

Ravapura® HDPE

High-density polyethylene
Recycled Quality Compound

Injection Moulding - Processing guideline

Material description

RAVAPURA® HDPE compounds are designed for injection molding application and they can be processed using a wide range of processing parameters, see summary of processing conditions below:

Safety

Information on the safety aspects of all RAVAPURA® HDPE compound is provided in the relevant Material Safety Data Sheets.

RAVAPURA® HDPE compounds 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 60-70°C) is recommended, e.g.:

- when condensation is visible or can be expected
- for aesthetical parts
- for mineral filled RAVAPURA® HDPE compound grades

Equipment

RAVAPURA® HDPE compounds 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

RAVAPURA® HDPE	Unfilled	Mineral filled	Glass filled
Pre-drying	(60-70°C/2-4 h)	(80-90°C/2-4 h)	(80-90°C/2-4 h)
Cylinder temperatures	180-230°C	190-240°C	190-240°C
Mould temperatures	20-70°C	20-70°C	30-80°C
Holding pressure	50-70% of injection pressure		



Storage

RAVAPURA® HDPE compounds should be stored in a covered facility and kept away from moisture and heat. For better product preservation, carefully close the packaging immediately after use.

Disclaimer

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

Processing

Ravago Group Headquarters

Moerenstraat 85A
B - 2370 Arendonk

Tel: +32 (0)14 67 25 11
Fax: +32 (0)14 67 20 12

www.ravago.com
manufacturing@ravago.com