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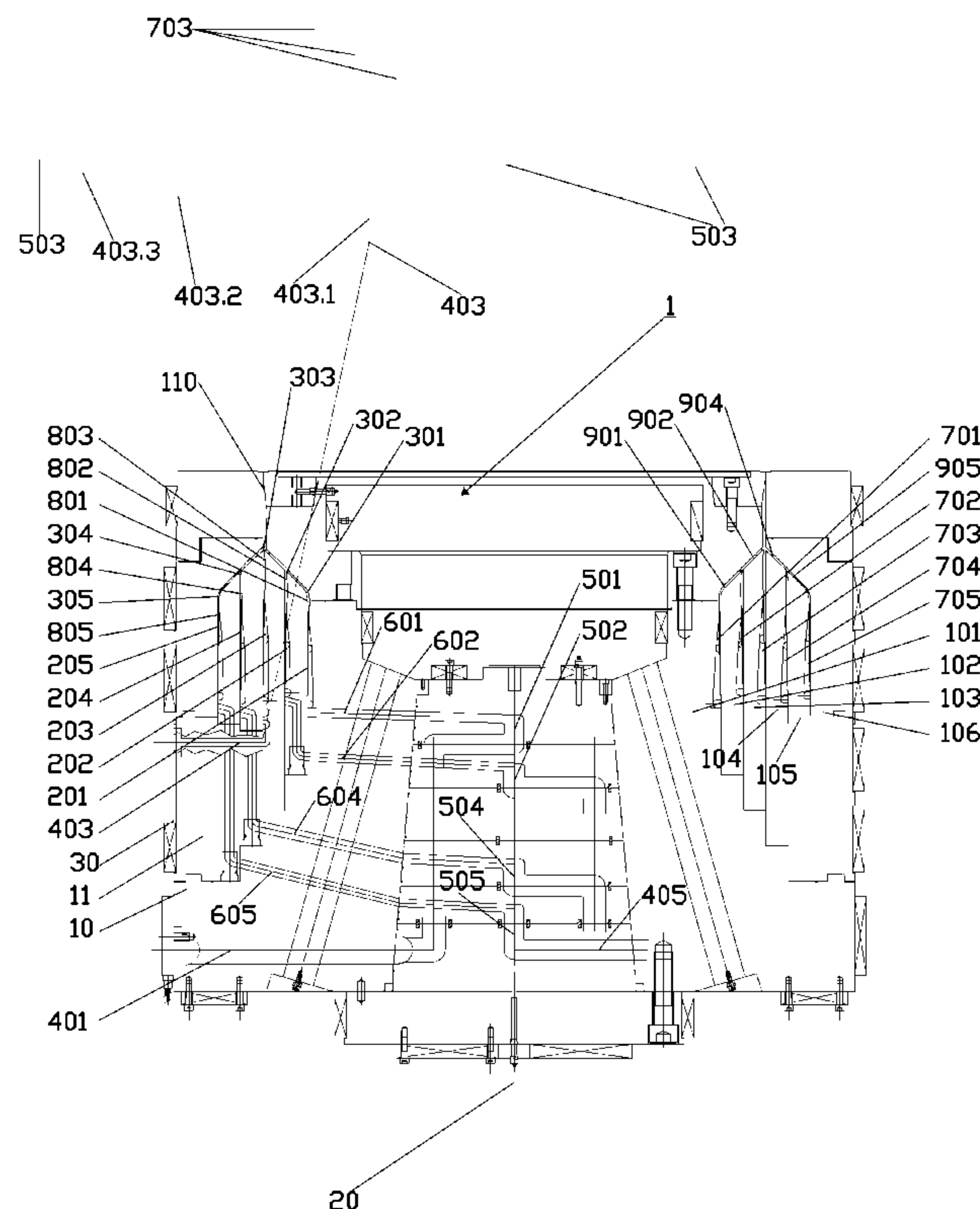


Fig.4

(57) Abrégé/Abstract:

A large concentric co-extrusion die (1) is described having a plurality of annular or conical die mandrel layers (201-205). Each layer is formed between a pair of adjacent annular or conical die mandrels (101-106) defining between them a flow path for molten



(57) **Abrégé(suite)/Abstract(continued):**

thermoplastics material from an inlet to an annular extrusion outlet (110) through which a thermoplastics tubular extrusion is formed in use. Extrusion takes place through the multiple annular layer outlets (301-305) to form a multi-layered product. At least one layer (203) of the annular or conical die mandrels has a plurality of molten material inlets arranged around the external circumference of the co-extrusion die with each inlet being connected to a feed channel (403) which has plural bifurcations (403.1, 403.2, 403.3) providing $2n$ subsidiary outlet feed channels (503) where n is the number of bifurcations. Each subsidiary outlet feed channel being connected to a corresponding helical outlet channel (703).

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(54) Title: CONCENTRIC CO - EXTRUSION DIE AND A METHOD OF EXTRUDING A MULTILAYER THERMOPLASTIC FILM

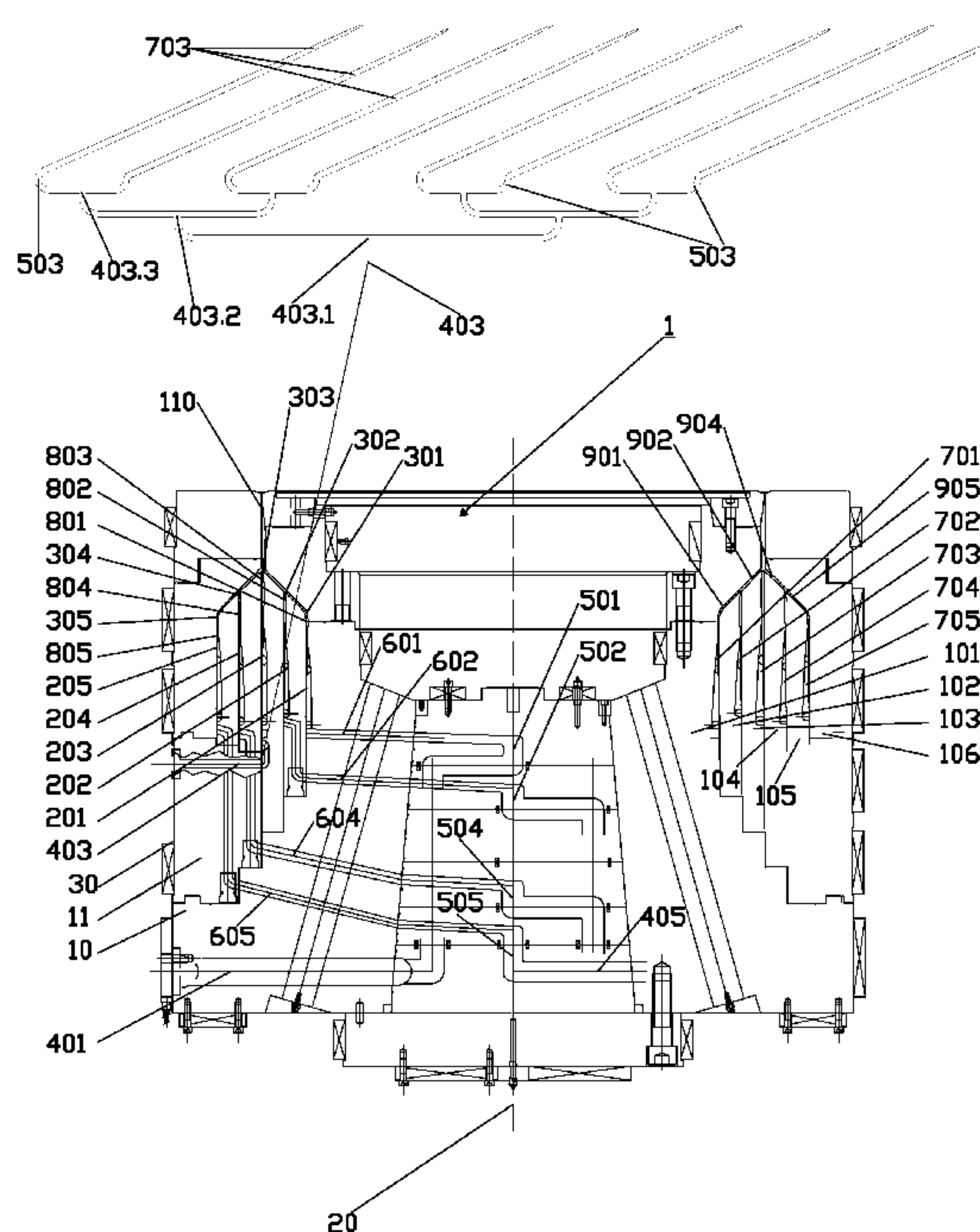


Fig.4

(57) Abstract: A large concentric co-extrusion die (1) is described having a plurality of annular or conical die mandrel layers (201-205). Each layer is formed between a pair of adjacent annular or conical die mandrels (101-106) defining between them a flow path for molten thermoplastics material from an inlet to an annular extrusion outlet (110) through which a thermoplastics tubular extrusion is formed in use. Extrusion takes place through the multiple annular layer outlets (301-305) to form a multi-layered product. At least one layer (203) of the annular or conical die mandrels has a plurality of molten material inlets arranged around the external circumference of the co-extrusion die with each inlet being connected to a feed channel (403) which has plural bifurcations (403.1, 403.2, 403.3) providing 2^n subsidiary outlet feed channels (503) where n is the number of bifurcations. Each subsidiary outlet feed channel being connected to a corresponding helical outlet channel (703).

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CONCENTRIC CO-EXTRUSION DIE AND A METHOD OF EXTRUDING A MULTILAYER
THERMOPLASTIC FILM

The present invention relates to extrusion dies and, more particularly, to co-extrusion dies
5 and especially those for extruding large width blown films using thermoplastic materials.

BACKGROUND

The basic function of any blown film extrusion die is to take one or more melt streams
10 entering the die and distribute them to a single concentric annular melt stream at the die
exit as uniformly as possible.

A number of different types of extruder die are known in the art. Concentric helical mandrel
dies are cylindrical in shape and are mounted one above another secured to a common
15 component to maintain their relative positions. Variations of this design may have, for
example, a central feed where all melt streams are fed to the centre and then split to the
helical outlet channels with radially arranged tubular ports. An example of this type is
shown in US3966377 . Another variation is an annular feed mandrel die in which the melt
streams flow into the die through centrally located concentric annuli and then, through
20 outwardly radially extending tubular ports, to helical outlet channels. This variation can be
implemented in two sub-variations; one with central part of the feed block is open for IBC
tube installation, the other having the inner layer stream as the central pipe of the feed
block. Examples are to be found in US4182603 . A further variation is a side-feed mandrel
die in which each layer has a single melt inlet on the outside of the die and the melt is then
25 distributed in a pair of vertical paths to the entries of the helical outlet channels, each of the
two distribution paths being on the same cylindrical surface as the corresponding helices.
An example is to be found in US7811073.

Conical stacked mandrels stack one over another, with a variation of this design consisting
30 of conical shaped mandrels stacked over one another outside and/or inside a vertical
common path. Several options also exist as to the feeding of the helical entries of these
dies, e.g. central feeding of all layers or side feeding of the layers with horizontal split feed
at different heights. Examples are to be found in US6702563

35 Modular plate mandrels are split two-part modules which, like some conical designs, stack
one on another. There are basically two options; out-in versions in which the melt streams
flow from outside to inside, and in-out versions in which the melt streams flow from inside

to outside of each module. A combination of the two types is also possible. The melt distribution is typically horizontally split but it can also combine some vertical paths to reduce diameter.

- 5 It is also possible to combine the types, for example the basic die being of concentric mandrel type with some layers being of modular plate design, usually for the outer layers of the multi-layer blown film.

WO01/78966 discloses a co-extrusion die with one of the extruded components being fed
10 through a single side inlet into a bifurcated feed channel which supplies the die outlet and similar constructions are shown in WO90/11880 and JP2011005824.

US2004/022886 discloses a single layer extrusion die with side inlets feeding multiple bifurcated feed channels.

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Figure 1 attached shows a five-layer concentric mandrel die 1 with central feeding in accordance with prior art. The die shown in figure 1 has an 1800mm diameter, i.e. for the annular path 110 to which all layers flow after they merge. This diameter also corresponds to the diameter of the mandrels of the middle layer of the die. Since the die is of centre-fed
20 type, all the extruder inlets 401-405 (only two of which - 401 and 405 are shown for simplicity) through which the molten thermoplastic is fed to the die are placed close to the bottom of the die and are spread around the perimeter. As can be seen, such dies have complex internal constructions, requiring the accurate registration of components in the different layers.

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To avoid complexity in the figures only the main elements of parts of the flow paths are shown, but in detail each flow path includes:

- a horizontal inlet part 401-405, which extends to the centre of the die for the outer layer and towards the centre of the main die body 10, but to an off-center point for
30 the remaining layers.
- a path 501-505 directed upwards and making any necessary bends in order to avoid collision with other layers and reach the centre (only path 501 is shown - for simplicity).
- multiple inclined radial ports 601-605 (which may also be horizontal and only port
35 601 is shown). Each of the inclined ports also has an additional vertical path as soon as it arrives at the layer mandrel (the one indicated in the drawing is small but still exists).

The length of each of the flow paths for the layers 201-205 from the die inlet to helical outlet channel start point is, for the layers in turn from inner layer to outer layer, 2772mm, 2776mm, 2803mm, 2834mm and 2893mm.

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Blown film dies exist from sizes of 50mm to 2500mm diameter. Most of the dies that are used for packaging film applications are of a maximum diameter of 900-1000mm and up to eleven layers. These dies are of either concentric mandrel, modular or conical, or mixed. Conical stacked mandrel and modular plate designs can be implemented up to a diameter size of 900mm, flared from 600-700mm. There exist dies of modular plate design which are flared to 1300mm from 600-700mm and which have very long flaring melt flow paths.

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Larger dies (up to 2500mm) are typically of three to five layers and are usually central or annular mandrel dies, typically used for agricultural applications (e.g. greenhouse films) where large film dimensions are necessary (e.g. 8 to 22m bubble circumference, 100 - 200µm thickness), or for geomembrane applications (6 to 8m bubble circumference, 500 - 2500µm thickness)

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In existing concentric dies of side feed design, the material follows a binary split distribution feed channel arrangement from a single side inlet of the layer to the starting point of each extrusion helical outlet. As the die gets bigger in diameter, the length of this flow channel gets longer and longer. As a consequence, higher melt pressures are developed in use and the material residence time gets longer, resulting in increased melt temperatures and material degradation. As a result side feed concentric mandrel dies have been limited to about 1200mm die diameter.

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In a typical large blown film die having 3 to 5 layers and 1800mm die diameter all layers are centrally fed. For the middle layer of the die, this results an overall length between the die inlet to the helical outlet of more than 2700mm (see above reference to figure 1).

As a consequence the average residence time as well as the tail of the residence time distribution become very long. In addition the size of the die does not allow reducing the thickness of a specific layer while maintaining good thickness uniformity of this layer due to the very long paths that the melt has to flow through within the die and the required low material quantity for such layer. Further, the back pressure developed between the layer inlet and the start of the helical outlet becomes very high, reducing the remaining available

pressure which can be used for the helical outlet section of the layer to improve thickness uniformity due to the fact that total available pressure is limited.

5 Residence time and melt distribution around the die circumference is also a very critical issue for large dies, especially for sensitive materials because of carbon build up, high purging time, waste, deposits, etc. (slow moving particles are prone to degradation and long purging time).

10 An example is a 2m diameter, five layer concentric mandrel die where the middle layer is designed to extrude an ethylene vinyl alcohol copolymer (EVOH) film at a very low output and percentage (e.g. less than 4%) and at a very good thickness tolerance distribution around the die circumference.

15 Such materials need to be processed with a very short residence time and also need to be used in very low percentages due to their significantly higher cost in relation to standard materials. As an example, EVOH has a cost which is in the range of 5-6 times higher compared to Polyolefins, therefore in case of a film combining both materials, EVOH has to be used in small percentages in order for the film to be of reasonable cost while maintaining the advantage that using EVOH has as to the barrier properties it provides.

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Thus, it is often desirable to reduce residence time distribution, to minimize wetted surface area (the area where the polymer comes to contact with the metal), to minimize the melt volume inside the die, to optimise back pressure, to avoiding overheating the die, to enable rapid purging for efficient product change-over and reduction of resin waste, to eliminate
25 flow lines in the final products, to eliminate melt fracture, interfacial instability, gels, black spots, carbon built up, etc., to improve operational flexibility in resin selection and processing parameters, to increase output levels and/or efficiency, to improve thickness tolerance of each layer and total film thickness, to improve film optics, and to achieve thermal isolation between layers especially the ones with significantly different processing
30 temperatures.

The present invention targets, in particular, large co-extrusion blown film dies (with mandrel diameter above 1200mm) for producing film bubbles of large circumference (8 to 22m).

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SUMMARY OF THE INVENTION

According to the present invention there is provided a concentric co-extrusion die having a plurality of annular or conical die mandrel layers, each layer comprising a pair of adjacent
5 annular or conical die mandrels defining between them a flow path for molten thermoplastics material from an inlet to an annular extrusion outlet through which a thermoplastics tubular extrusion is formed in use, extrusion through the multiple annular or conical layer outlets forming a multi-layered product, characterised in that

at least one layer of the annular or conical die mandrels has a plurality of molten
10 material inlets arranged around the external circumference of the co-extrusion die, each inlet being connected to a feed channel which has plural bifurcations providing 2^n subsidiary outlet feed channels where n is the number of bifurcations, and each subsidiary outlet feed channel being connected to a corresponding helical outlet channel.

15 Such a construction is especially suited to dies having an annular film output of diameter above 1200 mm.

The molten material inlets arranged around the external circumference of the co-extrusion die may be connected to the corresponding feed channels via respective inlet paths
20 passing through a main body of the die separate from the mandrels.

Alternatively, the molten material inlets arranged around the external circumference of the co-extrusion die may be connected to the corresponding feed channels via respective inlet paths passing through a central die block separate from both the mandrels and from a main
25 body of the die.

The present invention can be implemented for a concentric mandrel die or conical central fed die or a combination of these.

30 It has been found that this significantly shortens the flow path length between the layer inlet and the start of the helical outlet channel compared to the corresponding flow path length for the same layer of the same size in a conventionally centrally fed concentric mandrel die as well significantly shortens residence time in the die. In addition pressure drop is minimised between the layer inlet and the start of the helical outlet channels compared to
35 the pressure drop across the corresponding section of the same layer of a same size centrally fed concentric mandrel die. The reduction in pressure allows the gain in pressure to be used or partially used in the helical section of the layer to improve thickness

uniformity. This results in better controlling of the uniformity of thickness of this layer by optimising the distribution of the melt flow around the circumference of the die.

In addition, although the presence of multiple side entry inlets may complicate the construction of the die as the side inlets have to pass through multiple other layers of the die, avoiding interference with channels in the other layers, and hence is counter-intuitive, due to the peripheral feed of the material and the shorter flow paths the melt is distributed around the circumference in an optimal way resulting in uniform thickness distribution even at very low percentages and outputs of the respective layer(s).

These factors are particularly important when using certain thermoplastic materials such as EVOH, Polyamide, PVDC and fluoropolymers as explained above, and particularly in a composite, multi-layer film where obtaining the right matching conditions between the films is also important.

In a die of the invention, the total number of layers of the die can be from two to twenty one and the number of side feed layers from one to eleven correspondingly. The side fed layers can have a plurality of molten material inlets with bifurcated feed channels disposed over a part or all of their length in one or more of a vertical, horizontal or conical orientation according to the type of mandrel used. The remaining layers can have central or annular feeding.

The number of inlets of the said layers may be between 2 to 16.

These types of dies can be installed in either a blow up configuration or in a blow down configuration.

It is also possible to have different materials for each of the extruders supplying the mandrel, resulting in different properties around the circumference of the film and resulting bubble.

Another possibility is to improve the thickness tolerance by controlling separately the throughput of each extruder supplying said mandrel, and in this way to correct thickness deviations around the bubble circumference. This can be done with or without melt pumps and can be connected with a thickness measurement unit for on-line thickness control.

The invention includes a method of extruding a multi-layer thermoplastic film using a co-extrusion concentric die as defined above. Material of particular interest which can be extruded through the at least one layer according to this method may be comprised of a polyamide or ethylene vinyl alcohol copolymer (EVOH) or PVDC or fluoropolymers.

- 5 Additional materials of particular interest for this method are Thermoplastic Polyurethanes (TPU) or Polybutene-1 (PB-1).

BRIEF DESCRIPTION OF THE DRAWINGS

- 10 Examples of multi-layer concentric annular dies according to the prior art and the invention are shown in the accompanying drawings, in which:

Figure 1 (Prior art) is a longitudinal section of a prior art design of a five-layer concentric annular extrusion die;

- 15 Figure 2 (Prior Art) is a longitudinal section through a conventional side fed co-extrusion die of relatively small dimensions;

Figure 3 (Prior Art) is a longitudinal section of a conventional design of a seven-layer concentric annular extrusion die;

- Figure 4 has a main view which is a longitudinal section of a first example of a five-layer concentric annular co-extrusion die with the melt flow path of the middle extrusion outlet layer (3rd layer) , and a secondary view showing a developed partial annular section through the middle layer, in accordance with the invention;
- 20

Figure 5 shows, plan view, an arrangement of extruders around the co-extrusion die of fig 4;

- 25 Figure 6 is similar to Figure 4, but showing another co-extrusion die with the melt flow path of the 5th, outer, layer and developed, in accordance with the invention;

Figure 7 is a plan view, similar to that of Figure 5, but showing an arrangement of extruders around a seven-layer extrusion die;

- Figure 8 shows the corresponding longitudinal and developed sections for the co-extrusion die of Figure 7;
- 30

Figure 9 shows another embodiment of the corresponding longitudinal and developed sections for the co-extrusion die of Figure 7;

Figure 10 shows a top view of a modular plate section providing the outer layer of a concentric die;

- 35 Figures 11A-11F are partial cross-sectional views of parts of respective concentric dies to illustrate the form and position of the channels relative to die components; and

Figures 12 and 13 illustrate a multi-layer concentric die in longitudinal section and plan view respectively, with two side-fed layers being fed from the same extruders.

5 DETAILED DESCRIPTION OF EXAMPLES IN ACCORDANCE WITH THE INVENTION

In the examples described below, the mandrel exit diameter is shown to be 1800 mm. However co-extrusion dies according to the present invention can have any desired exit diameter, but are especially suitable for diameters in the range of 1300 to 2500 mm. The detailed design of all parts depends on the final application as well as required residence time, pressure and other rheological parameters.

In the detailed description that follows, all the data of the dies mentioned (dimensions, number of extruders, total number of layers, number of layers which are side fed with multiple inlets, number of inlets per layer, number of bifurcations, number of spirals overlaps, number of spirals, number of radial ports, inclination of ports, inclination of side feed inlets etc) are indicative and only for the purpose of the examples.

In figure 4, a longitudinal section of a first concentric co-extrusion die is shown as well as a developed partial annular section of the middle layer. The co-extrusion die 1 has six concentric mandrels 101-106 which define between them five annular extrusion layers 201-205, the outlets 301-305 of which feed an annular exit 110. The die mandrels 102,103 are supported on a main die body 10, part of which forms the die mandrel 101, whereas the die mandrels 104,105,106 are supported on a central die block 11 as described in more detail below.

The layers 201,202,204 & 205 have conventional feed channel arrangements in which the melt of each layer follows a generally horizontal inlet path, 401,402,404,405 respectively through the main die body 10 (note that because of the position of the section the inlet paths 402 & 404 are not shown in figure 4) towards the central axis 20 of the die and each of which paths is then directed upwardly (as shown) along feed channels 501,502,504,505 (making any necessary bends in order to avoid collision with the melt stream flow paths of other layers). At the end of the feed channels where the respective feed channel arrives at the centre of the die, it splits into a number of radial channels, 601,602,604,605 respectively, typically 16 for each layer, directed from the centre to the periphery of the main die body 10. Only one of these radial channels for each layer is shown in figure 4.

The outlets of the radial channels are evenly distributed around the main die body leading into the respective outer circumference of the respective mandrel.

The radial channels 601 and 602 extend to the respective mandrel of the corresponding layer, where they are further split into two (not shown), and each such split feeds a single helical outlet channel 701,702 respectively, of the layer, so that each radial channel supplies two helical outlets. The helical outlets feed respective annular channels 801,802 which in turn feed inclined conical outlet channels 901,902 which extend to the annular die exit 110 as shown, where, in operation, all the individual layers of the film are brought together in the final annular extrusion. The channels 604,605 on the other hand take a slightly different form as they extend to a central die block 11, at which point they turn so as to lie generally parallel to the die axis 20 before entering into the corresponding die layers 204, 205. In other respects their paths are similar to the radial channels 601,602. At the respective mandrel of the corresponding layer, they are further split into two (not shown), and each such split feeds a single helical outlet channel 704,705 respectively, of the layer, so that each radial channel supplies two helical outlets. In an alternative form, the channels 604,605 may be split within the central die block 11, with or without further splits occurring within the mandrels. The helical outlets feed respective annular channels 804,805 which in turn feed inclined conical outlet channels 904,905 which extend to the annular die exit 110 as shown, where, in operation, all the individual layers of the film are brought together in the final annular extrusion.

However, layer 203 is fed, in accordance with the present invention, from the side, as indicated in the figure 4, through four horizontal inlet feed channels 403 (only one of which is shown in the section of figure 4), extending directly from the external circumference 30 of the die through a central die block 11 until it reaches the outer annular surface of mandrel 103 corresponding to the third or middle layer 203. After reaching the surface of mandrel 103, each feed channel 403 is bifurcated three times (as shown in the developed section of figure 4 at 403.1, 403.2, & 403.3) so that, ultimately, each feed channel 403 feeds eight subsidiary feed channels 503, each of which in turn feeds a respective helical outlet 703 of the layer 203, there thus being 32 in total for the layer 203. The central die block 11 which is formed as a single annular component, interfaces with the lower annular surfaces of the mandrels 104,105,106 to support them and also with the external circumferential surface of the mandrel 103 and provides a route for the feed channels 403 which avoids the need for complex sealing and/or registration between the mandrels 104,105,106 were the feed channels to have to pass directly through each of those mandrel layers. The central die block 11 thus also effectively shortens the die mandrels 104-106,

The bifurcated distribution of a single one of the four feed channels 403 is indicated in the developed partial annular section of figure 4. In table 2 below, the length between the inlets of the middle layer to the die and the entry 403.3 of the last bifurcation before the inlet of the corresponding helical outlets has been calculated. For the middle or third layer and it is 940 mm. This example can be compared to the prior art die of figure 1 where the length of the flow path of the same middle layer of the same diameter die is calculated as 2803mm. As one can see, with the length of feeding path of the central layer of the die fed according to prior art being 2803mm as indicated in table 1, while the length of the same path according to the present invention is 940 mm (as indicated in table 2 below), there is a 66.4 % reduction in overall length. Given that the path length has very important impact on residence time and back pressure, such a reduction will also reduce the residence time and back pressure, thus enabling the use of heat sensitive materials in dies (especially larger ones).

In addition, having less pressure drop in the distribution section of the flow path enables more pressure to be available to be consumed (totally or in part) in the helical outlet channels 701-705. This improves thickness uniformity. If the pressure margin is only partially consumed at the helical outlets or if it is not consumed at all, reduced backpressure at the die inlet results, which is also an advantage, since reduced pressure also results in a reduction of the melt temperature.

Table 1

Layer length calculation of a prior art 5 layer centrally fed co extrusion die		
Layer	Diameter	Total length
A (inner)	1480	2772
B	1640	2776
C(<u>middle</u>)	1800	2803
D	1960	2834
E (outer)	2120	2893

Figure 5 shows a top view of the concentric die extruder of figure 4 for a five layer blown film line. In this embodiment, the middle layer 203 of the five layer line extrusion die 1 has side feed from four small extruders 2, while the remaining layers 201,202,204,205 are each centrally fed each by a single larger extruder, 3.

While four extruders, one corresponding to each inlet channel 403 are shown in figures 4 and 5, other numbers of extruders could be used in order to feed the central or third layer 203 of the extruder. For example, two or three extruders can be used with a corresponding number of inlet feed channels 403.

5

In addition, any layer could be side-fed supplied with any desired number of extruders, while also more than one layer (two, three etc) could be side fed simultaneously in accordance with the present invention. Further, the extrusion die can have any number of layers equal to or more than two and any diameter, especially above 1300mm.

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In other embodiments one extruder can feed more than one said layer from each side of the die.

In a further embodiment according to the present invention shown in Fig 6, outer layer 205 is side fed through feed channel 405' which passes through the mandrel 106. In this case, referring to table 2 below, the flow path length is 874 mm. The length of flow path for the same layer of a die according to the prior art is 2893 mm as shown in the above table 1, therefore providing a 69.7% reduction in length according to this example of the invention.

20 Table 2

Layer length calculations for a 5 layer co-extrusion die of the example		
Layer	Diameter	Total length
C(middle)	1800	940
E (outer)	2120	874

In figure 7 another embodiment in accordance with the present invention is shown. In this case, we have the top view of a seven layer die. In this die layers 201,202,203,205,206,207 are each centre fed by a respective extruder 3. Layer 204 is side fed by four smaller extruders 2.

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Figure 8 shows a first embodiment of the longitudinal and developed sections of the 1800mm die of figure 7. Melt feed to the layer 204 is implemented with four inlets 404 in accordance with the present invention, with the inlet channels 404, like the inlet channel 403 of figure 4, passing through a central die block 11 directly to the layer 204. The length

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calculated is 1020mm as shown with reference to table 3 below. Comparing this to the same layer of the corresponding prior art die design, we can see that for a die design implemented according to prior art the corresponding length is 2968mm as shown in table 5 below. Therefore, according to the present invention, we have a length reduction of 65.6%.

Table 3

Layer length calculations for a 7 layer co-extrusion die of the examples		
Layer	Diameter	Total length
D(middle)	1800	1020
G (outer)	2280	922

Figure 9 shows another embodiment of the longitudinal and developed sections of the 1800mm die of figure 7. Melt feed to the layer 204 is implemented with four inlets 404 in accordance with the present invention entering the die directly through the main body 10 of the die and then turning to be parallel with the die axis 20 before entering the mandrel . To allow machining of the parallel portion 404' it is drilled from the lower surface 12 of the main die body 10 and the lower part 404" is then closed by a plug. The length calculated is 1320mm as shown with reference to table 4 below. Comparing this to the same layer of the corresponding prior art die design, we can see that for a die design implemented according to prior art the corresponding length is 2968mm as shown in table 5 below. Therefore, according to the present invention, we have a length reduction of 55.5%. In a further embodiment (not shown) the radial part of the channel inlet 404 may extend through a pipe to the bottom of the channel portion 404" rather than through the main die body 10.

Table 4

Layer length calculations for a 7 layer co-extrusion die of the examples		
Layer	Diameter	Total length
D(middle)	1800	1320
G (outer)	2280	922

For a corresponding seven layer central fed concentric die of prior art design shown in figure 3 (of 1800mm die diameter) the lengths of each of the melt flow paths is indicated in table 5 below.

5

Table 5

Layer length calculation of a prior art 7 layer centrally fed co extrusion die design		
Layer	Diameter	Total length
A (inner)	1320	2999
B	1480	2902
C	1640	2936
D(middle)	1800	2968
E	1960	3023
F	2120	3119
G (outer)	2280	3087

10

Comparing tables 3 and 4 with table 5, we can conclude that for the outer layer G we also have a significant reduction in length by 2165 mm or 70.1%

The feed to other layers of the die shown in figures 7, 8 and 9 can also be implemented in a similar way if desired.

15

Calculations in respect of a known 450mm diameter five layer concentric mandrel die (shown in figure 2) with side feeding from a single inlet and bifurcated feed channels have also shown the flow path length for the central layer to be 1141mm. This is compared with the 1800mm die of figure 4 which shows a flow path length of 940mm, Thus, even a prior art concentric die of much smaller diameter has longer flow paths than a co-extruder die of the invention.

20

In all embodiments the bifurcated channel can be disposed, over a part or all of its length, in one or more of a vertical, horizontal or conical orientation, depending on die construction

25

and position as illustrated, by way of example, in Figures 11A to 11F. Furthermore, a given bifurcated channel BC can be positioned either wholly within the body of one of the die mandrels M, at the surface of a particular mandrel M (see for example Figures 11B, 11C and 11F) or partly within each of two adjacent mandrels M of the die which can be oriented
5 vertically, horizontally or conically (see for example Figures 11A, 11D and 11E). In addition, combinations of the above positioning of the channel can be implemented for example the bifurcated channel could be positioned partly within the body of one of the die mandrels over a part of its length and partly within each of two adjacent mandrels over a different part of its length. Any such combination is possible depending on requirements. Also, the
10 bifurcated channel may be of different cross-sectional shapes, as shown in Figures 11A to 11F. The cross-sectional shape of the feed channels can be circular, oval or any other shape which can be machined and may vary over its length.

It is possible to have one or more modular plate die sections in the outer layer(s) of a
15 concentric die in accordance with the invention. In figure 10 such a design is shown, with a modular plate 6 of 1800mm. In this embodiment, four inlets 403 are provided which are bifurcated in a similar manner to the examples above and in this case the flow path length to the end of the 32 helical outlet channels 703 is 1056mm. So again, a reduction in flow path length is possible and similar to that achieved in the previous examples.

20 It is to be noted that all lengths mentioned in the above examples and tables are indicative and they can vary according to the detail design. However in all cases the lengths of a die implemented according to the present invention are much shorter compared to a prior art die of comparable size and number of layers.

25 In a further embodiment shown in figure 12, one or more of the extruders 2 can be arranged to supply melt to more than one layer. For example this can be achieved by splitting the output channel 21 of an extruder 2 into two output channels 213, 215, each of which connects to and supplies a different die layer 207, 204. In this case it is possible (but not
30 necessary) to use melt pumps 22 for exact control of the flow to each inlet. Figure 13 illustrates the arrangement as a top plan view for further understanding.

Further it is also possible that one single inlet, e.g. 405' can be arranged to supply more than one layers of the die, e.g. 204 and 205.

35 Further, it is also possible that the exit of a bifurcated feed channel, e.g. 403.1, 403.2, or 403.3, is arranged to supply the helical channels of more than one layer.

Although the figures of the various examples of the invention show that the bifurcations of the inlet channels extend mainly in planes normal to the axis 20 of the dies, it is possible for the bifurcation branches to extend at least partially in the axial direction of the die, i.e. so that they are either substantially parallel with the axis 20 or else angled to it.

Table 6 below illustrates a comparison of pressures and residence times between a prior art die and one of similar size but in which the middle layer is implemented according to the present invention. Specifically, the pressures and residence times have been calculated for the middle layer of a prior art 7 layer concentric centrally fed co-extrusion die design of 1800 mm diameter. These pressures and residence times have been calculated for three different materials Linear Low density polyethylene (LLDPE), Polyamide (PA) and Ethylene vinyl Alcohol (EVOH). In addition, two levels of shear rate have been considered, $10 - 13\text{s}^{-1}$ and 15s^{-1} . The same calculation has been repeated for a 7 layer die of 1800 mm diameter in which the middle layer has been implemented to be side fed from four inlets according to the embodiments presented in the figures 8 and 9 . As the table indicates, an improvement from 50 to 60% in the side fed layer can be achieved for both pressure and residence time in comparison to a prior art centrally fed die.

Table 6

COMPARISON EXAMPLE INDICATING THE PRESSURE DROP AND RESIDENCE TIME IMPROVEMENT											
DIE DIMENSIONS AND LAYER PERCENTAGES USED IN THE EXAMPLE											
Die gap diameter (mm):	1800										
Number of layers	7										
Output (Kg/h):	1800										
Film total thickness (μm):	180										
Die layers location	inner			middle				outer			
Die layers number	1	2	3	4	5	6	7				
Die layers code	A	B	C	D	E	F	G				
Layer percentage - example	18.33%	15.00%	15.00%	3.33%	15.00%	15.00%	18.33%				
Middle layer output (Kg/h):				60							
Middle layer thickness (μm):				6							
Below is a simulation (based on the Carreau model) of the embodiment shown in fig. 8											
Data for middle layer		Middle layer centrally fed (prior art)				Middle layer side fed with 4 inlets				Comparison results (% in respect to prior art)	
Material	Melt temp (°C)	Total length (mm)	Total pressure drop (bar)	Residence time (sec)	Shear Rate (1/s)	Total length (mm)	Total pressure drop (bar)	Residence time (sec)	Shear Rate (1/s)	Pressure drop (%)	Residence time (%)
LLDPE	220	2968	283	124	13	1020	112	49	13	60.4	60.4
		2968	327	113	15	1020	130	45	15	60.2	60.4
PA	230	2968	138	150	10	1020	55	60	10	60.1	60.4
		2968	227	115	15	1020	90	46	15	60.4	60.4
EVOH	210	2968	290	156	10	1020	115	62	10	60.3	60.4
		2968	447	120	15	1020	178	48	15	60.2	60.4
Below is a simulation (based on the Carreau model) of the embodiment shown in fig. 9											
Data for middle layer		Middle layer centrally fed (prior art)				Middle layer side fed with 4 inlets				Comparison results (% in respect to prior art)	
Material	Melt temp (°C)	Total length (mm)	Total pressure drop (bar)	Residence time (sec)	Shear Rate (1/s)	Total length (mm)	Total pressure drop (bar)	Residence time (sec)	Shear Rate (1/s)	Pressure drop (%)	Residence time (%)
LLDPE	220	2968	283	124	13	1320	140	62	13	50.5	50.5
		2968	327	113	15	1320	162	56	15	50.5	50.5
PA	230	2968	138	150	10	1320	68	74	10	50.7	50.7
		2968	227	115	15	1320	112	57	15	50.7	50.7
EVOH	210	2968	290	156	10	1320	143	77	10	50.7	50.7
		2968	447	120	15	1320	221	59	15	50.6	50.7

Carreau is a well known rheological model which is used for simulating the rheological behavior of melt plastics. The 'layer percentage' shown in the first part of the table for each layer is the percentage of material by (presumably) weight.

Further simulations have shown that it is possible to run EVOH in the middle layer of a 1800 mm die configured with four (4) extruders feeding the die from the side as proposed by the present invention, and achieving output down to 33 kg/h with process conditions (shear stresses, shear rate, residence time, etc) according to raw material suppliers

5 recommendations.

AMENDED CLAIMS

received by the International Bureau on 14 December 2012 (14.12.2012)

1. A concentric co-extrusion die having an annular extrusion outlet having a diameter equal to or greater than 1300mm and having a plurality of annular or conical die mandrel
5 layers, each layer comprising a pair of adjacent annular or conical die mandrels defining between them a flow path for molten thermoplastics material from an inlet to the annular extrusion outlet through which a thermoplastics tubular extrusion is formed in use, extrusion through the multiple annular layer outlets forming a multi-layered product, characterised in that
10 at least one layer of the annular or conical die mandrels has a plurality of molten material inlets arranged spaced apart around the external circumference of the co-extrusion die, each inlet being connected to a feed channel which has plural bifurcations providing 2^n subsidiary outlet feed channels where n is the number of bifurcations, and each subsidiary outlet feed channel being connected to a corresponding helical outlet
15 channel.
2. A concentric co-extrusion die according to claim 1, wherein the molten material inlets arranged around the external circumference of the co-extrusion die are connected to the corresponding feed channels via respective inlet paths passing through a main body of
20 the die separate from at least some of the mandrels.
3. A concentric co-extrusion die according to claim 1, wherein the molten material inlets arranged around the external circumference of the co-extrusion die are connected to the corresponding feed channels via respective inlet paths passing through a central die
25 block separate from the mandrels and from a main body of the die.
4. A concentric co-extrusion die according to any of claims 1 to 3, having plural said layers each having a plurality of molten material inlets arranged around the external circumference of the co-extrusion die, each inlet being connected to a feed channel which
30 has plural bifurcations.
5. A concentric co-extrusion die according to claim 4, wherein each of said layers having a plurality of molten material inlets has the same number of inlets.
- 35 6. A concentric co-extrusion die according to claim 4, wherein one or more of said layers has a different number of inlets from one or more of the others of said layers.

7. A concentric co-extrusion die according to any of claims 1 to 6, wherein the annular mandrels are cylindrical or conical.

8. A concentric co-extrusion die according to any of claims 4 to 7, wherein the number of bifurcations in each of said layers having a plurality of molten material inlets is the same in each said layer.

9. A concentric co-extrusion die according to any of claims 4 to 7, wherein the number of bifurcations in one or more of said layers having a plurality of molten material inlets is different from the number of bifurcations in one or more of the others of said layers.

10. A concentric co-extrusion die according to any of claims 1 to 9, wherein the or each said layer having a plurality of molten material inlets has bifurcated feed channels disposed over a part or all of their length in one or more of a vertical, horizontal or conical orientation.

11. A concentric co-extrusion die according to claim 10, wherein the orientation of the bifurcated feed channels in all said layers is the same.

12. A concentric co-extrusion die according to claim 10, wherein one or more of said layers has a different orientation of the bifurcated feed channels from one or more of the others of said layers.

13. A concentric co-extrusion die according to any of the preceding claims, further including an additional layer comprises a modular plate, having a plurality of inlets for the supply of molten polymer and arranged to provide the outer layer of the extruded film.

14. A concentric co-extrusion die according to any of the preceding claims, further including a plurality of additional layers each comprising a modular plate, each plate having a plurality of inlets for the supply of molten polymer, said plates being arranged to provide the outer layers of the extruded film.

15. A concentric co-extrusion die system having a concentric co-extrusion die according to any of claims 1 to 14 and a plurality of thermoplastic material extruders supplying the or each said layer with molten material.

16. A concentric co-extrusion die system according to claim 15, in which each extruder supplies one or more inlets of one or more layers of the die.

17. A concentric co-extrusion die system according to claim 15 or claim 16, wherein all or part of said extruders are connected to the inlets of the die via melt pumps.
- 5 18. A method of extruding a multi-layer thermoplastic film using a co-extrusion concentric die according to any of the preceding claims.
- 10 19. A method according to claim 18, wherein the material extruded through the at least one layer is comprised of a polyamide or ethylene vinyl alcohol copolymer (EVOH) or PVDC or a fluoropolymer.
20. A method according to claim 18, wherein the material extruded through the at least one layer is comprised of a Thermoplastic Polyurethane (TPU) or Polybutene-1 (PB-1).

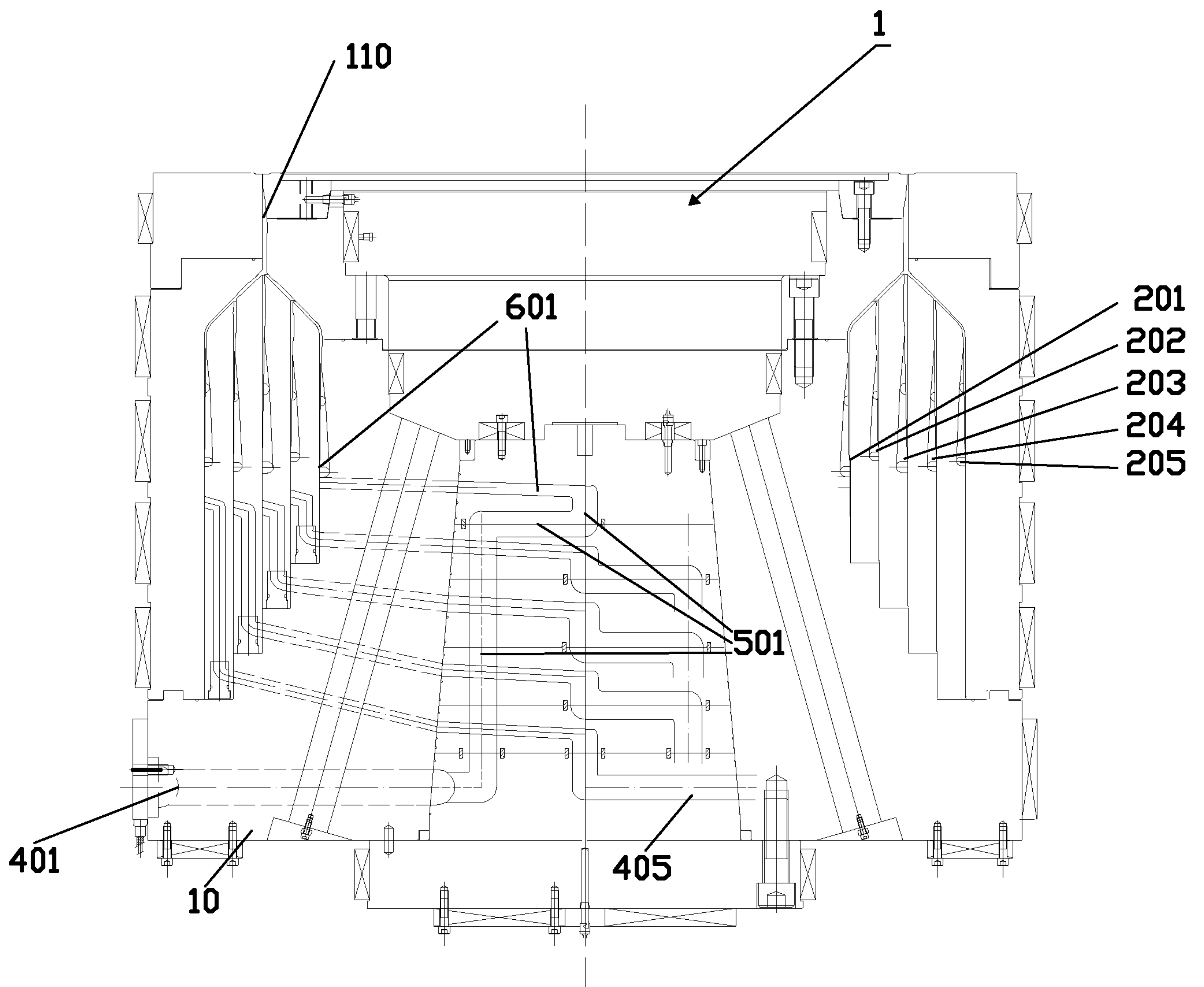


Fig.1 (PRIOR ART)

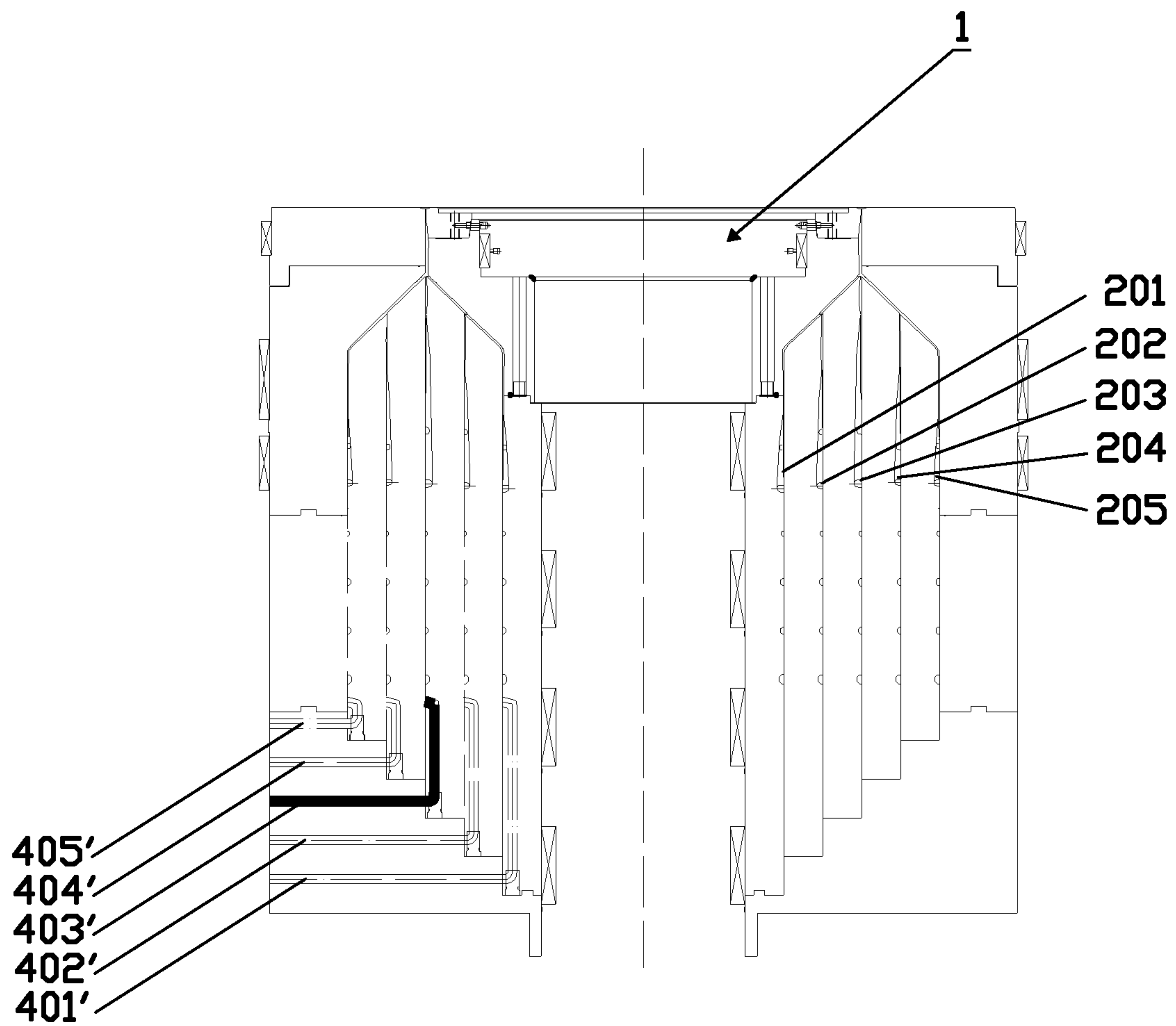


Fig.2(PRIOR ART)

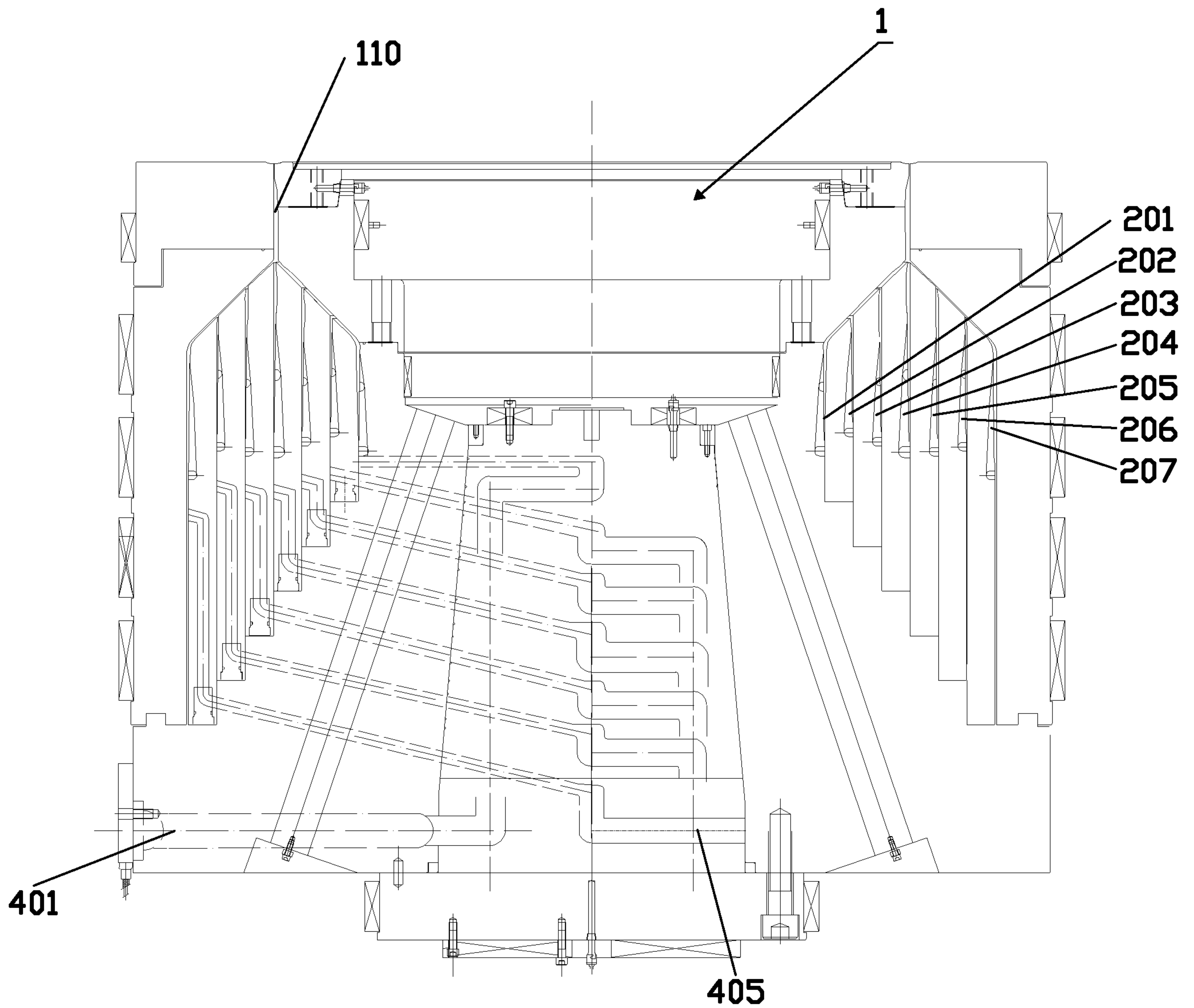


Fig.3(PRIOR ART)

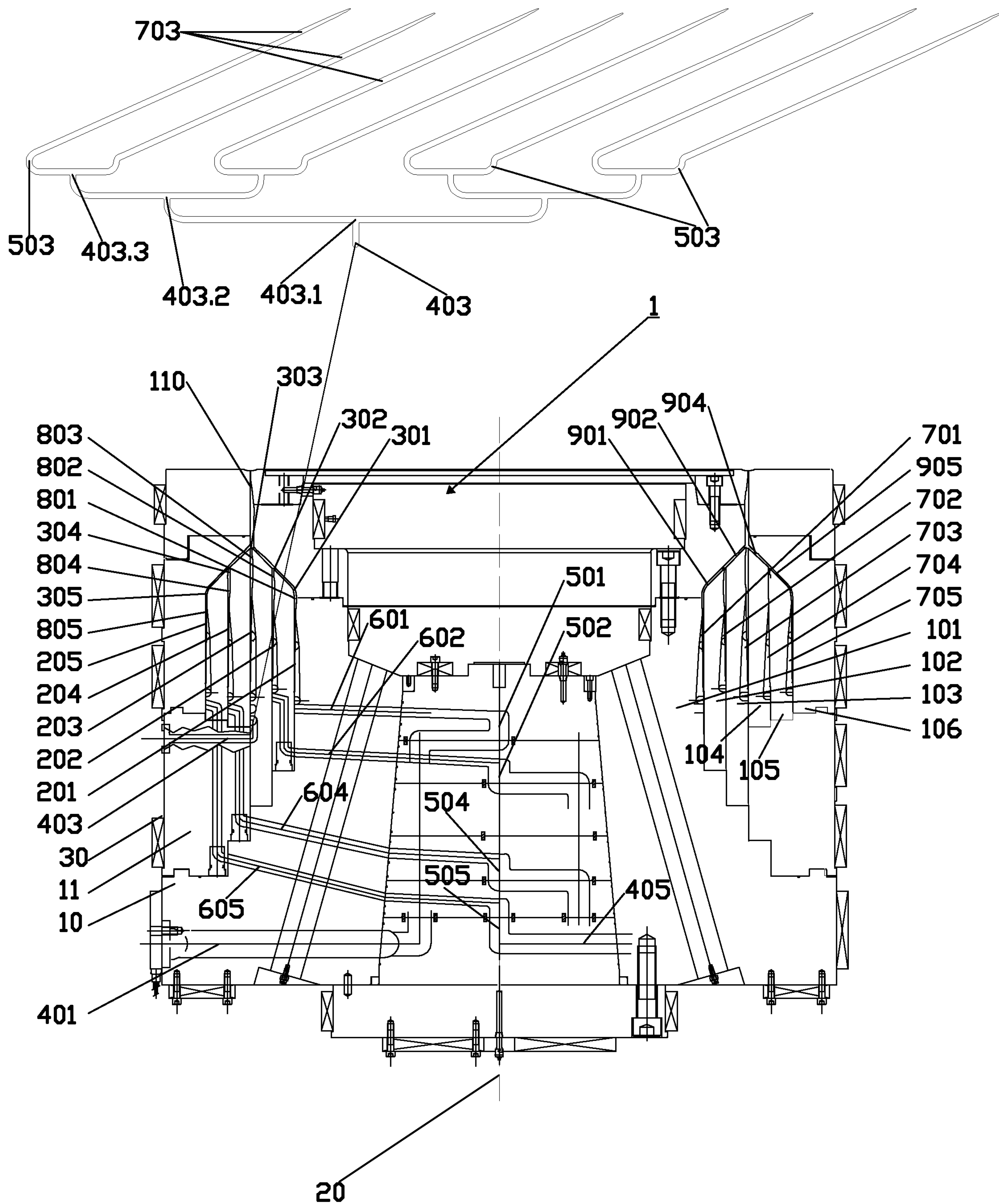


Fig.4

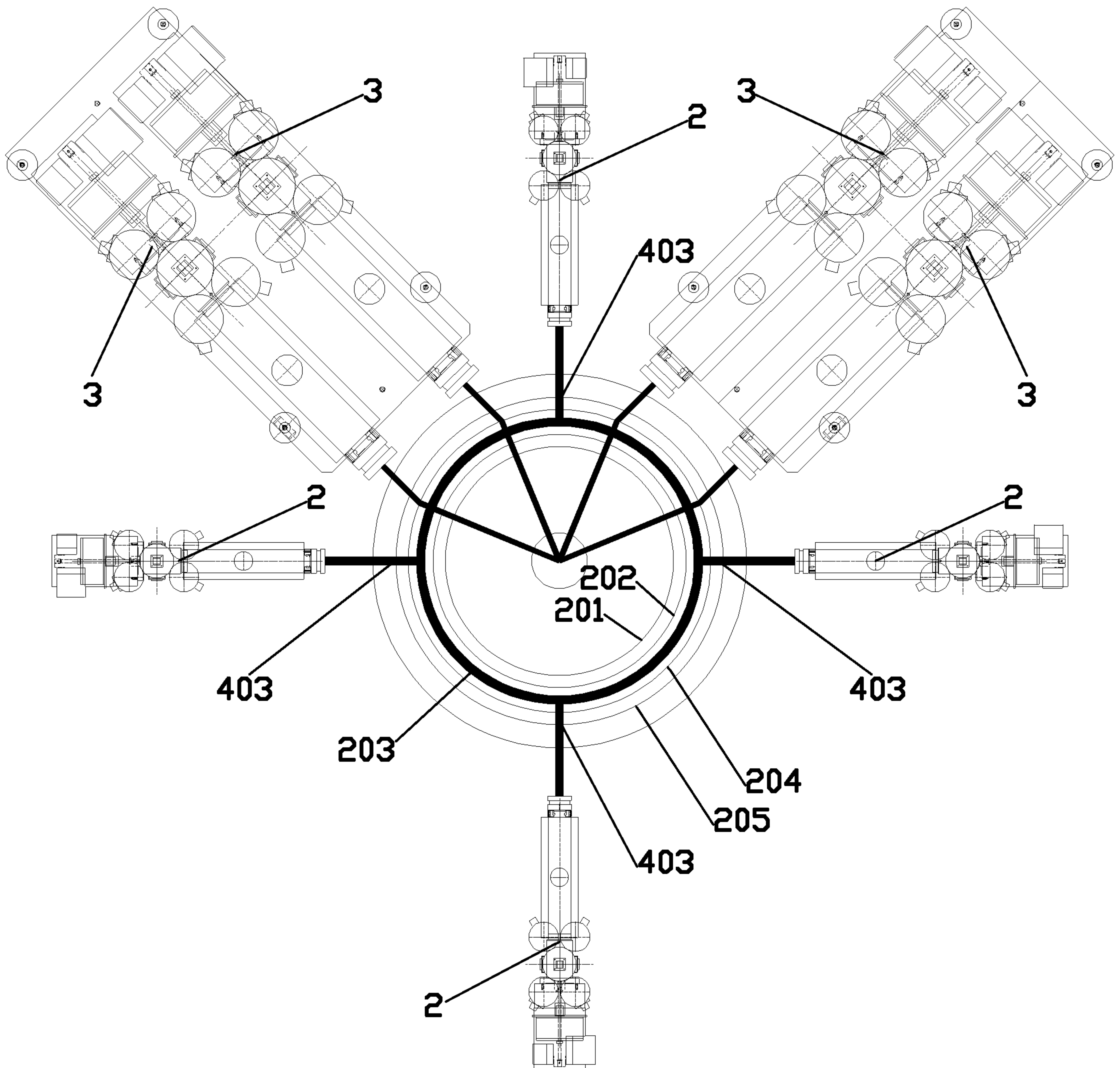


Fig.5

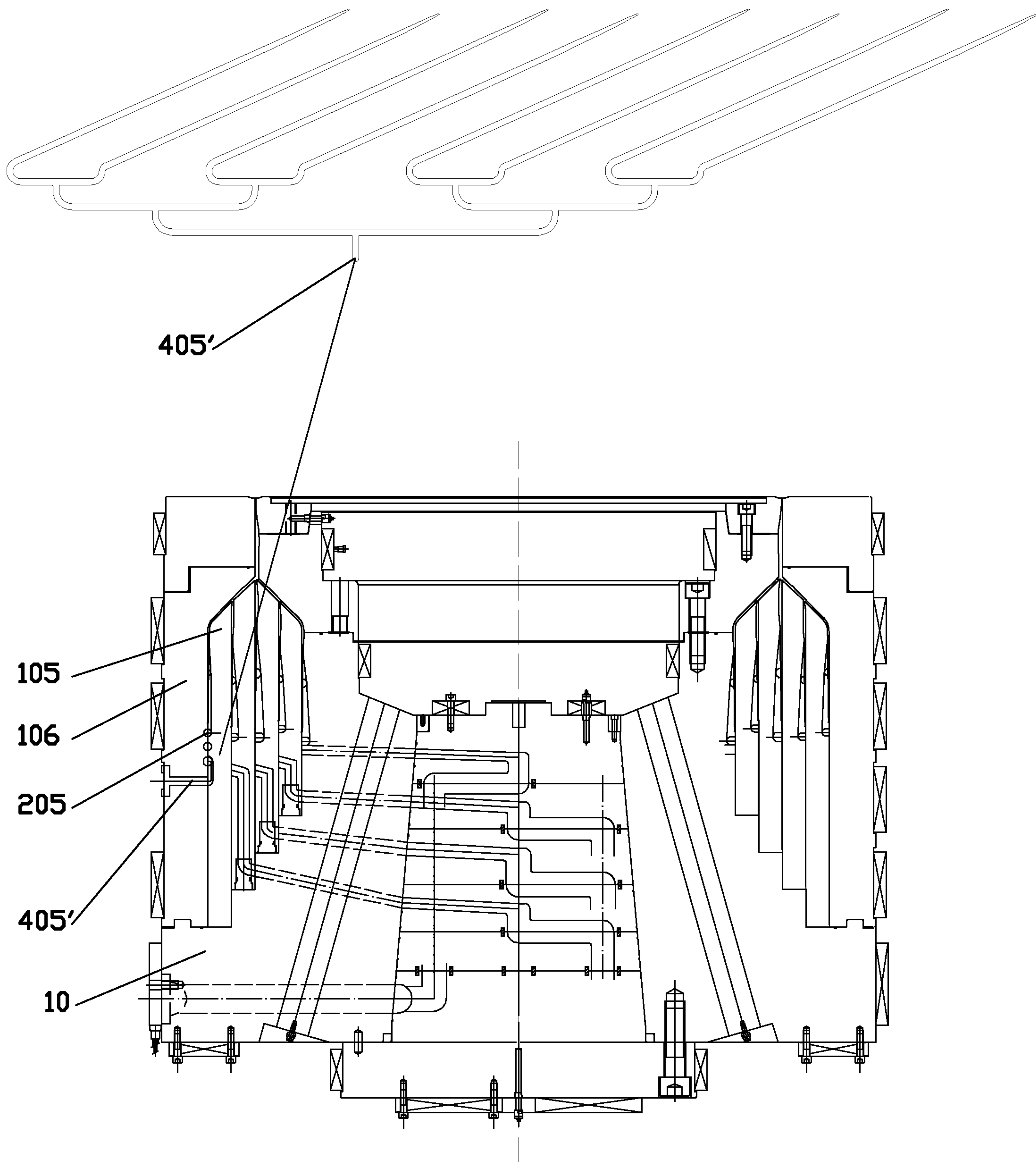


Fig.6

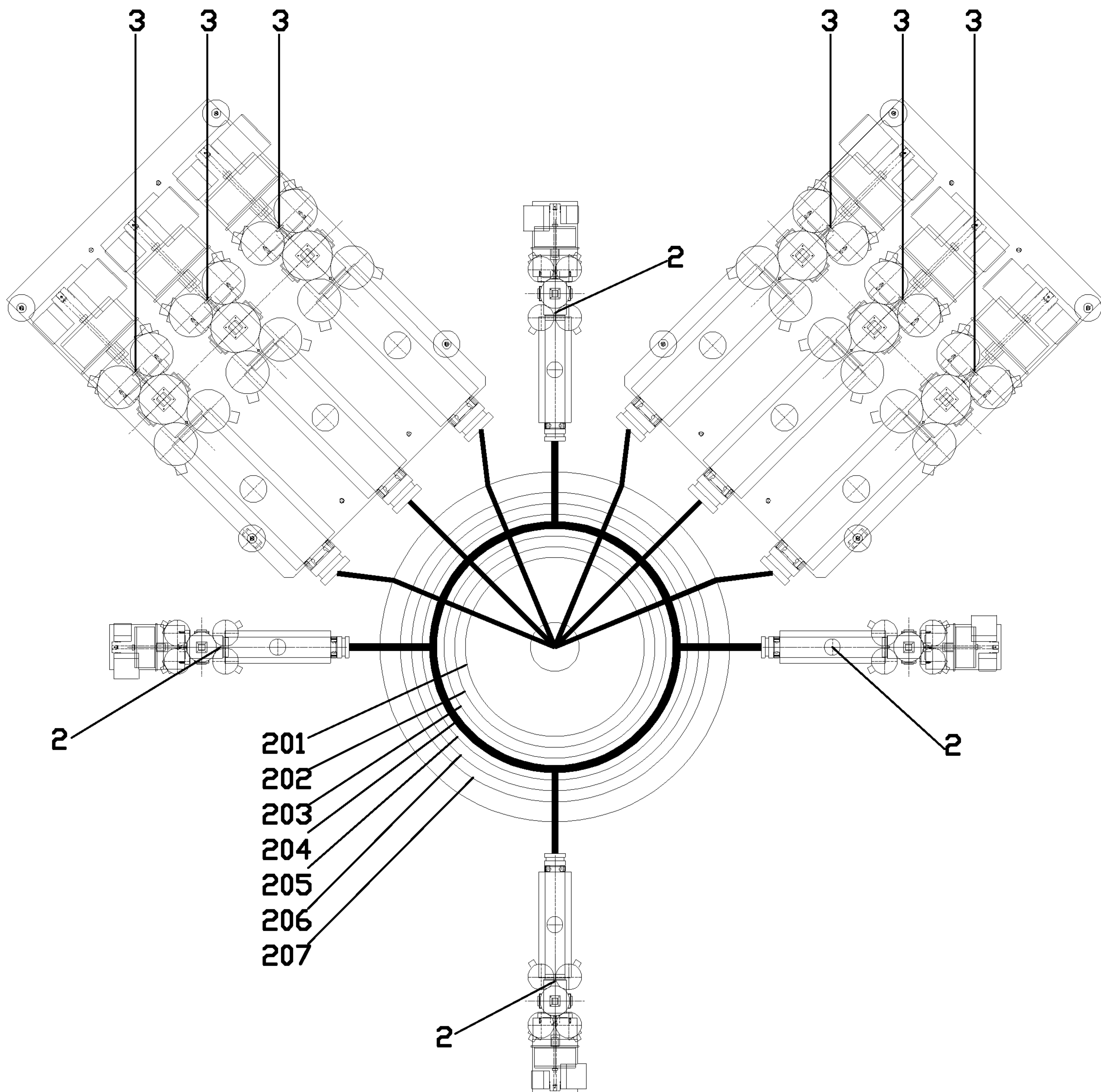


Fig.7

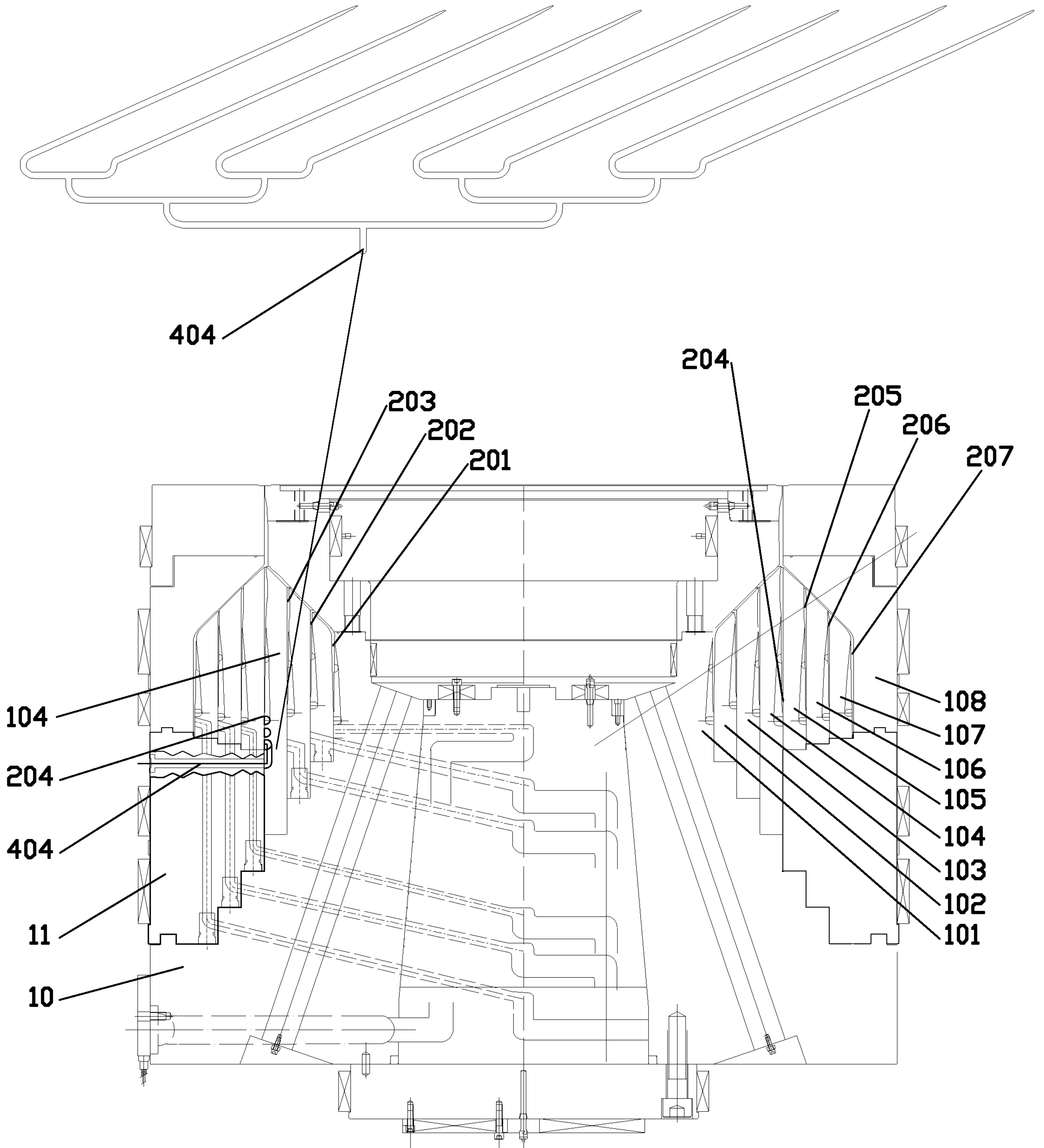


Fig.8

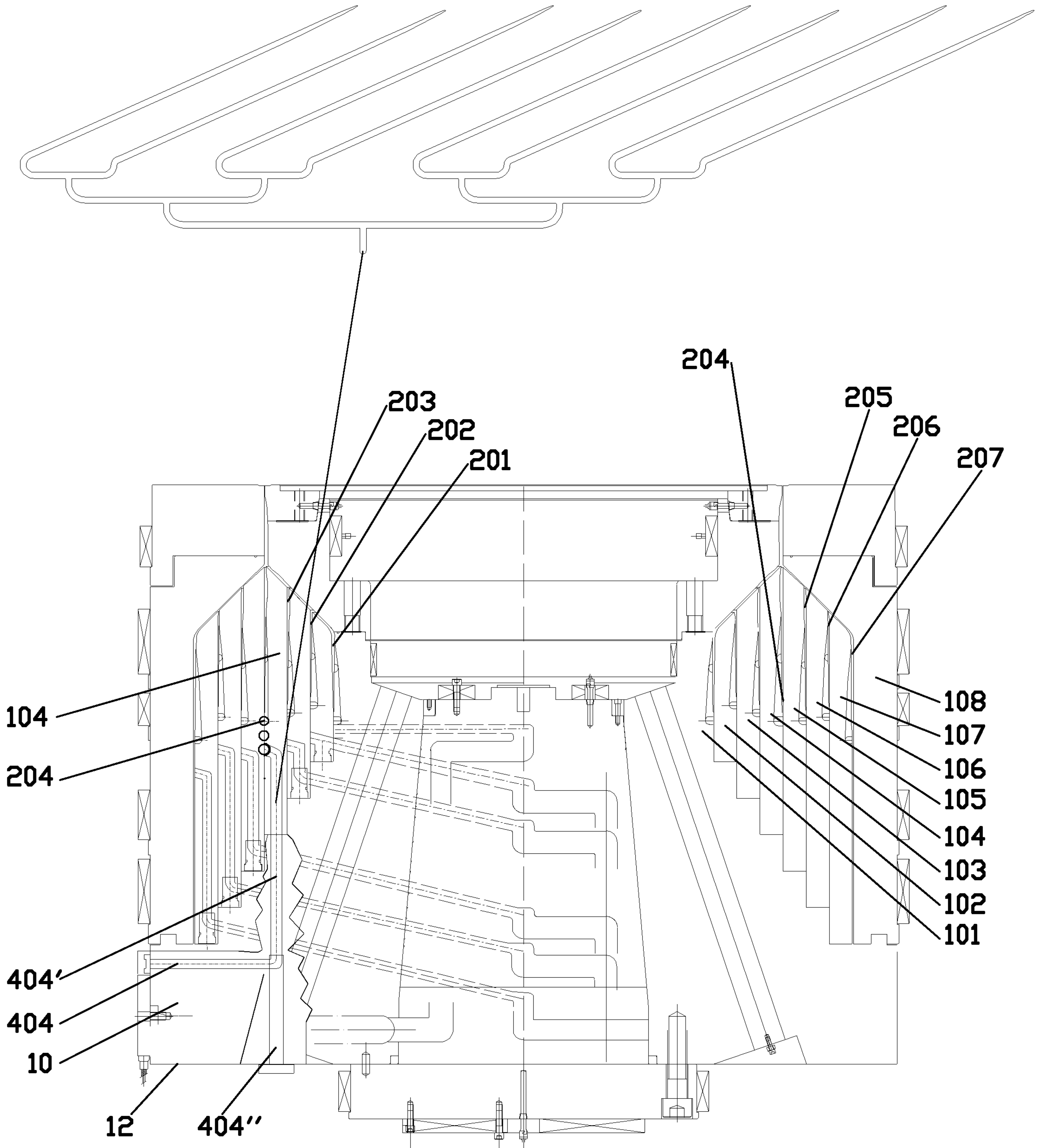


Fig.9

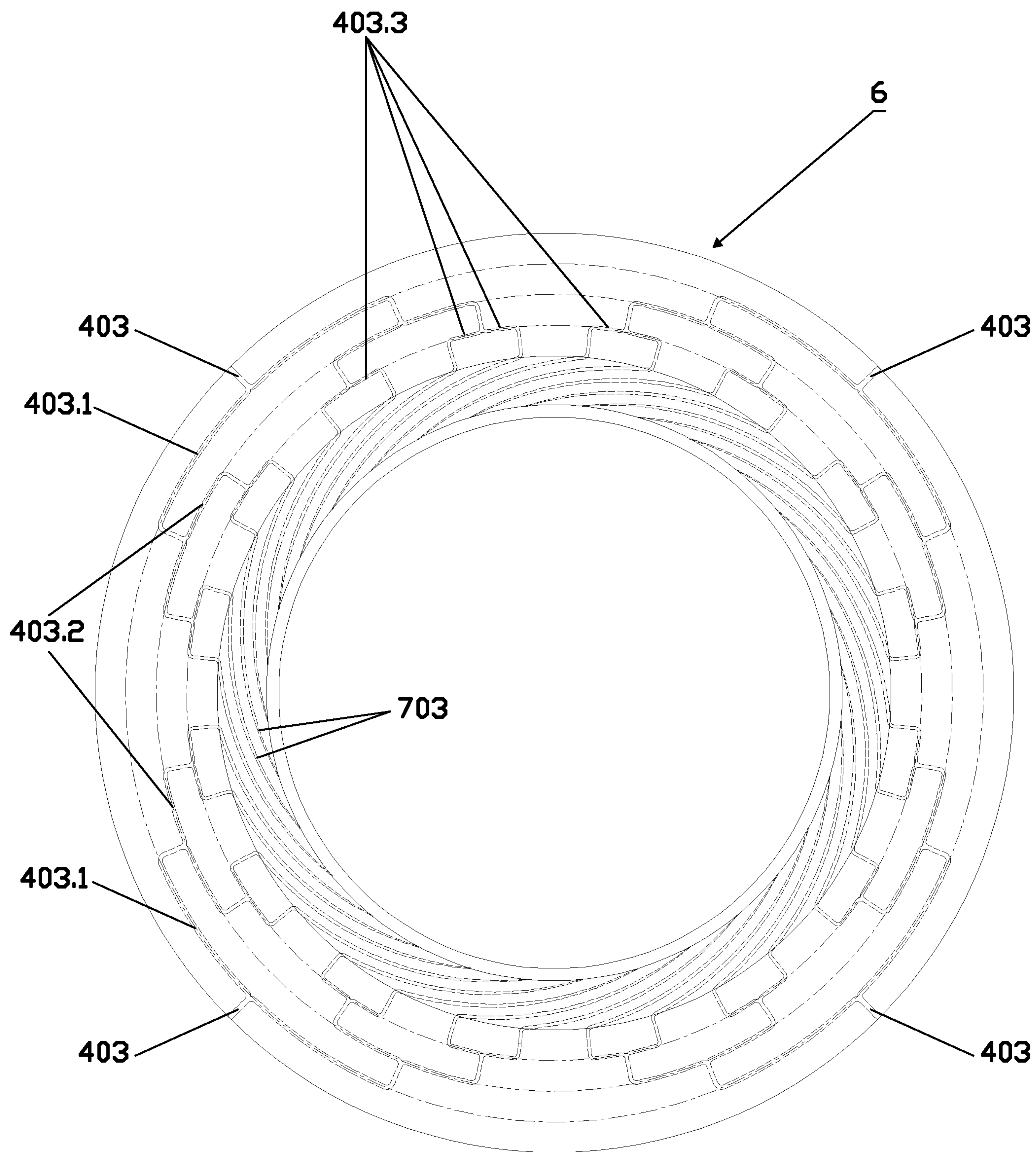


Fig.10

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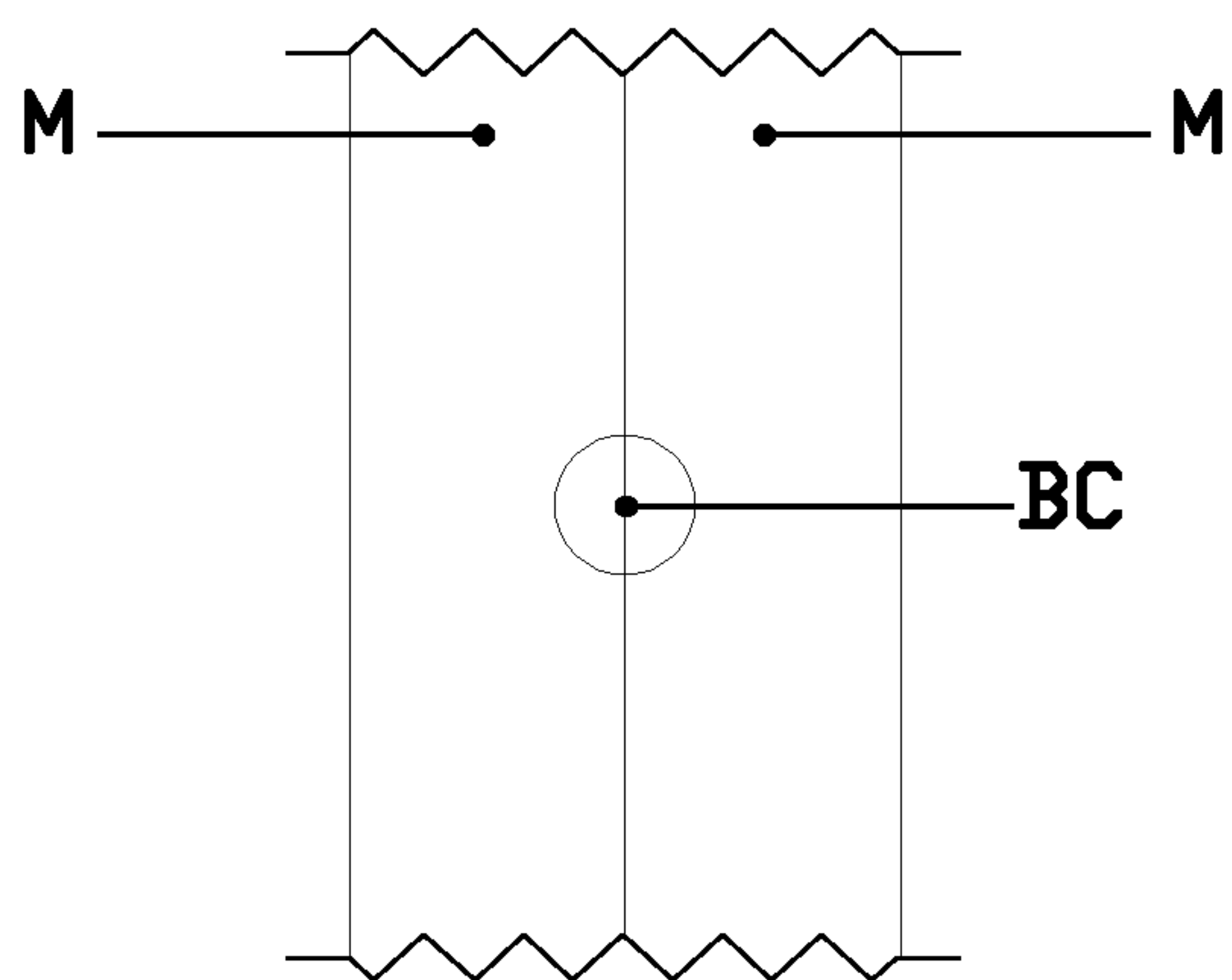


Fig. 11A

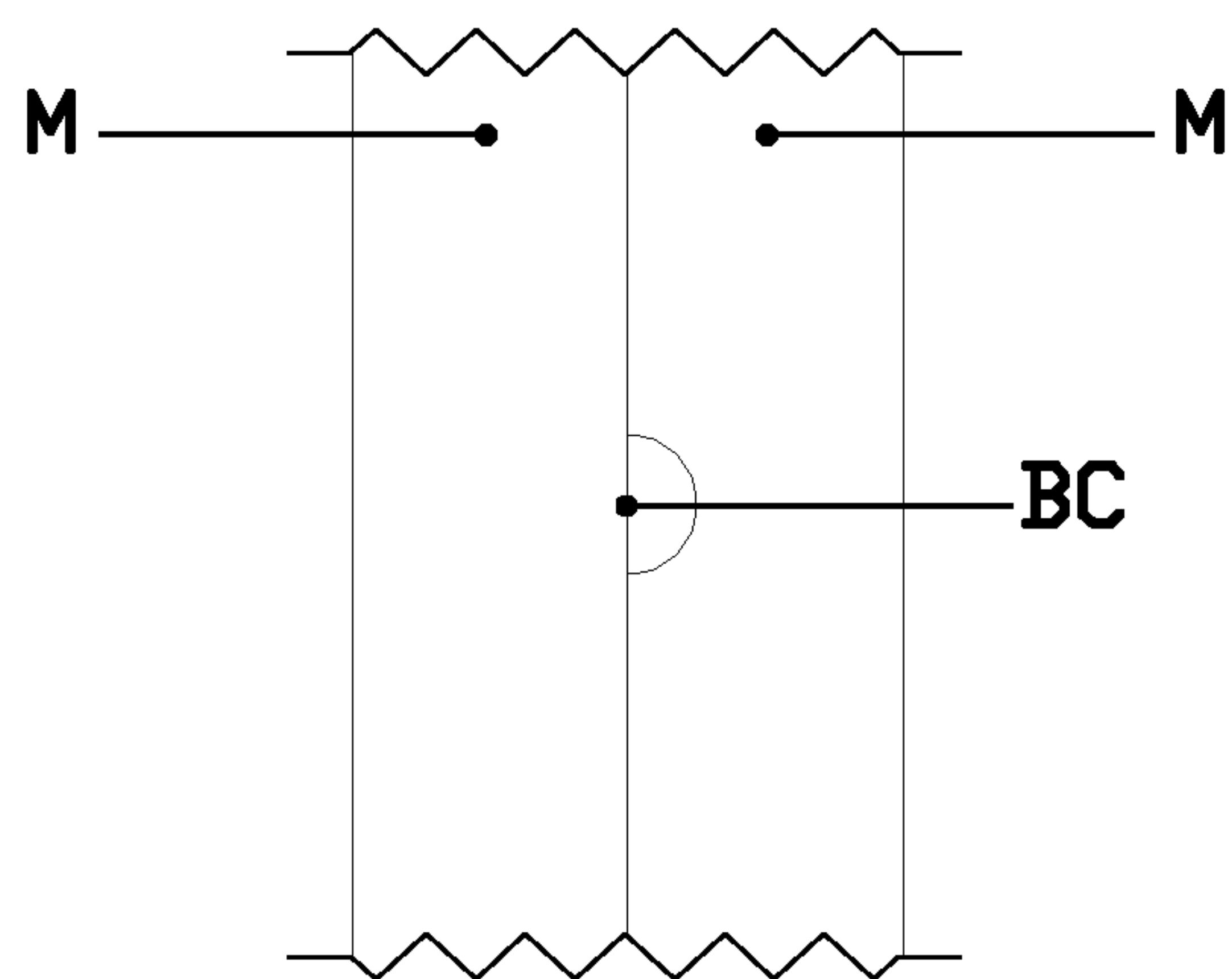


Fig. 11B

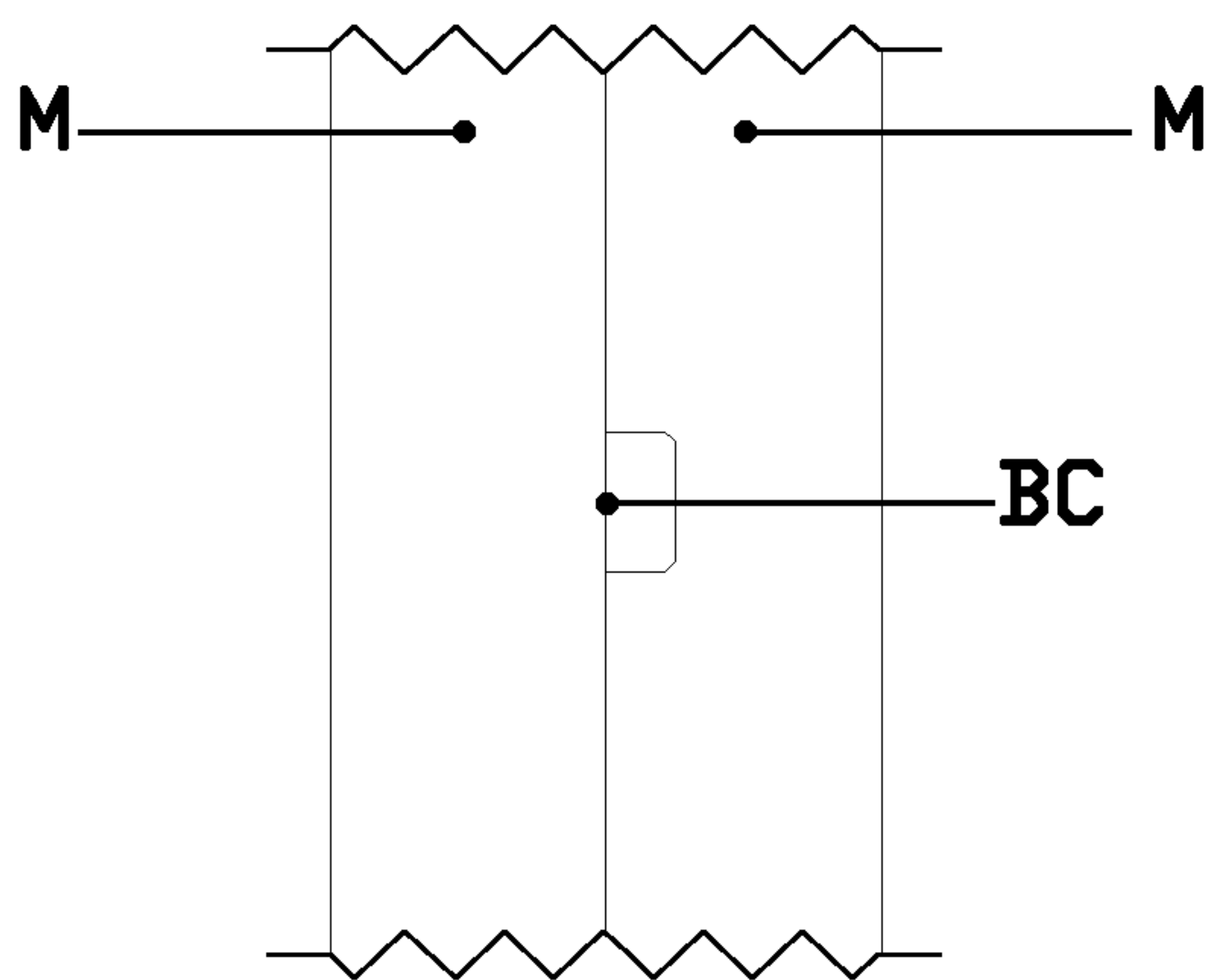


Fig. 11C

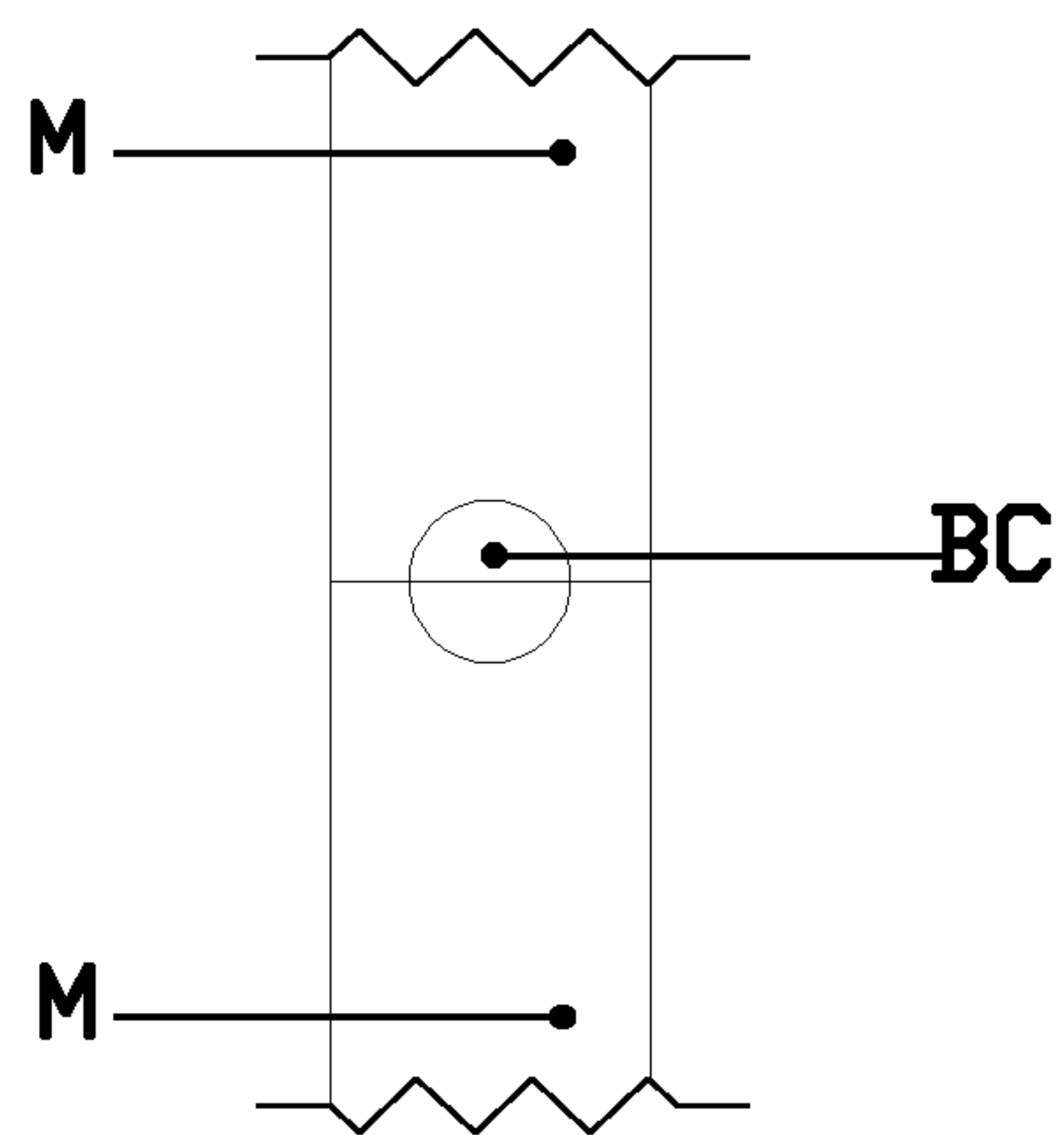


Fig. 11D

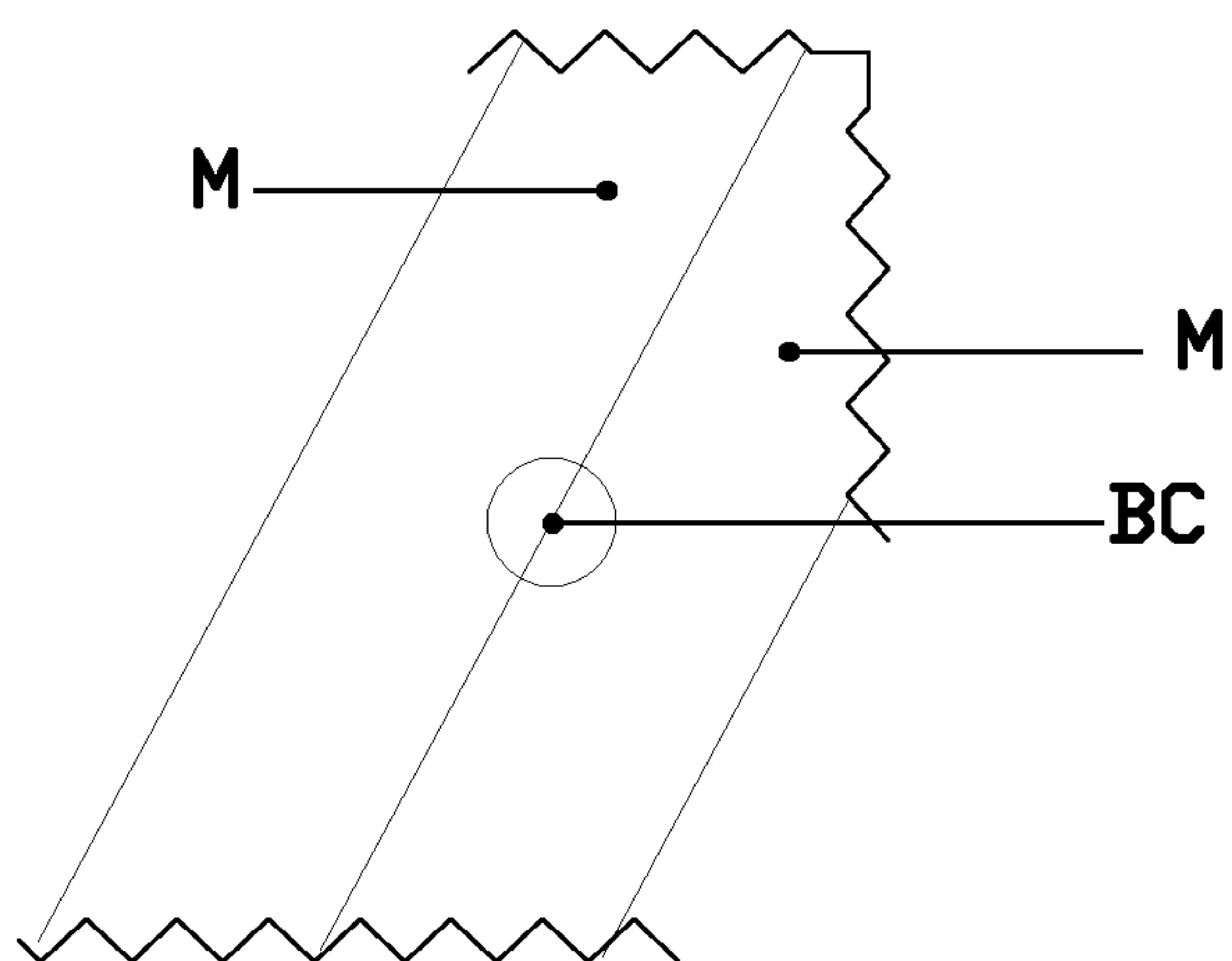


Fig. 11E

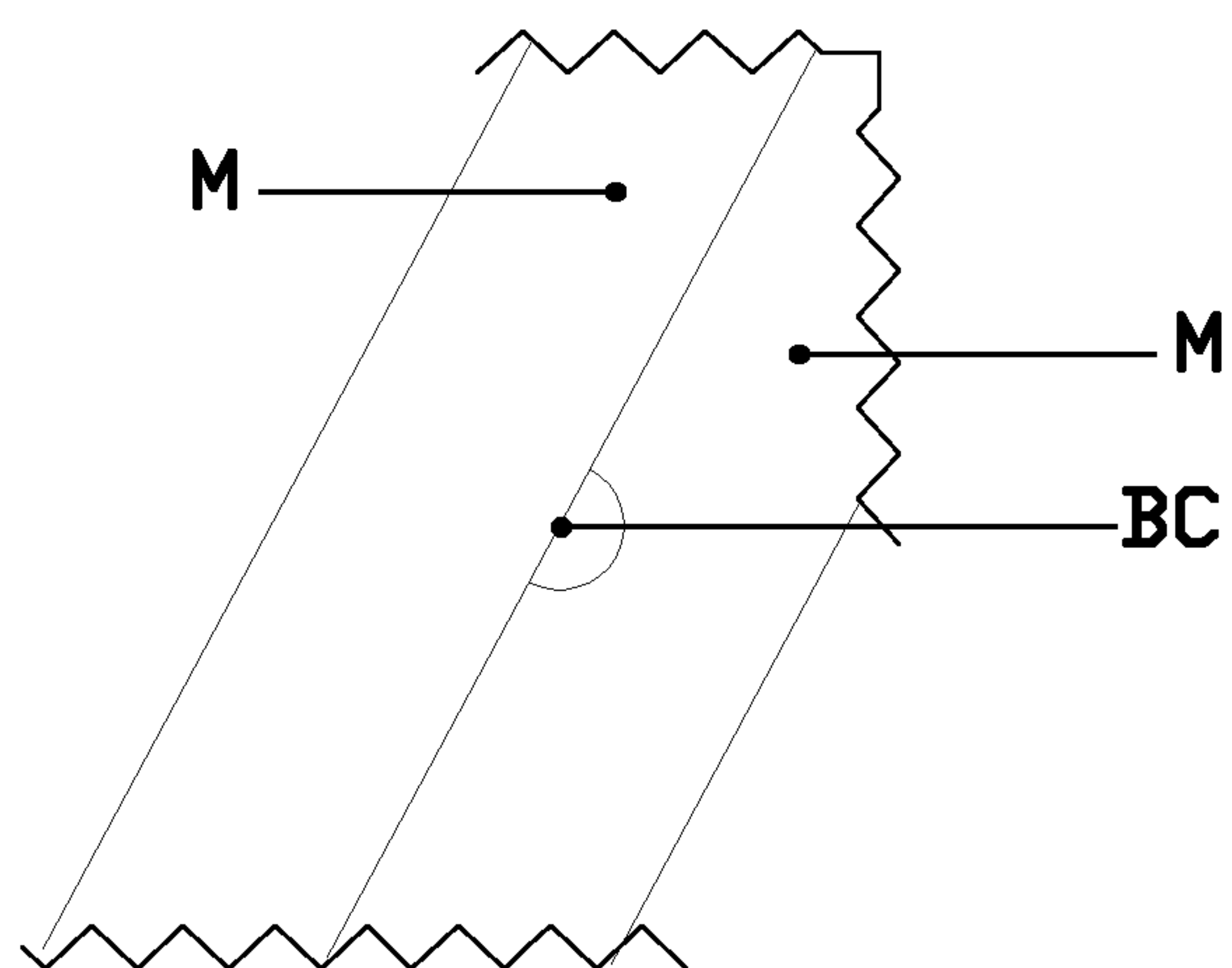


Fig. 11F

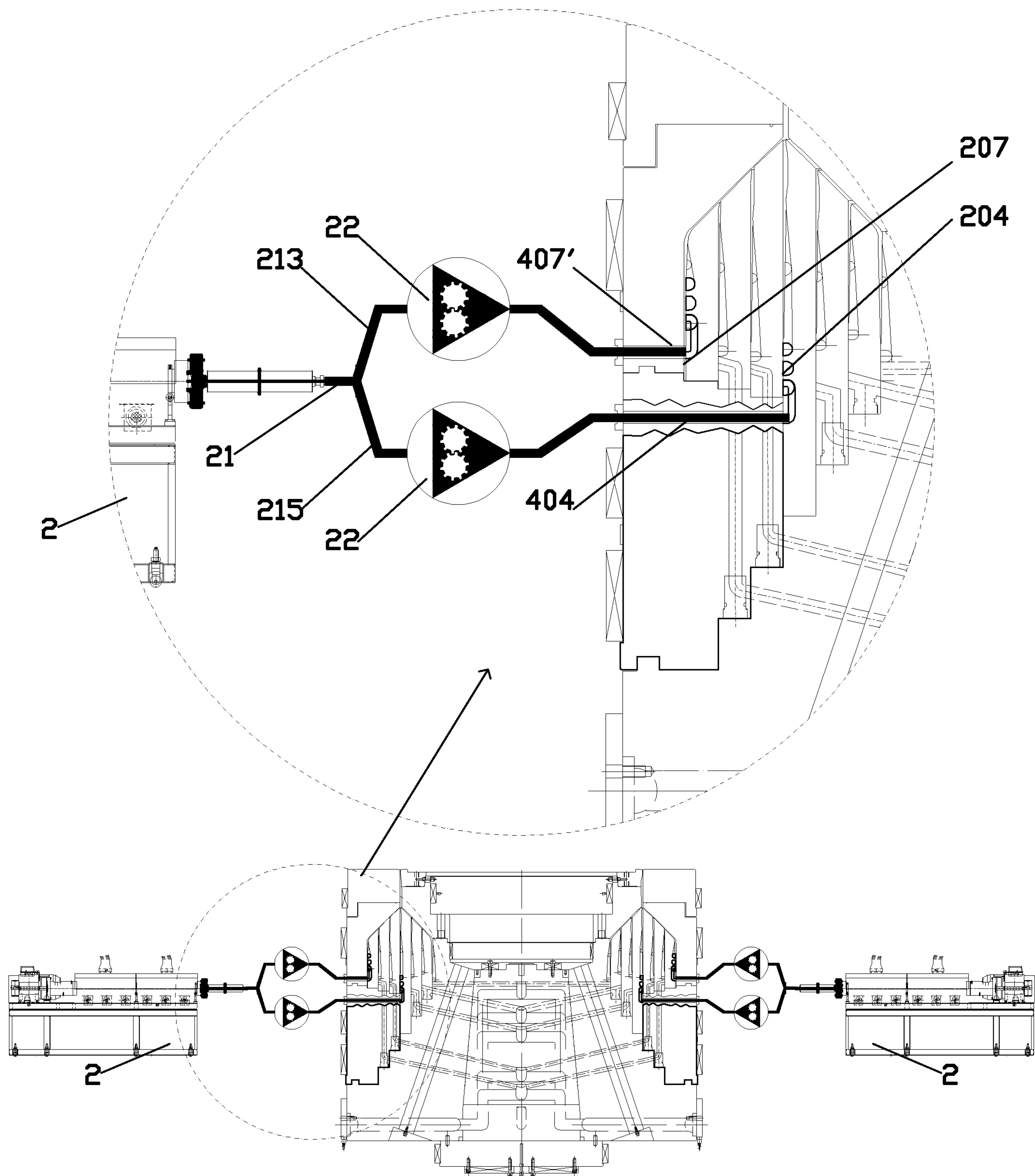


Fig.12

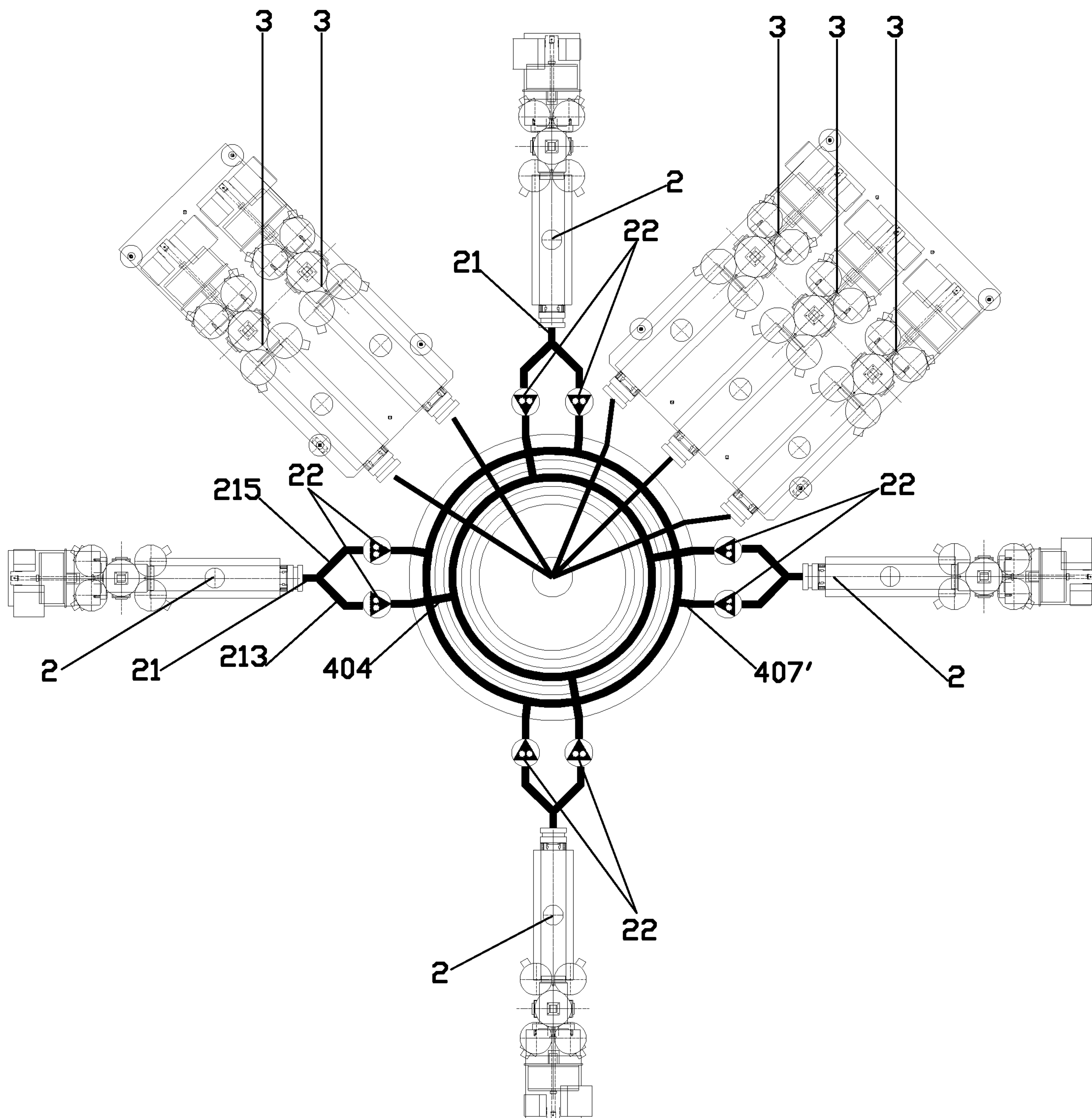


Fig.13

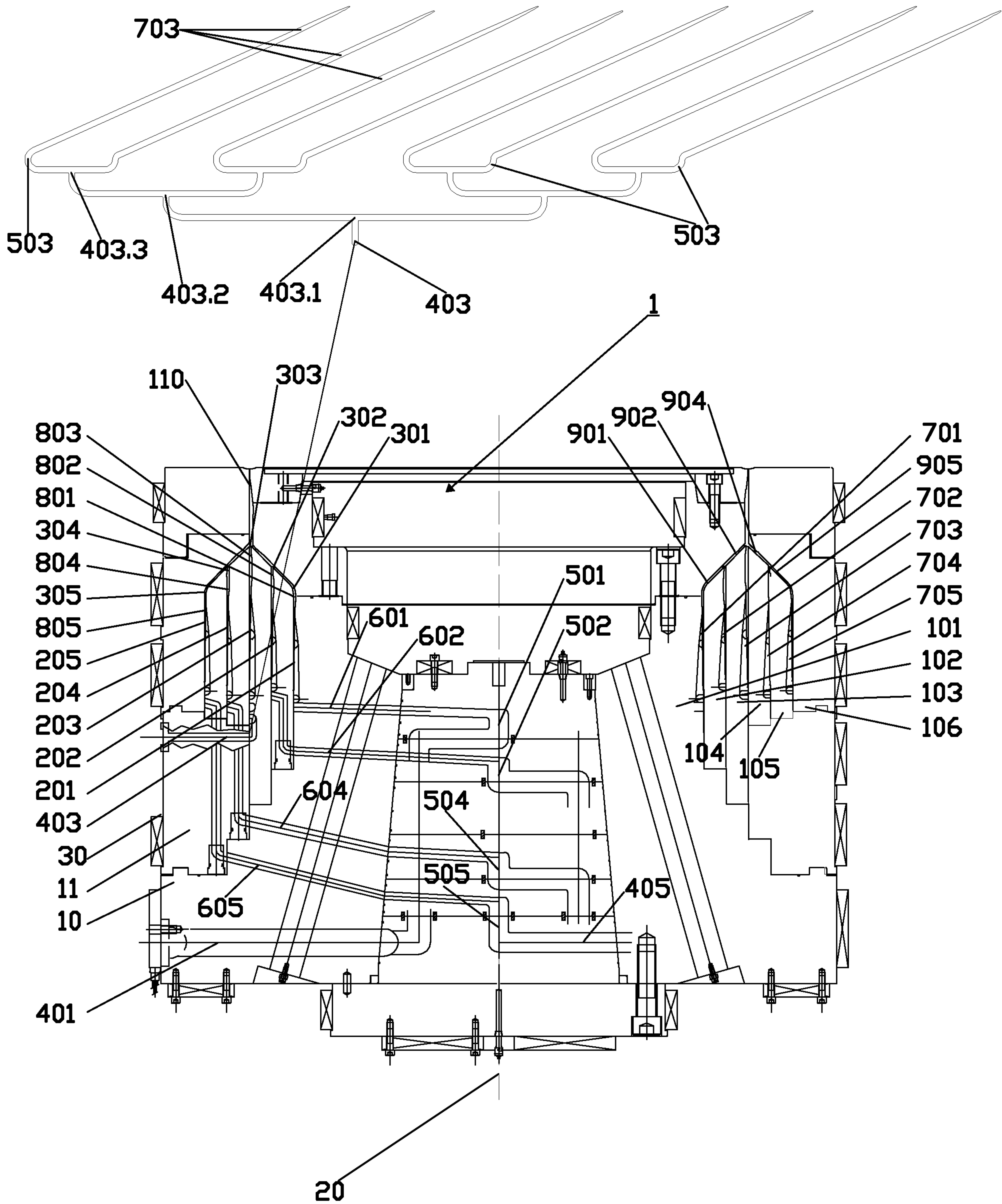


Fig.4