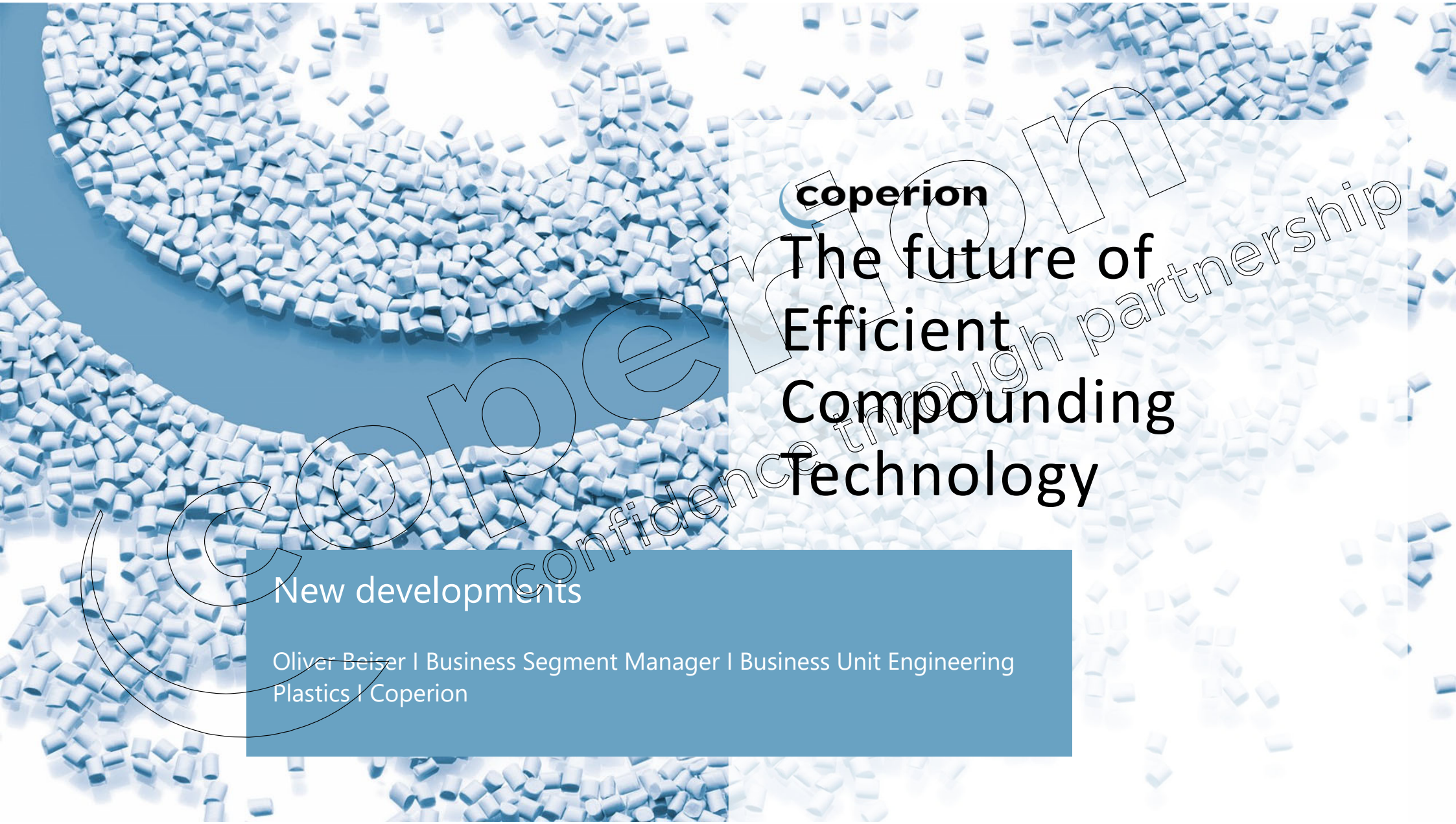


coperion

The future of Efficient Compounding Technology

New developments

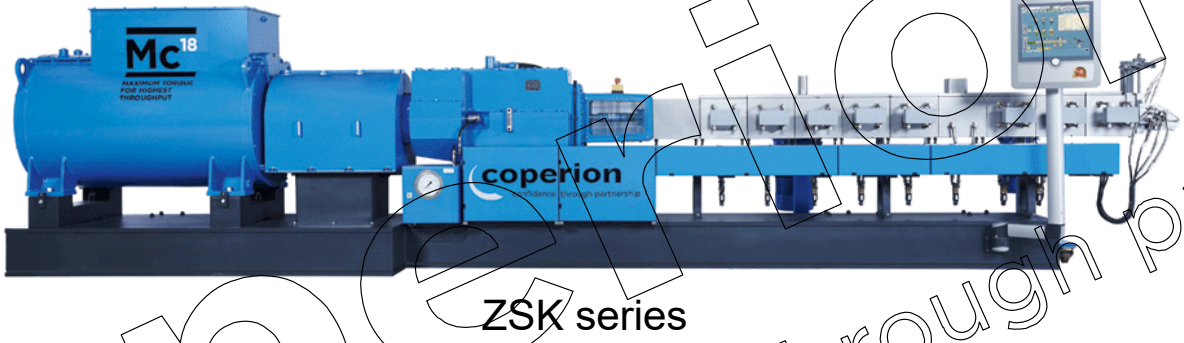
Oliver Beiser I Business Segment Manager I Business Unit Engineering Plastics I Coperion

1 ZSK Twin Screw Compounder and Pelletizers | Functionality, Specific Torque, Specific Energy Input SEI

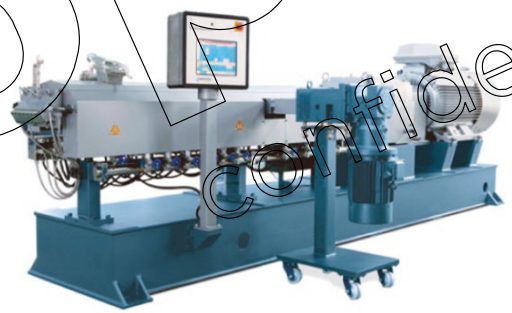
2 Examples | Specific torque, FET, ZS-EG, Bulk X-Change, C-Beyond

3 Summary

Product range



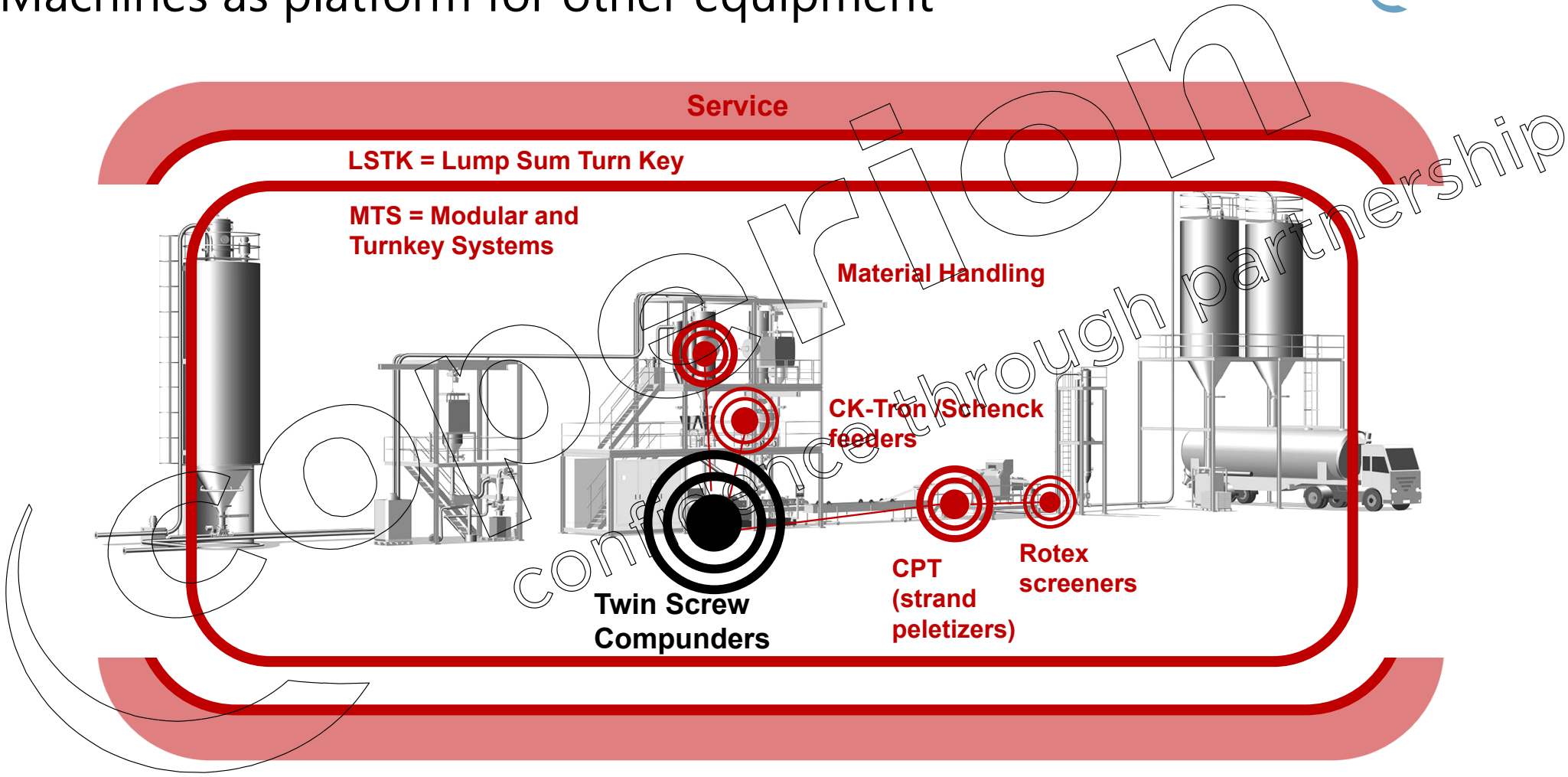
ZSK series



STS series

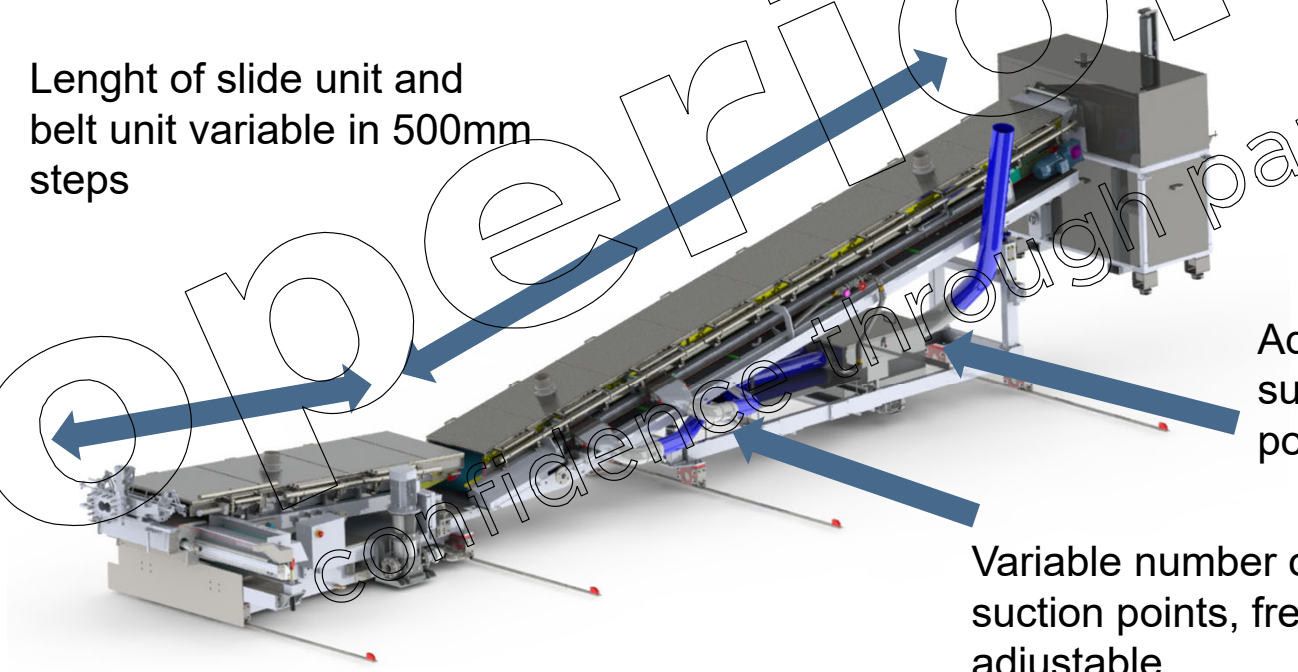
CTE / CKY series

Machines as platform for other equipment



Pelletizer

Automatic Strand Conveyance Type ASC



Automatic Strand Conveyance Type ASC

Technical data	ASC500-500	ASC700-500	ASC700-700
Number of strands (1)	50 / 60 (SK70)	70 / 84 (SK92)	70 / 84 (SK92)
Throughput [kg/h] (2)	3500	5000	6500
Working width strand sluice [mm]	570	930	930
Length of strand sluice/belt section [mm]	3500 / 7000		
Cooling water amount [m³/h]	15	30	30
Draw-in speed [m/min] (3)	40-150		
Working width belt/Pelletizer [mm]	500	500	700
Drive power [kW] - belt (frequency controlled)	1,1	1,1	1,1
Number of air knives	2 (adjustable position)		
Air volume [m³/min] / pressure [daPa]	86/1200	86/1200	96/1640
Drive power [kW] - blower	15	15	22
Rotor material	WS=tool steel / PM=powder steel, TC=tungsten carbide		
Draw-in section with option „duo drive“	driven upper feed roll with timing belt gear unit, freewheel clutch and double V-belt (allows hardened steel upper feed roll)		
Drive power [kW] - pelletizer	22.0 or 30.0	22.0 or 30.0	37.0 or 45.0
Base frames	powder coated mild steel – moveable on rails		
Measuring surface sound pressure [db/A]	</= 85		
Weight [kg]	4600	5600	

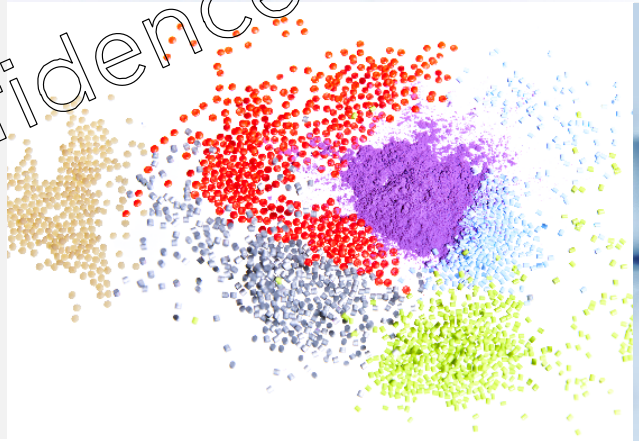
(1) Single row die / double row die (2) Depending on product and draw-in speed (3) different speed ranges on demand

Compounding tasks on Twin Screw Extruders

For high-quality end products: From single components to complete systems

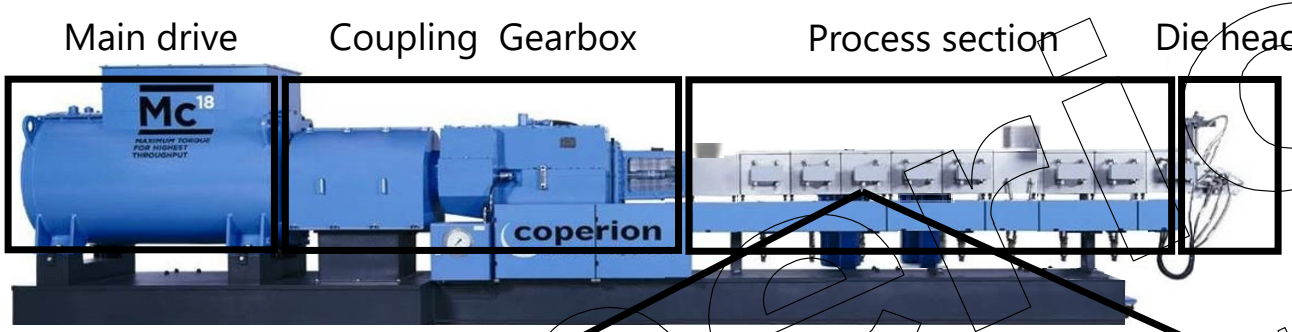
Target Markets

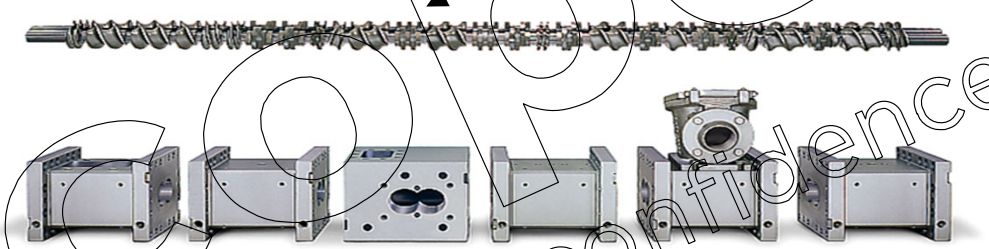
- Engineering Plastics
- Plastics Recycling
- Virgin Polymer
- Masterbatch
- PVC/HFFR
- Bio Plastics
- Direct Extrusion
- Battery Separator Films
- Chemical Applications
- Powder Coating
- Adhesives
- Polyolefines
- Battery Masses

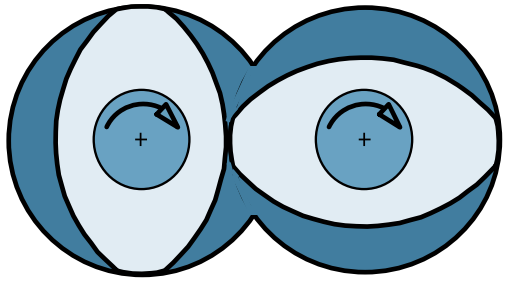


The ZSK twin screw extruder

Modular design and => perfect fit to any process task





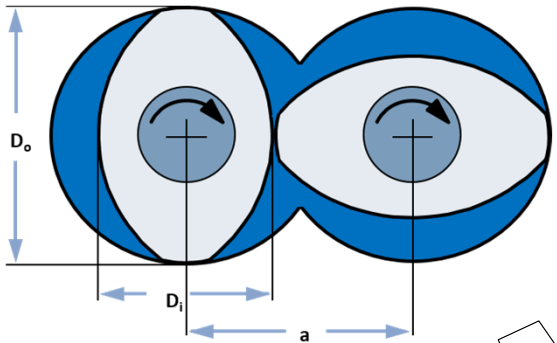


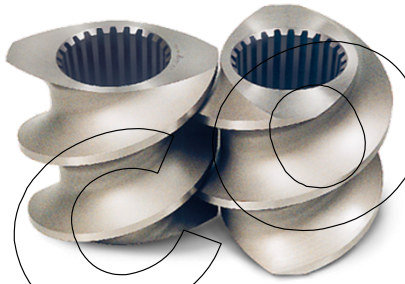
Benefits

- Modular design of barrels and screws
- Intermeshing and self-cleaning

ZSK development

Characteristic dimensions





D_0= Outer diameter
D_i = Inner diameter
a = Centerline distance
$\boldsymbol{D_0/D_i}$ = Diameter ratio
determines shear, degassing and powder intake

$\boldsymbol{M_d/a^3}$ = Specific torque
determines power density and filling degree

n = Screw speed
determines shear and mixing

Conclusion

- Specific parameters define a co-rotating twin-screw extruder ZSK
- The specific torque determins the power density of a co-rotating twin-screw

ZSK development

ZSK Standard
$D_o / D_i = 1,22$
$M_d / a^3 = 5,0$ Nm/cm³
n = 150 min-1

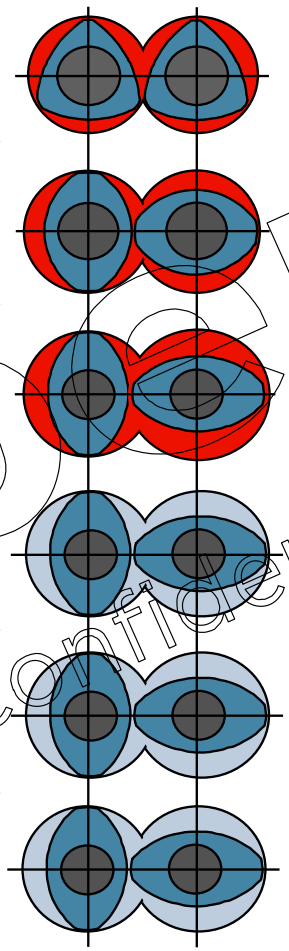
ZSK variable
$D_o / D_i = 1,44$
$M_d / a^3 = 5,0$ Nm/cm³
n = 300 min-1

ZSK Supercompounder
$D_o / D_i = 1,55$
$M_d / a^3 = 8,7$ Nm/cm³
n = 600 min-1

ZSK MEGAcompounder
$D_o / D_i = 1,55$
$M_d / a^3 = 11,3$ Nm/cm³
n = 1200 min-1

ZSK Mc PLUS
$D_o / D_i = 1,55$
$M_d / a^3 = 13,5$ Nm/cm³
n = 1200 min-1

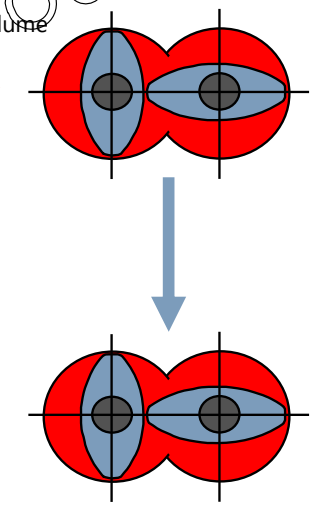
ZSK Mc¹⁸
$D_o / D_i = 1,55$
$M_d / a^3 = 18$ Nm/cm³
n = 1200 min-1



Increase of
free volume (100%)
and of specific torque

Increase of free volume
(additional 40%)

Increase of torque

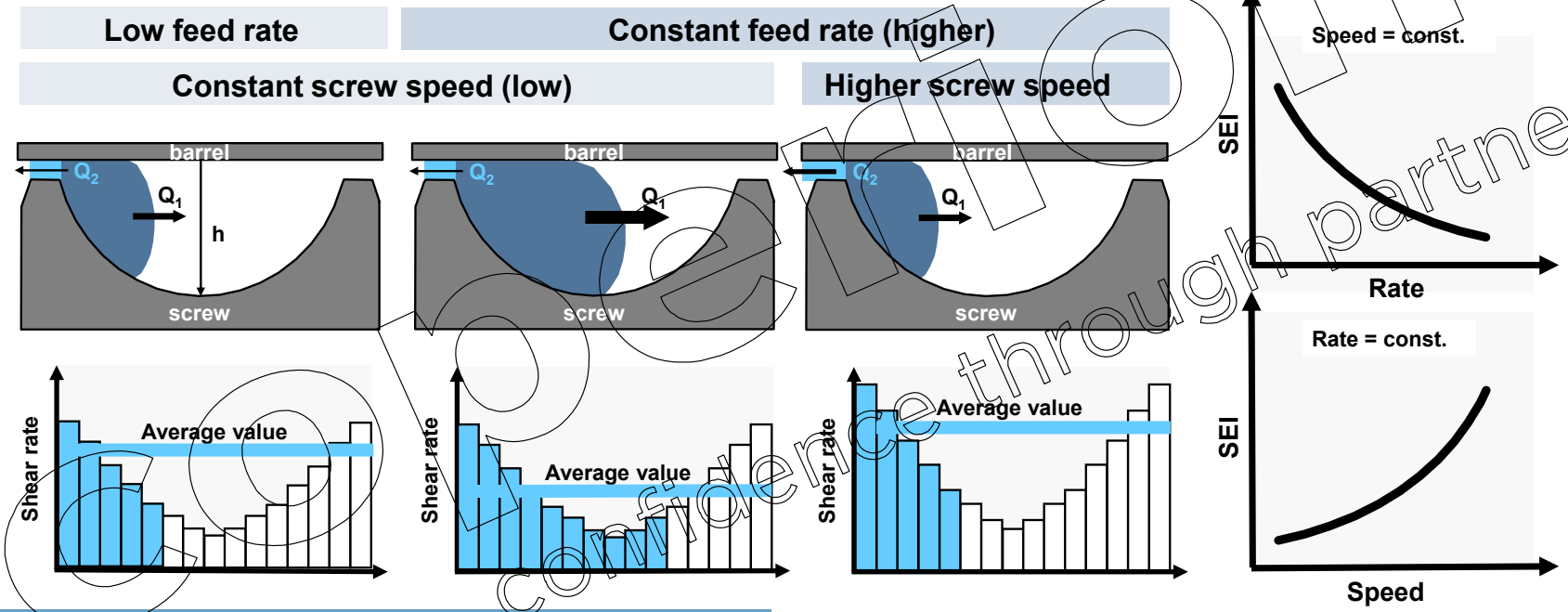


ZSK MEGAvolume
$D_o / D_i = 1,80$
$M_d / a^3 = 8,7$ Nm/cm³
n = 1800 min-1

ZSK Mv PLUS
$D_o / D_i = 1,80$
$M_d / a^3 = 11,3$ Nm/cm³
n = 1800 min-1

Process parameters

Specific energy (SEI): Influence of rate and screw speed



Why is high torque saving energy?

At constant screw speed, the specific energy SEI is reduced with higher throughput rate.
High degree of fill leads to higher energy efficiency and lower melt temperature

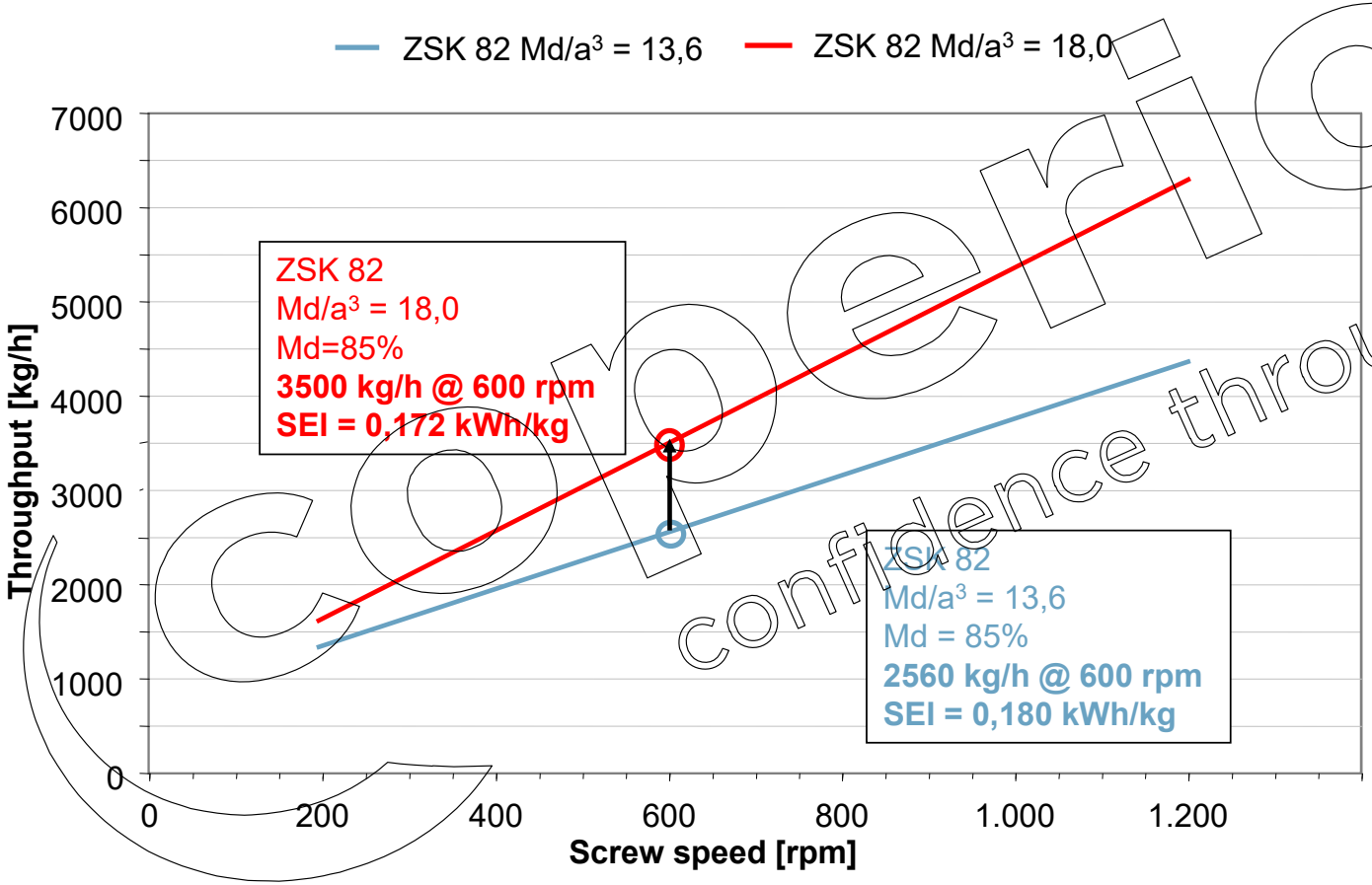
1 ZSK Twin Screw Compounder and Pelletizers | Functionality, Specific Torque, Specific Energy Input SEI

2 Examples | Specific torque, FET, ZS-EG, Bulk X-Change, C-Beyond

3 Summary

Example 1: Increasing Specific Torque

Fiber reinforced PA6 + 30% GF, higher degree of fill with higher specific torque



Conclusion

Higher specific torque leads to lower specific energy input SEI (and higher profitability)

3,5 t/h PA, runtime 6000h:

- **Energy saved:** 0.008kWh/kg * 21.000.000kg = **168.000kWh**
- **Output increase:** 940kg/h * 6000h = **5640t/year**

→ **Use highest possible torque**

→ **Check for modernization**

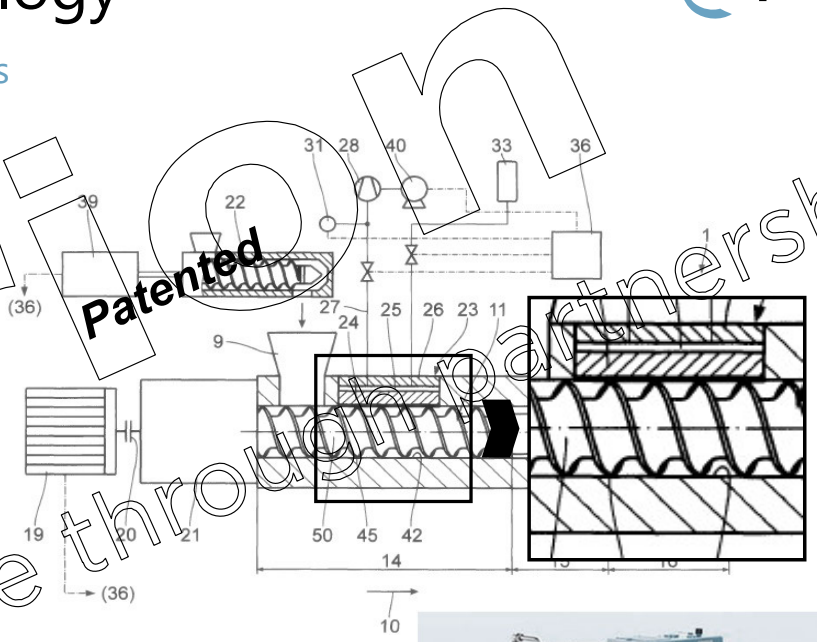
Example 2: Feed Enhancement Technology

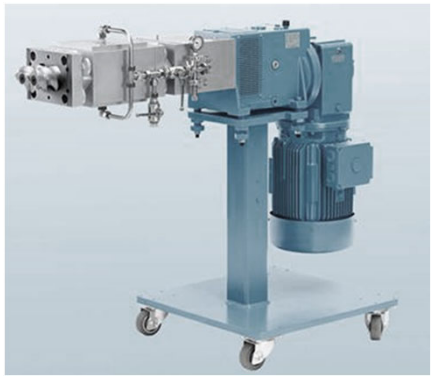
FET: Technology to increase the throughput of feed limited products

Features:
Solids conveying is improved by applying vacuum in the feed zone to a wall section which is porous and permeable to gas.

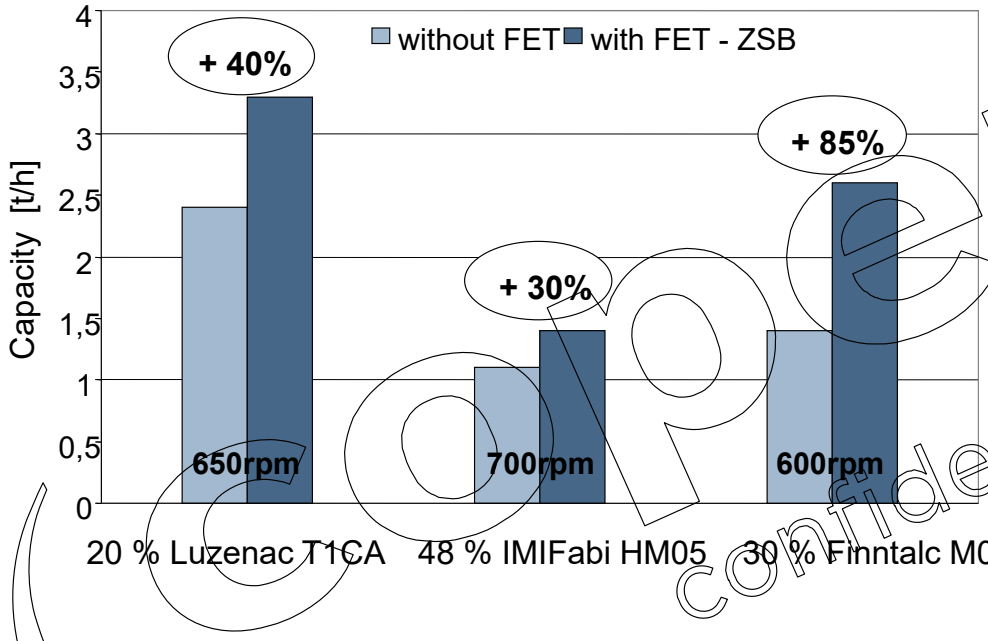
This wall section is realized by an insert with a filter membrane installed in an open barrel.

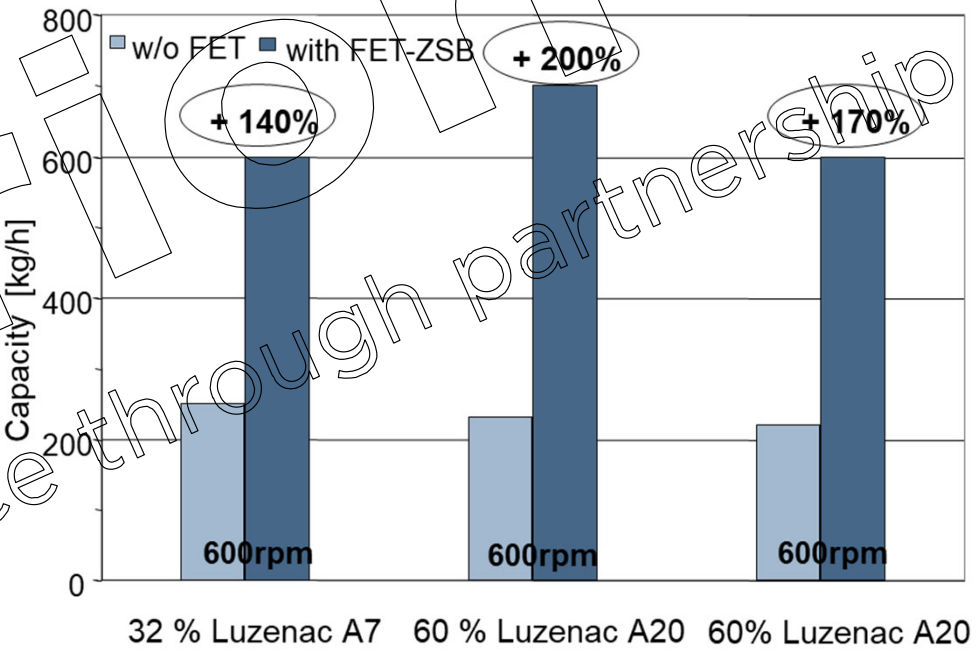
Already more than 150 ZSK equipped with FET





Example 2: Feed Enhancement Technology





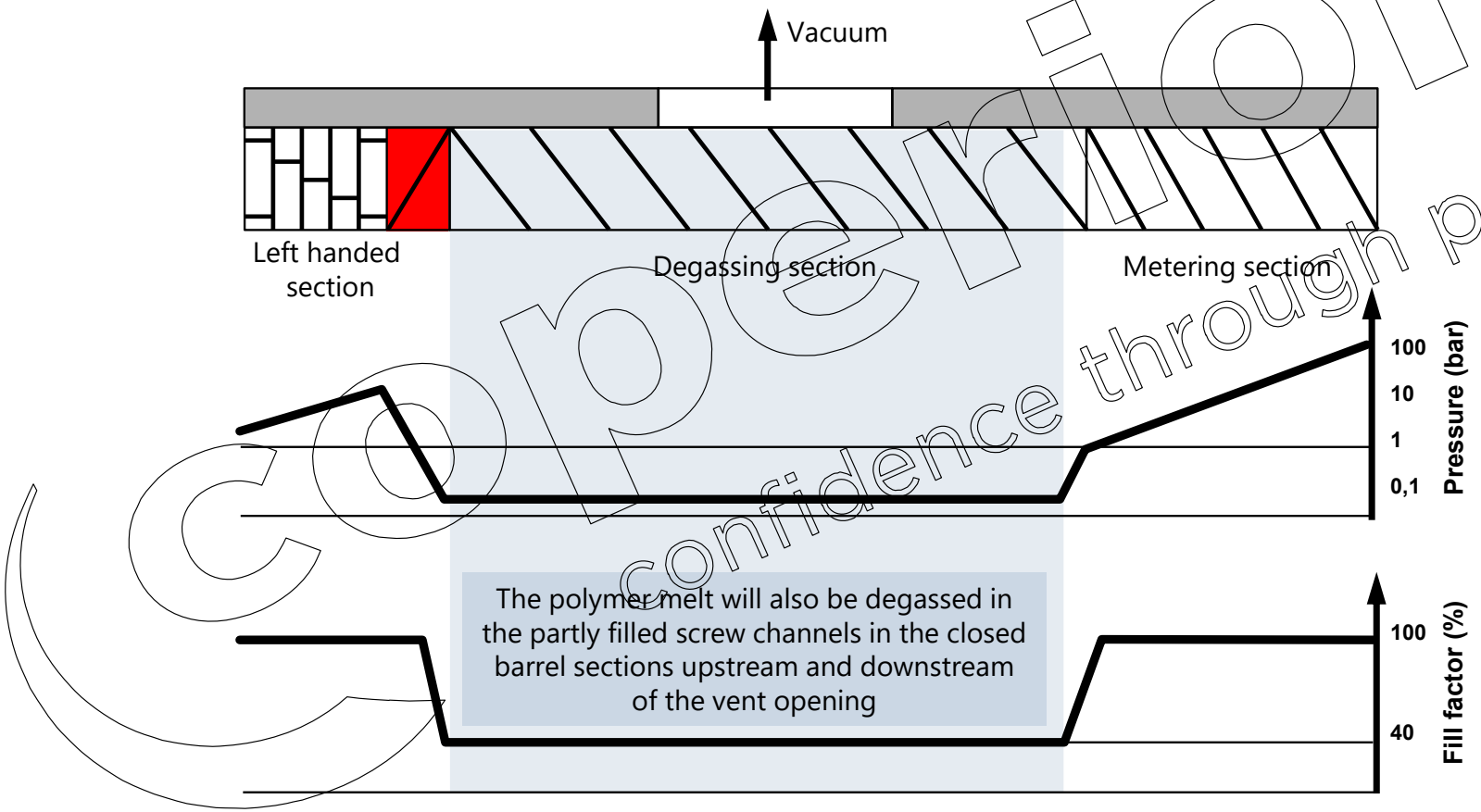
Conclusion

FET: Ex

- Increase of throughput for fine powders at constant screw speed of ZSK
- Decrease of SEI in relation to throughput increase and energy savings at same footprint

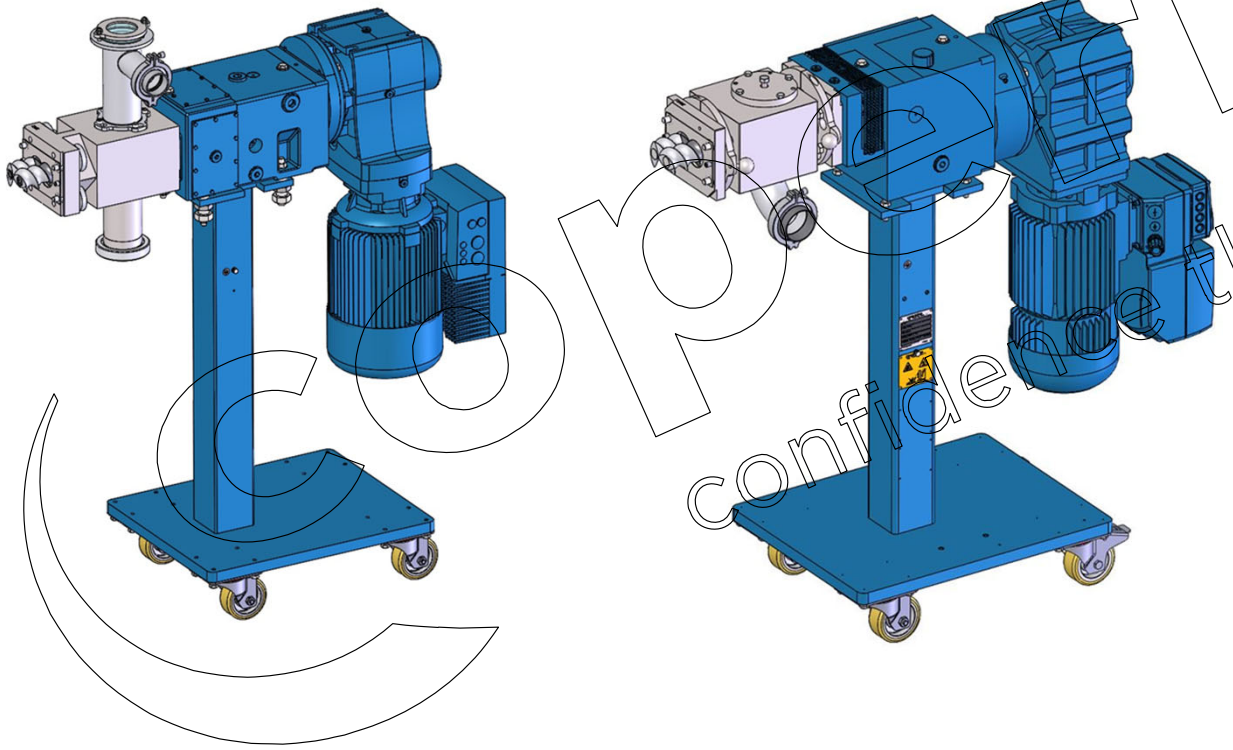
Example 3: Side degassing ZS-EG

Principle of degassing



Example 3: Side degassing ZS-EG

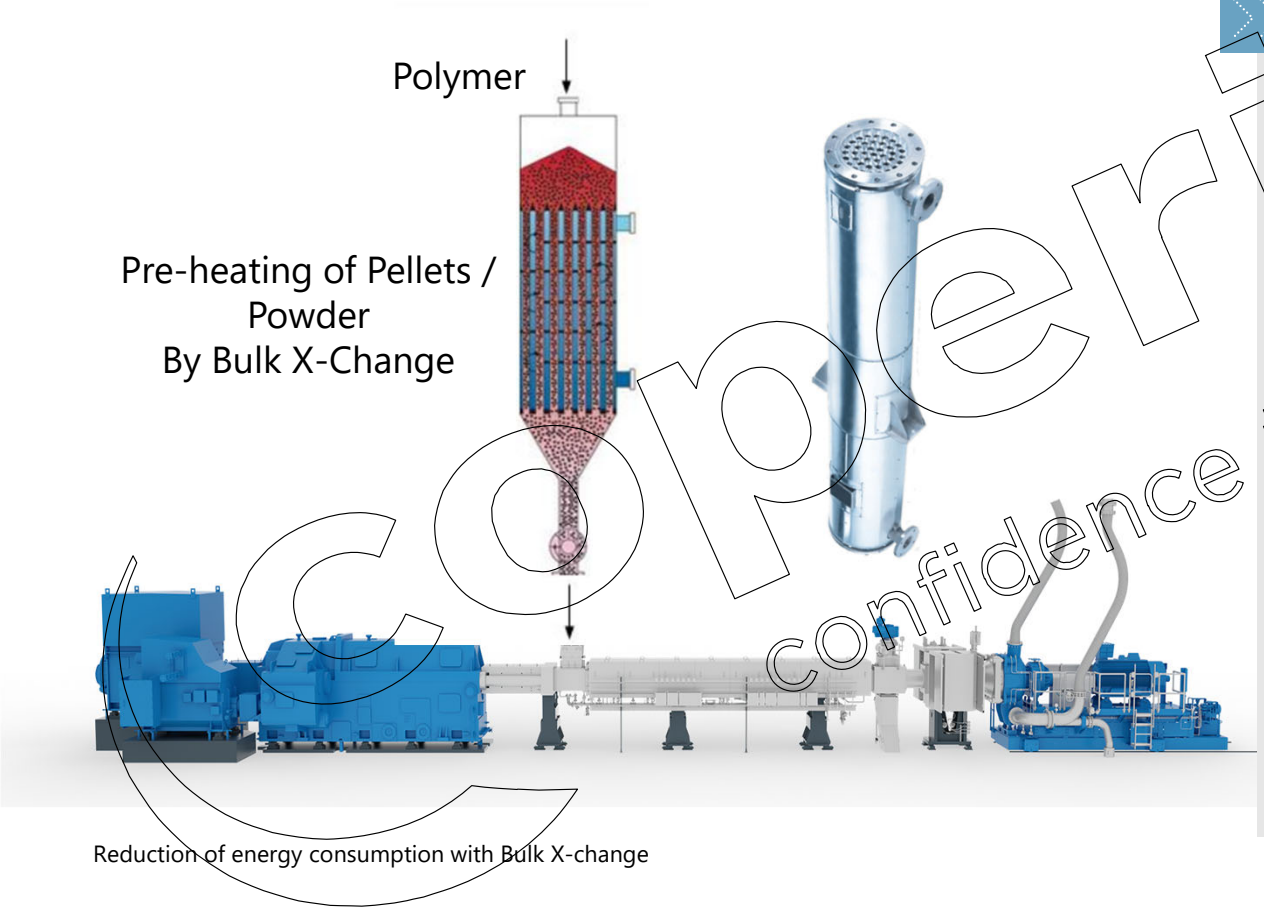
Side-Degassing ZS-EG for stable production



Side-Degassing ZS-EG

- Safe degassing for higher degree of fill
- Higher throughput due to higher filling degree (up to 30 %)
- Higher output rates for processes with higher moisture content e.g. recycling or WPC
- Less downtime, less scrap because of higher production safety

Example 4: Preheating of polymer



Reduction of energy consumption with Bulk X-change

Savings

Bulk X-Change use to lift the feed temperatur by using „secondary or waste" energy sources available on a petrochemical plant.

1) 45t/h HDPE plant (USA); 90°C feed, 95% availability:

- electricity cost (assumed): 0.0845$/kWh
- **Energy saved:** 0.020kWh/kg * 360.000.000kg = **7.200.000kWh**
- **Money saved:** 0.0845$/kWh * 7.200.000kWh = **600.000$/year**

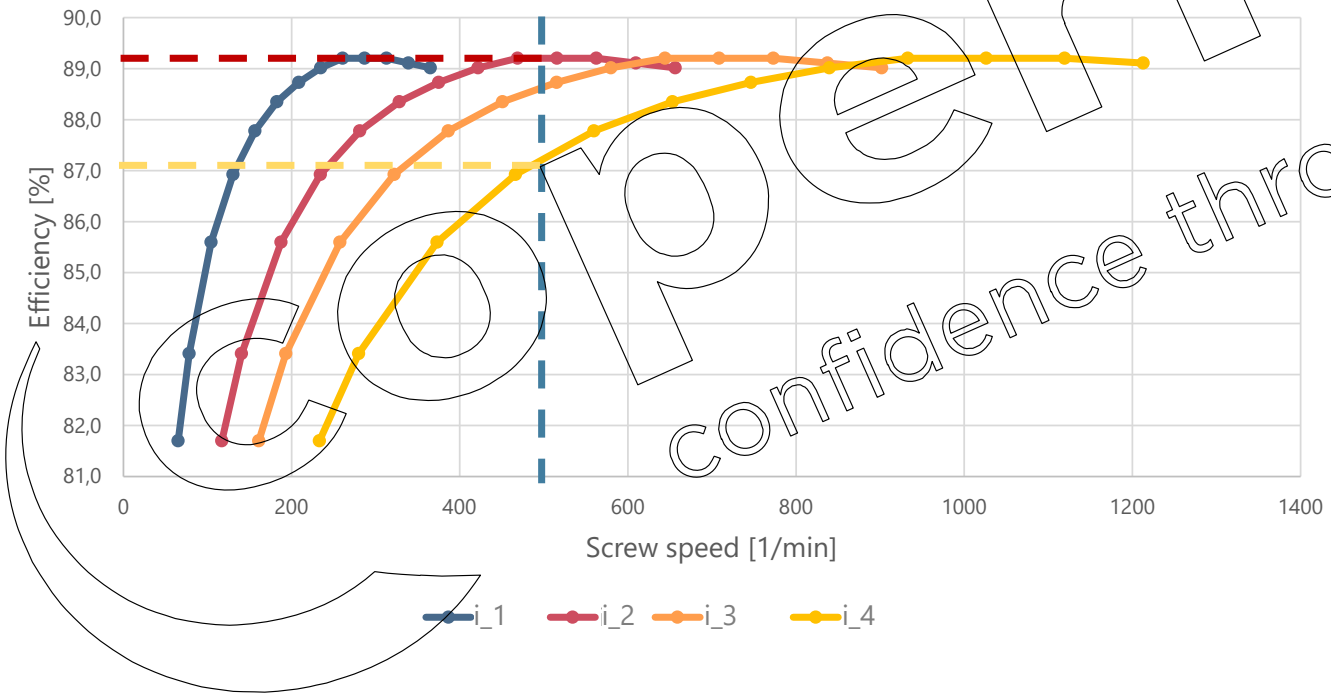
2) 2.0 t/h PA plant (Germany); 60°C feed, 95% availability:

- electricity cost (assumed): 0.17€/kWh
- **Energy saved:** 0.025kWh/kg * 16.000.000kg = **400.000kWh**
- **Money saved:** 0.17€/kWh * 400.000kWh = **68.000€/year**

Example 5: Motor efficiency

Reduction of energy consumption by choosing right motor range

Motor and frequency converter do not have a constant efficiency over the speed range.



Energy Savings

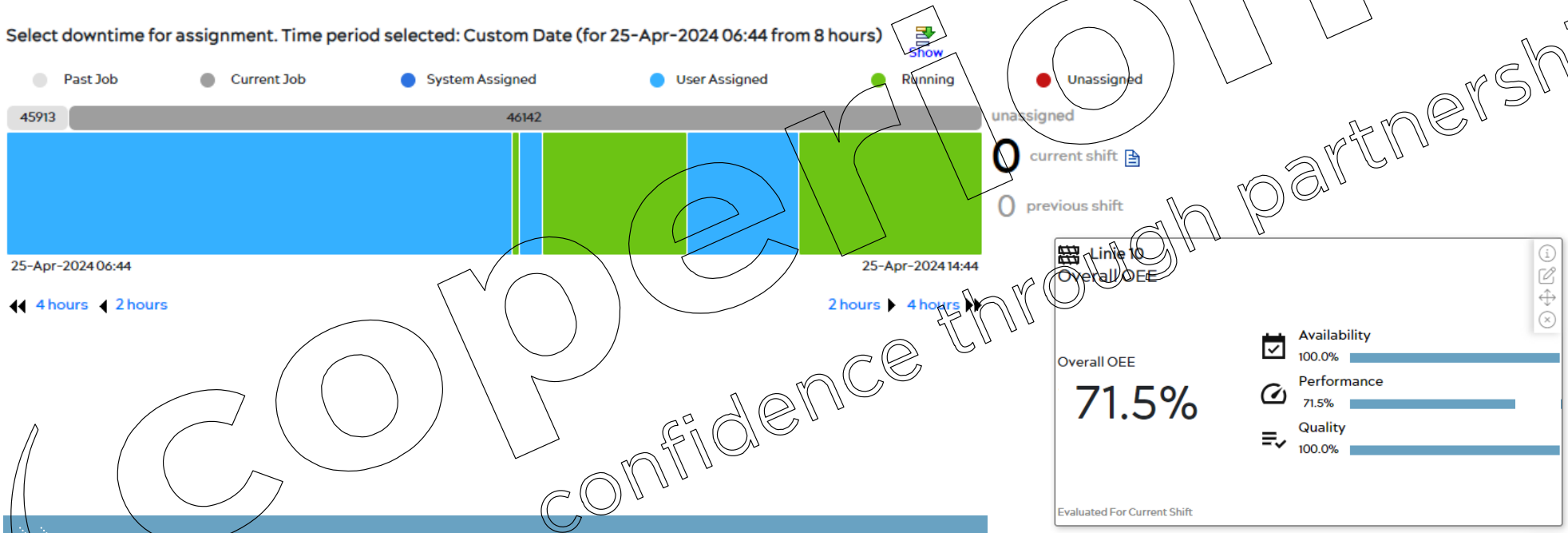
ZSK70Mc^{18}
Design screw speed 600 vs. 1200rpm

- 2% difference in efficiency at 500rpm
- 8,8kW higher efficiency at 4000h

→ 35000kWh savings

Example 6: C-Beyond, Downtime-Tracking and OEE

Reduction of energy consumption by evaluation of unnecessary downtime



Conclusion

By identifying OEE and the most common causes of downtime, situational awareness can be gained to achieve improvements in operations and energy consumption

1 ZSK Twin Screw Compounder and Pelletizers | Functionality, Specific Torque, Specific Energy Input SEI

2 Examples | Specific torque, FET, ZS-EG, Bulk X-Change, C-Beyond

3 Summary

Summary

How to increase energy efficiency

- Automatic Strand conveying can make pelletizing much easier and safer
- Using highest installed specific torque by using high degree of fill can save energy
- Feed Enhancement Technology FET can increase output and degree of fill for formulations with feed limited fine powders
- Side-degassing ZS-EG allows for higher degree of fill and to reduce scrap
- Pre-heating of material with Bulk X-change safes motor power and energy
- The right design of the motor can save energy
- C-beyond assist to determine downtime and increases awareness of energy waste
- Think about modernization by changing drive unit or adding features for increasing torque

Final Conclusion

Increasing energy efficiency is possible by using higher torque with several features, methods or combination of these. Additionally, also profitability can be increased!

Optional Chapter Navigation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