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

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