perspective ... <i>Thomas Schuldt</i>	125
4.1.1	Introduction	125
4.1.2	Economics	125
4.1.3	Technical Requirements along the Process Chain	127
4.1.3.1	Material Handling	127
4.1.3.2	Raw Material Pre-Treatment	129
4.1.3.3	Premixing	129
4.1.3.4	Extruder and Wear	131
4.1.3.5	Cooling and Pelletizing	135
4.1.3.6	Packaging	136
4.1.4	Quality Control	137
4.1.5	Environmental Aspects	139
4.1.6	Conclusions	139
4.2	Product Development	140
	<i>Thomas Schuldt</i>	
4.2.1	Introduction	140
4.2.2	Types of Product Development	140
4.2.3	Building Blocks of Product Development	142
4.2.3.1	Equipment Technology	143
4.2.3.2	Process Technology	143
4.2.3.3	Formulation	143
4.2.4	Ingredients	144
4.2.4.1	Additives	144

4.2.4.2	Fillers	145
4.2.4.3	Pigments	146
4.2.5	Innovation	148
4.2.6	Quality Control	149
4.2.7	Scale-up	150
4.3	Additives for Polymers – From Polymer to Plastic	152
	<i>Hermann Diem</i>	
4.3.1	Blends	152
4.3.1.1	Definition of Blends	152
4.3.1.2	Classification of Multi-Phase Systems	153
4.3.1.2.1	Polymer Blends	153
4.3.1.2.2	Dry Blends	155
4.3.2	Additives	155
4.3.2.1	Definition of Additives	155
4.3.2.2	Effects and Mode of Operation of the Additives	156
4.3.2.2.1	Plasticizers	156
4.3.2.2.2	Stabilizers	156
4.3.2.3	Incorporation of Additives into Polymers	158
4.3.3	Fillers	159
4.3.3.1	Definition of Fillers	159
4.3.3.2	Classification and Properties of Fillers	159
4.3.3.3	Aspect Ratio	160
4.4	Practical Examples Regarding Sources of Fault/Avoidance of Faults during Compounding	161
	<i>Klemens Kohlgrüber</i>	
4.4.1	Black Specks	163
4.4.2	Sources at Dosing and Mixing	167
4.4.2.1	Demixing	167
4.4.2.2	Dosing System	168
4.4.2.3	Mixing of Polymer with Additives	169
4.4.3	Drive-Measurement Technique	170
4.4.4	Faults in Tests with Small Extruders for Scale-up Purposes	172
5	Compounding with Co-Rotating Twin-Screw Extruders	177
5.1	Introduction	177
	<i>Klemens Kohlgrüber</i>	
5.1.1	Advantages of the Co-Rotating Twin-Screw Extruder	178
5.1.2	Disadvantages of the Co-Rotating Twin-Screw Extruder	180
5.1.3	Range of Services and Power Density of Co-Rotating Twin-Screw Extruders	181

5.1.4	Parameters in Dependence on the Diameter Ratio D_a/D_i	183
5.1.4.1	Strength and Throughput as a Function of D_a/D_i	183
5.1.4.2	Pressure and Power Characteristic as a Function of D_a/D_i	186
5.1.4.3	Maximum Product Volume	188
5.1.4.4	Inner Surface of the Housing to Maximum Product Space	189
5.1.4.5	Outlook	192
5.1.5	Special Types of Construction of the Co-Rotating Extruder	192
5.2	Tasks and Design of the Processing Zones of a Compounding Extruder <i>Reiner Rudolf, Michael Bierdel</i>	194
5.2.1	Melt Conveying Zone	195
5.2.2	Solids Conveying Zone	201
5.2.3	Plastification Zone	204
5.2.4	Distributive and Dispersive Mixing Zone	209
5.2.5	Devolatilization Zone	214
5.2.6	Pressure Build-up Zone	216
5.2.7	Complete Screw Configuration	219
5.2.8	Specific Energy Input	222
5.2.9	Residence Time Characteristics	225
5.3	Process and Screw Concepts for Machines with High Throughputs <i>Frank Lechner</i>	229
5.3.1	Development to High Torques, Volumes, and Rotations	229
5.3.2	Parameters and Process Limits of Co-Rotating Twin-Screw Kneaders	230
5.3.3	Process Length and Screw Development	233
5.3.4	Maximum Possible Screw Speed	234
5.3.5	Torque-Limited Processes	235
5.3.6	Volume-Limited Processes	237
5.3.7	Quality-Limited Processes	241
5.3.8	Process Concept for Economical Compounding	244
5.3.9	Outlook	247
5.4	Screw Designs for Highly Filled Polymers (and Dosing Strategies) <i>Sebastian Fraas</i>	247
5.4.1	Why Filler Compounds?	247
5.4.2	Typical Applications	248
5.4.3	Material-Specific Influencing Factors	248
5.4.3.1	Influence of Filler	248
5.4.3.1.1	Origin/Mining	250
5.4.3.1.2	Particle Size and Particle Size Distribution	250

	5.4.3.1.3	Coating	250
	5.4.3.1.4	Moisture Content	251
	5.4.3.2	Polymer and Additives	252
5.4.4		Process Technology	252
	5.4.4.1	Conveying Technology	254
	5.4.4.2	Dosing Equipment	255
	5.4.4.3	Downstream Equipment	256
	5.4.4.4	Barrel Setup of an Extruder for Highly Filled Compounds	256
	5.4.4.5	Screw Design	260
	5.4.4.5.1	Melting Zone	260
	5.4.4.5.2	Filler Addition and Wetting	261
	5.4.4.5.3	Dispersion Zone	261
	5.4.4.5.4	Vacuum and Discharge Zone	262
	5.4.4.6	Entire System	262
5.5		Compounding of Natural Fiber Reinforced Plastics	263
		<i>Dijan Iliw, Stephen Kroll, Andrea Siebert-Raths</i>	
	5.5.1	Pre-Knowledge for the Processing of Natural Fibers	265
	5.5.2	Design and Parameterization of the Process Unit of a Co-Rotating Twin-Screw Extruder	271
5.6		Fundamentals of Thermoplastic Foam Extrusion by Means of Parallel Twin-Screw Extruders	279
		<i>Lukas Vogel</i>	
	5.6.1	Definition and Characterization of Foams	281
	5.6.2	Process Steps for Foam Extrusion	283
	5.6.2.1	Provision of Thermoplastic Melts	284
	5.6.2.2	Addition and Admixing of the Propellant (Blowing Agent)	284
	5.6.2.3	Injecting the Blowing Agent and Conditioning of the Melt	285
	5.6.2.4	Discharge of the Melt through the Die	287
	5.6.2.5	Growth of Cells and Stabilization of the Foam Structure	289
	5.6.3	System Components for Foam Extrusion	293
5.7		Screw Configurations	298
		<i>Michael Bierdel</i>	
5.8		Materials, Coatings, Wear Technology	313
		<i>Oliver Kayser</i>	
	5.8.1	Requirements to the Components for Compounding	313
	5.8.2	Materials and Heat Treatment	314
	5.8.2.1	Tempering Steels and Nitriding Steels	315

5.8.2.2	Hot-Work Steels	315
5.8.2.3	Alloyed Cold-Work Steels	316
5.8.2.4	High-Speed Steels	317
5.8.3	Execution of Components of Twin-Screw Extruders	317
5.8.4	Process of Surface Layer Hardening	319
5.8.4.1	Wear Protection by Nitriding	320
5.8.4.2	Avoidance of Adhesive Wear due to Nitriding	323
5.8.4.3	Avoidance of Pitting Corrosion by Nitriding	324
5.8.4.4	Special Process for Maintaining Corrosion Protection	324
5.8.5	Wear Protection by Coatings	326
5.8.5.1	Hard Chromium	326
5.8.5.2	Chemical Nickel	328
5.8.5.3	Thin Layers of Hard Material	329
5.8.5.3.1	Physical Vapor Deposition	329
5.8.5.3.2	Chemical Vapor Deposition	333
5.8.6	Recommendations for Application	336
5.8.7	Summary and Outlook	337
6	Compounding and Polymer Processing with Different Extruder Types	341
6.1	Extruder Types - Introduction	341
	<i>Klemens Kohlgrüber</i>	
6.1.1	Compounding and Processing with Different Extruder Types	341
6.1.2	Single-Screw Extruders	344
6.1.3	Gear Pumps	345
6.1.4	Co-Rotating Twin-Screw Extruders	346
6.1.5	Counter-Rotating Twin-Screw Extruders	347
6.1.6	Multi-Screw Extruders: Ring Extruders and Planetary Roller Extruders	348
6.1.7	Non-Screw Extruders	349
6.1.8	High-Viscosity Reactors	350
6.2	Single-Screw Extruder	351
	<i>Gregor Karrenberg</i>	
6.2.1	Applications in Compounding	351
6.2.2	Design and Function	353
6.2.3	Plasticizing Extruder	356
6.2.4	Melt Extruder	361
6.2.5	Degassing Extruder	362
6.2.6	Mixing Elements for Single-Screw Extruders	364
6.2.7	Scale-up Methods	367

6.3	The RingExtruder	369
	<i>Michael Erdmann</i>	
6.3.1	Mechanical Setup	370
6.3.2	Principle of Movement and Distributive Mixing	373
6.3.3	Dispersive Mixing	374
6.3.4	Degassing Efficiency	375
6.3.5	Heat Transfer – Surface/Volume Ratio	376
6.3.6	Wear Protection	377
6.3.7	Extruder Series and Scale-up	378
6.3.8	Fields of Application	379
	6.3.8.1 PET Recycling	380
	6.3.8.2 Continuous Production of Rubber Compounds	381
6.4	Counter-Rotating Intermeshing Twin Screws	387
	<i>Ernst Krüger</i>	
6.4.1	Understanding of Gelation of PVC as a Requirement for Understanding of Twin Screws	388
6.4.2	Structure of a PVC Grain	389
6.4.3	Scheme of PVC Processing	390
6.4.4	Model of PVC Compounding and Processing	390
6.4.5	Level of Gelation and Mechanical Properties	391
6.4.6	Formulation Components	392
6.4.7	Homogeneity of the Gelation Level	392
6.4.8	Homogeneity in PVC Processing	393
6.4.9	Influence of Temperature on Gelation Homogeneity	394
6.4.10	Temperature inside the 8to0 Adapter	394
6.4.11	Basics of Screw Design	395
	6.4.11.1 Zones of a Counter-Rotating Twin Screw	396
	6.4.11.2 Special Features of the Screw Design of Counter-Rotating Twin Screws	398
6.4.12	Design and Wear	399
6.5	Planetary Roller Extruder	404
	<i>Harald Rust, Thomas Birr, Holger Lange</i>	
6.5.1	Introduction	404
6.5.2	Mechanical Principle	405
6.5.3	Construction	406
6.5.4	Characteristics	407
6.5.5	Construction Sizes and Designations	408
6.5.6	Conveying and Working Principle	410
	6.5.6.1 Partially and Fully Filled Areas	411
6.5.7	Planetary Spindle Configuration	412
	6.5.7.1 Types of Planetary Spindles	413

6.5.7.2	Planetary Spindle Lengths	416
6.5.7.3	Distribution of Planetary Spindles	418
6.5.8	Intermediate Rings	419
6.5.9	The Modular System	422
6.5.10	Feeding of Solids	423
6.5.11	Feeding of Liquids	427
6.5.12	Degassing	429
6.5.13	Sensor System	438
6.5.14	Peripheral Devices	440
6.6	Oscillating Screw Kneader or Continuous Kneader	442
	<i>Hans-Ulrich Siegenthaler</i>	
6.6.1	Introduction	442
6.6.2	Historical Background	443
6.6.3	Working Principle	444
6.6.4	Shear Rate	446
6.6.5	Residence Time and Residence Time Distribution	448
6.6.6	Technical Design	450
6.6.6.1	Modularity	450
6.6.6.2	Liners	452
6.6.6.3	Screw Elements	454
6.6.6.4	Kneading Bolts and Teeth	456
6.6.6.5	Temperature Control	458
6.6.6.6	Pressure Build-up Systems	461
6.6.7	Application Fields	462
6.6.7.1	Cable Compounds	463
6.6.7.2	Engineering and High-Performance Plastics	464
6.6.7.3	PVC Applications (Granulating and Calendering) ...	465
6.6.7.4	Thermoset Applications	466
6.6.7.5	Powder Coatings and Toners	466
6.6.7.6	Anode Masses for Aluminum Production	467
6.6.7.7	Specialties	467
6.6.7.8	Food Applications	468
6.7	Farrel Pomini Continuous Mixers	470
	<i>Peter Gohl, Roman Kebalo, Joe Pereira, Stuart Sardinskas</i>	
6.7.1	Introduction	470
6.7.2	General Mechanical Features	472
6.7.2.1	Mechanical Features: Mixer	472
6.7.2.2	Mechanical Features: Extruder	473
6.7.3	FCM Configuration	473
6.7.3.1	Feed Section	473
6.7.3.2	Mixing Section	473

6.7.3.3	Apex Zone	474
6.7.3.4	Rotor Orientation	475
6.7.4	Principles of Operation	478
6.7.4.1	Heating and Cooling	480
6.7.4.2	Mixer Body Segments and Mixing Dams	481
6.7.5	Process Flexibility	482
6.7.6	Applications	484
6.7.7	Energy Saving	485
6.7.8	Conclusion	487
6.8	Extruder Types – Comparison	488
	<i>Klemens Kohlgrüber, Michael Bierdel</i>	
6.8.1	Questions to Be Asked Prior to a Comparison	488
6.8.2	Costs, Operating Figures, Specific Energy	490
6.8.3	Characteristic Process Properties of Different Extruder Types	496
6.8.4	Descriptive Evaluation of Extruders with Current Throughputs and Sizes	500
6.9	MRS (Multi-Rotations System)	510
	<i>Axel Hannemann</i>	
6.9.1	Mode of Operation	510
6.9.1.1	Feeding and Plastification in the MRS	510
6.9.1.2	The Degassing Drum – The Heart of the MRS Technology	511
6.9.1.3	Conveying and Pumping	514
6.9.2	Continuous Measure and Control of Process Parameters	514
6.9.2.1	Importance of Acquisition and Control of the Process Parameters Melt Pressure, Temperature, and Viscosity	514
6.9.2.2	Control by Means of Online Viscometer VIS	514
6.9.3	Essential Process-Related Influencing Factors during PET Processing	515
6.9.3.1	Drying and Extrusion	515
6.9.4	Processing of Other Polymers	519
6.9.4.1	Recycling of Polyolefins	519
6.9.4.2	Monomer Removal	521
6.9.4.3	Decontamination	524
6.9.5	Energy Savings with the MRS System	525
6.9.6	Results	526

7	Processing of Polymer Melts with Other Devices and Machines	529
7.1	High-Viscosity Reactors	529
	<i>Oliver Seck</i>	
7.1.1	Introduction	529
7.1.2	Single-Shaft High-Viscosity Reactors	532
7.1.3	Twin-Shaft High-Viscosity Reactors	534
	7.1.3.1 Reacom	534
	7.1.3.2 Reasil	535
7.1.4	Product Transport	536
7.1.5	Energy Input	537
7.1.6	Axial and Radial Mixing Behavior	538
7.1.7	Devolatilization	541
7.1.8	Apparatus Design and Scale-up	544
7.1.9	Summary	546
7.2	Compounding of Polymers by Means of Calender and Flat Film Lines	548
	<i>Harald Rust, Stefan Seibel</i>	
7.2.1	History	548
7.2.2	Continuous Feeding	550
7.2.3	The Planetary Roller Extruder for Calender Feeding	550
7.2.4	Comparison of Different Compounding Systems	551
7.2.5	Modern Calender Lines	552
7.2.6	Types of Pelletizing	554
7.2.7	Roll Mill and Strainer	556
7.2.8	Roll Mill	556
7.2.9	Strainer	556
7.2.10	Edge Trims	558
7.2.11	Different Calender Types	559
7.2.12	Special Designs	561
7.2.13	Differences between Calenders and Calandrettes	561
7.2.14	The Task of the Calender and Different Calender Rolls	562
7.2.15	The Setup and Mode of Operation of a Calender	564
7.2.16	Possibilities of Correction	565
7.2.17	Temperature Distributions	566
7.2.18	Comparison of the Temperature Distribution in the Edge Areas between a Conventional, Peripherally Bored Roll and a Coiled Roll	566
7.2.19	Static and Thermal Comparison of Calender Rolls in Use Today	567
7.2.20	Speeds and Sizes	567
7.2.21	The Mini Impression Roller	569

7.2.22	Thickness Measuring and Inspection Unit for Contamination . . .	570
7.2.23	Winder	571
7.2.24	Sheet and Film Production	572
7.2.24.1	Gear Pumps	572
7.2.24.2	Flat Film Dies	573
7.2.24.2.1	Die Construction Always Is a Compromise	573
7.2.24.2.2	Application-Specific Die Equipment	574
7.2.24.2.3	Multi-Layer Extrusion	574
7.2.25	Chill Roll Line	576
7.2.26	Flat Film Line	577
7.2.27	Polishing Rolls	577
7.2.28	Foam Sheets of 20 mm–200 mm	579
7.2.29	Vacuum Nap Film Line According to the Film Casting Principle for Construction Nap Film	580
7.2.30	TPU Film Line for Direct Embossing between Siliconized Fabric	581
7.2.31	Film Stretching Lines	581
7.2.32	Introduction to the Biax Process Using the Example of BOPP . .	582
7.2.32.1	Raw Material Supply and Extrusion	582
7.2.32.2	TDO (Transversal Direction Orienter)	583
7.3	Mixing and Dispersion	585
7.3.1	Fundamentals: Homogeneous and Dispersive Mixing	585
	<i>Jörg Kirchhoff, Michael Bierdel</i>	
7.3.1.1	Overview, Principles, and Experiments	585
7.3.1.1.1	Homogeneous Mixing – Mixing in Laminar Flow	585
7.3.1.1.2	Dispersive Mixing	591
7.3.1.1.3	Determining the Mixing Quality	598
7.3.1.2	Three-Dimensional Calculations of Mixing and Residence Time Behavior	602
7.3.1.3	Summary	608
7.3.2	Static Mixers	609
	<i>Klemens Kohlgrüber</i>	
7.3.2.1	Introduction, Advantages, and Disadvantages	609
7.3.2.2	Construction Types	611
7.3.2.3	Process Technology	616
7.3.2.3.1	Pressure Loss and Mixer Evaluation	616
7.3.2.3.2	Reduction in Layer Thickness Depending on the Mixing Length – Distributive Mixing	617
7.3.2.3.3	Residence Time Distribution	618
7.3.2.3.4	Power Input and Temperature	618

	7.3.2.3.5	Gas Dispersion	620
	7.3.2.3.6	Mixing-in of Additives	621
	7.3.2.3.7	Heat Transfer	621
	7.3.2.3.8	Scale-up of the Mixing Function	622
7.3.2.4		Static Mixers with Internal Temperature Control . . .	624
	7.3.2.4.1	SMR Heat Exchanger	625
	7.3.2.4.2	Compact Heat Exchanger with Temperature-Controlled X Installations	625
PART D Further Important Components of a Processing Facility			627
8 Bulk Material Technology in Polymer Processing			629
8.1	Silo Design for Flow and Stability		629
	<i>Harald Wilms</i>		
8.1.1	Silos Discharge Problems		629
	8.1.1.1	Arching	629
	8.1.1.2	Ratholing	630
	8.1.1.3	Erratic Flow	631
	8.1.1.4	Flushing	631
	8.1.1.5	Segregation	631
	8.1.1.6	Level Control	633
	8.1.1.7	Residence Distribution	634
8.1.2	Flow Profiles in Silos		635
8.1.3	Shear Tests to Determine the Flow Properties		637
8.1.4	Silo Design for Flow		641
	8.1.4.1	Hopper Wall Inclination for Mass Flow	642
	8.1.4.2	Outlet Diameter to Avoid Arching in Mass Flow	645
	8.1.4.3	Outlet Diameter to Avoid Ratholing in Funnel Flow . .	649
	8.1.4.4	Influence of Time Consolidation	653
	8.1.4.5	Application of Discharge Devices and Discharge Aids	654
8.1.5	Structural Aspects of Silo Design		656
	8.1.5.1	Pressures in Silos	656
	8.1.5.2	Pressure Peaks in Silos	657
	8.1.5.3	Asymmetric Flow Channels	658
8.2	Blending Silos for Plastic Compounding and Processing		662
	<i>Harald Wilms</i>		
8.2.1	Introduction		662
8.2.2	Requirements for Blending Silos		664
8.2.3	Survey on Blending Silo Designs		666
	8.2.3.1	Blending Silos with Mechanical Energy Input	666
	8.2.3.2	Blending Silos with Pneumatic Energy Input	667

8.2.3.3	Gravity Flow Blending Silos with Internal Blend Hoppers	669
8.2.3.4	Gravity Flow Blending Silos with Blending Pipes ...	671
8.2.3.5	Multi-Chamber Blending Silos	674
8.2.4	Selection Criteria	675
8.2.5	Summary	677
8.3	Feeding Technology	678
	<i>Bernhard Hüppmeier</i>	
8.3.1	Basics of Feeding Technology	679
8.3.2	Different Feeding Technologies for Solids	681
8.3.3	Loss-in-Weight Liquid Feeders	686
8.3.4	Loss-in-Weight Feeder	687
8.3.5	Requirements for the Weigh-Feeders	688
8.3.6	Plant Implementation	689
8.3.7	Refill	691
8.3.8	Venting	693
8.3.9	ATEX	694
8.3.10	Accuracy & Consistency (Namur)	695
8.3.11	Cleaning and Product Change	696
8.3.12	Control and Interfaces	696
8.3.13	Future Outlook	696
8.3.14	Summary	697
8.4	High-Intensive Mixing	697
	<i>Harald Wilms, Henning Kreis</i>	
8.4.1	Introduction	697
8.4.2	Introduction to Mixing of Solids	698
8.4.2.1	Mixing Task	698
8.4.2.2	Classification of Mixers	699
8.4.2.3	Segregation	699
8.4.2.4	Description of the State of Mixing by Statistical Means	700
8.4.3	Applications for High-Speed Mixers	702
8.4.3.1	PVC Processing	703
8.4.3.2	Production of Wood-Plastic Compounds (WPC)	704
8.4.3.3	Production of Compounds for Powder Injection Molding (PIM)	704
8.4.3.4	Production of Compounds for Bonding Applications	704
8.4.4	Mixers Operating in Batch Mode	705
8.4.4.1	Fluid Mixers	705
8.4.4.2	High-Speed Mixers	706
8.4.4.3	Heating-Cooling Mixer Combination	708
8.4.4.4	Container Mixer	709

8.4.5	Mixers for Continuous Operation	710
8.4.6	Summary and Outlook	712
8.5	Pneumatic Conveying in the Polymer Industry	714
	<i>Harald Wilms, Guido Winkhardt</i>	
8.5.1	Introduction	714
8.5.2	Conveying Modes and Flow Characteristic	715
8.5.3	Design of Pneumatic Conveying Systems	717
8.5.4	Design and Operation of Pneumatic Conveying Systems	720
8.5.4.1	Concept and Operation of a Dilute-Phase Conveying System	721
8.5.4.2	Concept and Operation of Dense-Phase Conveying Systems	721
8.5.5	Feeding of Solids into the Conveying Line	726
8.5.6	Summary	727
9	Gear Pumps for Compounding	731
	<i>Sven Wiczorek</i>	
9.1	Introduction – Gear Pumps	731
9.2	Mode of Operation of the Gear Pump	732
9.3	Gear Pump for Compounding in the Main Flow	733
9.3.1	Design of the Pump	734
9.3.1.1	Housing and Covers	735
9.3.1.2	Gear Wheels	736
9.3.1.3	Friction Bearing	738
9.3.1.4	Axial Shaft Seal	740
9.3.1.5	Heating	741
9.3.2	Influence of the Pumped Medium	741
9.3.2.1	Viscosity	741
9.3.2.2	Solids	743
9.3.3	Control System	743
9.4	Gear Pump for Additives	743
9.4.1	Design of the Pump	743
9.4.1.1	Housing and Covers	744
9.4.1.2	Gear Wheels	744
9.4.1.3	Friction Bearing	745
9.4.1.4	Axial Shaft Seal	745
9.4.1.5	Heating	745
9.4.2	Influence of the Pumped Medium	745
9.4.2.1	Viscosity	745

10 Filters for (Highly) Viscous Polymer Melts	747
<i>Thomas Grimm-Bosbach</i>	
10.1 Basic Principles of Polymer Filtration	747
10.1.1 Possible Contamination of Polymer Melts	748
10.1.2 Usable Filter Media	749
10.1.3 Definition of Polymer Melt Filtration	753
10.2 Filtration Systems	754
10.2.1 Large-Area Filters	754
10.2.1.1 Filter Candles	755
10.2.1.2 Filter Discs	756
10.2.2 Screen Changers	760
10.2.2.1 Piston Screen Changers	760
10.2.2.2 Rotary Screen Changers	763
10.2.3 Modern Filtration Systems – Economic Considerations	765
10.3 Design Procedure for Melt Filters	767
10.4 The “Right” Filtration	777
11 Pelletizing and Drying	781
<i>Harald Zang, Horst Müller</i>	
11.1 Overview of Pelletizing Processes	781
11.2 Process Engineering Aspects of Pelletizing	783
11.3 Process Engineering Aspects of Drying	786
11.4 Pelletizing and Drying in the Polymer Production	787
11.4.1 Typical Application Requirements	787
11.4.2 Underwater Pelletizing Technology for Polyolefins	788
11.4.3 Air-Cooled Pelletizing for PVC	792
11.4.4 Underwater Strand Pelletizing	793
11.4.5 Pellet Drying and Process Water Treatment in the Polymer Production	794
11.5 Pelletizing and Drying in Compounding Processes (Filling, Reinforcing, Additivation, Blending)	796
11.5.1 Typical Application Requirements	797
11.5.2 Underwater Pelletizing and Drying	798
11.5.3 Strand Dry Cut (Conventional Strand Pelletizing)	800
11.5.4 Automatic Strand Dry Cut	802
11.5.5 Special Processes for Special Applications	803
11.6 Other Pelletizing and Drying Processes	804
11.6.1 Dicers	804
11.6.2 Water Ring Pelletizers	805
11.6.3 Alternative Pelletizing Processes	806

12 Measurement Technology	809
<i>Christoph Kugler, Johannes Rudloff, Christina Hoffmann, Thomas Hochrein</i>	
12.1 Metrological Basics	809
12.2 Pressure and Temperature Measurement Technology	810
12.2.1 Temperature	811
12.2.2 Pressure	813
12.3 Rheological Metrology	815
12.3.1 Laboratory Rheometers	815
12.3.2 Process Rheometers	817
12.4 Optical and Spectroscopic Methods	818
12.4.1 Color Measurement	818
12.4.2 Infrared Spectroscopy	819
12.4.3 Microscopy and Image Analysis	820
12.4.4 Optical Sorting System	820
12.5 Application-Related Tests	823
12.6 Filter Pressure Test	824
12.7 Special Systems	827
12.7.1 Ultrasonic Measurement Technology	828
12.7.2 Model-Predictive Control	828
Index	831