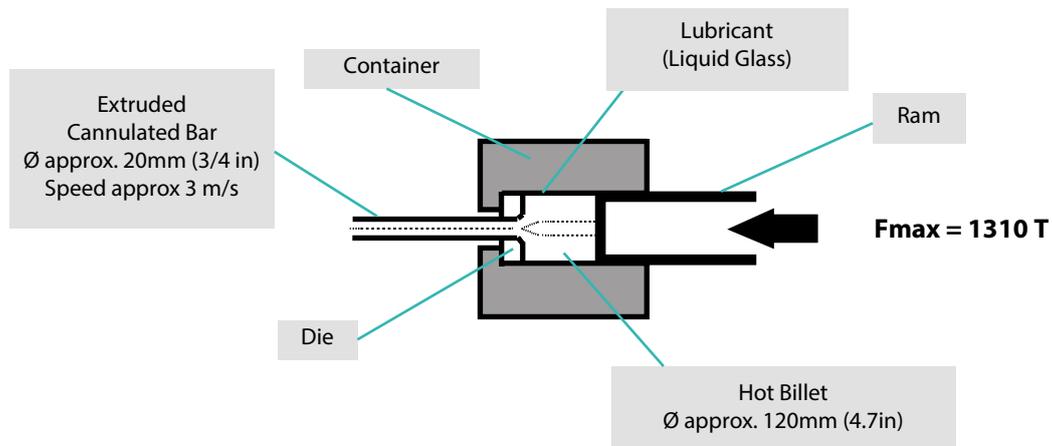


MEDICAL EXTRUSION PROCESS FOR CANNULATED BARS

EXTRUSION PROCESS LAYOUT



Temperatures

- Titanium Alloys $\approx 920^{\circ}C$ (1688 $^{\circ}F$)
- Stainless Steels $\approx 1120^{\circ}C - 1160^{\circ}C$ (2048 $^{\circ}F - 2120^{\circ}F$)

During extrusion TIME, SPEED, TEMPERATURE and PRESSURE are supervised with a specific acquisition system which analyses each and every billet. Typical curves are shown hereafter.

Pressure and Ram Speed in relation to time during an implantable 316L extrusion operation.

