

## PROCESS DATA FOR INJECTION MOULDING PP MINERAL FILLED

### DESCRIPTION

Polypropylene resin mineral filled (filler level 5-40%).

### PRE DRYING

When condensation is visible, drying is recommended (2h 90°C). Dehumidified air (dessicant) dryer is recommended but simple hot air dryers may also be used.

### PROCESSING CONDITIONS<sup>1</sup>

Following parameters should be used as guideline:

<i>Mold temperature</i>	30 – 60	°C	
<i>Feed temperature</i>	20 – 50	°C	
<i>Rear zone<sup>2</sup></i>	210 - 220	°C	
<i>Middle zone<sup>2</sup></i>	220 – 230	°C	
<i>Front zone<sup>2</sup></i>	230 – 240	°C	
<i>Nozzle zone<sup>2</sup></i>	230 – 250	°C	
<i>Back pressure</i>	3 - 10	bar	
<i>Holding pressure</i>	30 - 50	bar	
<i>Screw speed</i>	40 – 70	rpm	Moderate

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)<sup>3</sup>.

<sup>1</sup> These conditions will depend on the type of equipment used

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

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