

# Mafill® CR

Polypropylene  
Industrial Quality Compound

## Injection Moulding - Processing guideline

RAVAGO MAFILL® PP Industrial Quality Compound materials can be processed using a wide range of processing parameters, see summary of processing conditions below:

### Safety

Information on the safety aspects of all RAVAGO MAFILL® PP Industrial Quality Compound grades is provided in the relevant Material Safety Data Sheets.  
RAVAGO MAFILL® PP Industrial Quality Compound grades are not classified as dangerous preparation.

### Pre-drying

Material is delivered in silos, octabins or bags.

When stored in a cold place, allow material to slowly reach room temperature before opening the package.

Although not always necessary, pre-drying (2 to 4 hours at 60 to 80°C) is recommended, e.g.:

- when condensation is visible or can be expected
- for aesthetical parts
- for mineral filled Mafill CR grades

### Equipment

RAVAGO MAFILL® PP Industrial Quality Compound grades can be processed on all modern injection molding machines with screw plasticizing. Both core progressive and three-zone screws can be used. L/D ratios of >20 and compression ratios of 1:2.0 to 1:2.8 are recommended. When using a hot runner, please contact our technical service.

### Processing parameters

Mafill CR	Unfilled	Mineral filled	Glass filled
Pre-drying	(60-80°C/2-4 h)	(60-80°C/2-4 h)	(60-80°C/2-4 h)
Cylinder temperatures	210-260°C	220-260°C	230-270°C
Mould temperatures	30-60°C	30-50°C	30-70°C
Holding pressure	40-70% of injection pressure		

*The information contained herein is to our knowledge accurate and reliable as of the date of publication. Ravago extends no warranties regarding fitness for a particular purpose or compliance to specifications and regulations. It is the customer's responsibility to test the product regarding suitability for a specific purpose.*

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