- a special co-extrusion film die with a width of 1500 mm;
- a three-roll calender with horizontal roller arrangement, the third roller being capable of swivelling about +/- 45° in relation to the horizontal;
- a roller conveyor;
- a device for application of protective film on both surfaces;
- a take-off device;
- winding machine .

The granular material of the base material was supplied to the feed hopper of the main extruder. In the respective plasticising system constituted by cylinder/screw the melting and conveying of the respective material took place. Both material melts were brought together in the co-extrusion nozzle. From the nozzle the melt arrived at the calender. On the roll calender the definitive shaping and cooling of the material take place. For the purpose of structuring the surfaces of the film, in this connection two polished chromium rollers (for gloss/gloss surfaces) were employed. Subsequently the film was transported through a take-off, the protective film is applied on both sides, then the winding-up of the film took place.

With this film extrusion line , with a temperature of the main extruder from 220 °C to 240 °C and with a temperature of the co-extruder from 228 °C to 260 °C three-layer films according to the invention with two smooth, glossy sides with a layer thickness of 800 µm were extruded, the copolyester core layer of Copolyester I being 650 µm thick and the thermoplastic polyurethane layer on each side being in each instance 75 µm thick.