

FireCon™
THERMOPLASTIC CPE-A

General Extrusion Guidelines

FireCon™ Thermoplastic CPE-A is a flexible thermoplastic chlorinated polyethylene blend designed for industrial instrumentation, power, and control cables.

EXTRUDER	
Screw	1" to 6" deep flighted metering screw 3:1 compression ratio
Tooling	Tubing type – zero land (for smaller sizes) Pressure type – for 1" size or larger
Die	Tubing type – low DDR Pressure type – short land
L/D	24:1 or higher
Screen Pack	20/40/20 Mesh
Cooling Trough	120–150 °F (50–65 °C) recommended
Dryer	Hot air or desiccant type, 4 hours at 175–185 °F

PROCESSING	
Temperature	
Wire Preheat	None
Feed Zones	290–300 °F
Transition	320–340 °F
Metering	340–350 °F
Head/Die	350–365 °F
Target Melt	350–365 °F
Maximum Melt	390 °F
Purge Compound	HDPE

A deeper mandrel and slotted breaker plate may be necessary to reduce head pressure.

Precautions: the extruder should not be idle with the material in the hot barrel. Drop all heating sections 50°F–100°F during extended downtime, die changes, etc. or keep bleeding if possible. If already degraded, a complete tool cleaning is recommended.

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