

PROCESS DATA FOR INJECTION MOULDING PP GLASS FIBER REINFORCED

DESCRIPTION

Polypropylene resin glass fiber reinforced chemically coupled.

PRE DRYING

To avoid residual humidity from transport or storage, the material should be pre-dried approximately 2h 90°C. Dehumidified air (dessicant) dryer is recommended but simple hot air dryers may also be used.

PROCESSING CONDITIONS¹

Following parameters should be used as guideline:

<i>Mold temperature</i>	30 – 60	°C
<i>Feed temperature</i>	20 – 50	°C
<i>Rear zone²</i>	210 - 220	°C
<i>Middle zone²</i>	220 – 230	°C
<i>Front zone²</i>	230 – 240	°C
<i>Nozzle zone²</i>	230 – 250	°C
<i>Back pressure</i>	Low to medium	
<i>Holding pressure</i>	30 - 50	bar
<i>Screw speed</i>	Low to medium	

Excessive melt temperatures may result in thermal degradation and a loss of performance, properties and aesthetics.

STORAGE

Store in dry conditions at temperatures below 50°C and protected from UV-light. Improper storage can initiate degradation, which results in odour generation and colour changes and can have negative effects on the physical properties of this product.

SAFETY

The product is not classified as dangerous. For further information refer to the downstream user information sheet of non-hazardous substances and mixtures in accordance with Article 32 of the EEC Regulation 1907/2006 (Reach)³.

¹ These conditions will depend on the type of equipment used

² The heat profile depends on many conditions: barrel size, screw design, rpm, residence time, etc.

³ <http://www.mepol.com/it/material-safety-data-sheets>