

APT Asia Pacific Pty Ltd

Yarn Product Specifications

COMPANY CONFIDENTIAL

For Internal Use Only

BL - Rev 33 - 20200925

Product Code: 400011-re	Work Order:	Date:	Product Description: 1100TEX FBPE 10000MP MEADOW 80mtrs - Blend	Status: Active
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Material Code	Hopper A	Hopper B	Hopper C	Hopper D	Hopper E	Hopper F
	X2645G	X2645G	XAM104	X1371	X10100	X1371
Material Description	DOWLEX 2645G	DOWLEX 2645G	PROCESS AID TEGOMER	M/BATCH MEADOW PE/MB/GN STR 1371 - 8%	DOW HDPE KS 10100	M/BATCH MEADOW PE/MB/GN STR 1371 - 8%
% Add Rate	38.5	38.0	0.5	4.0	15.0	4.0
Feeder Config.	0.0	0.0	12mm 20:1	0.0	0.0	0.0

BARMIG 350 Fixed Settings	
Die-Type	EMO 1370
Distance Die -Chiler Roller	20mm/H=6.8/R=0.0/A=7
Chill Roller Temp. (°C)	24
Film width (gross)(mm)	1260
Air Knife Gap (um)	50

Drive	Start up	Running
P1	0	80
P2 Melt pump	50	50
P3	0	232

Heatings		Start up	Running
Ext Heat Zone 1		200	200
Ext Heat Zone 2		225	225
Ext Heat Zone 3		235	235
Ext Heat Zone 4		240	240
Ext Heat Zone 5		235	235
Flange		235	235
Filter Zone 1		235	235
Filter Zone 2		235	235
Adapter 1		235	235
Melt pump		235	235
Adapter 2		235	235
Die 1		230	230
Die 2		230	230
Die 3		230	230
Die 4		230	230
Die 5		230	230
Die 6		230	230
Die 7		230	230
Melt Temp 1			257

Cooling		Start up	Running
Cooling Unit 1		24	24
Air Knife		0	34
TCU 1		20	20
Hot Air Oven 1		115	115
Cooling Unit 2		20	20
TCU 2		108	108
TCU 3		108	108
Hot Air Oven 2		110	110
TCU 4		110	110
Cooling Unit 3		20	20

BARMIG 350 Variable Settings	
Needles	4 Pin
Fibrilator	1 G G 2 G G
Dip-In depth Fibrilator (mm)	16.2
Film Thickness (µm)	215
Cutin width (mm)	21.2
3 Thick	- Silver 1 Thin 1 Gold

Stretching Ratios	
Str.1 - CD	1.025
Str.2 - Str.1	4.777
Fib.4 - Str.2	2.776
Ann.1 - Fib.4	0.373
Ann.2 - Ann.1	0.838
Str.3 - Ann.2	0.955

Extrusion QC Spec.	
Extruded Linear Density (Tex)	1080
Tape Thickness(µm)	115
Tape Width(mm)	10
Extrusion Shrinkage (%)	4

Gogot Pressure Rollers - on/off	
Godet #1 - A	OFF ON
Godet #1 - B	OFF OFF
Godet #2 - A	OFF OFF
Godet #4 - A	OFF ON

Screen Pack	20/70/20
ICBT Brake Tension Setting	0
ICBT Air Pressure	5

[Paste Extrusion Film Standard Below]