Sicostirolo® CR

Polystyrene
Industrial Quality Compound

Injection Moulding - Processing guideline

RAVAGO SICOSTIROLO® PS 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 SICOSTIROLO® PS Industrial Quality Compound grades is provided in the relevant Material Safety Data Sheets.

RAVAGO SICOSTIROLO® PS Industrial Quality Compound grades is 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 3 hours at 60 to 80ºC) is recommended, e.g.:

- when condensation is visible or can be expected
- for aesthetical parts

Equipment

RAVAGO SICOSTIROLO® PS 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 >20/1 and compression ratios of 2.5/1 to 3.8/1 are recommended. We do not recommend the use of hot runners for Industrial Quality Compounds.

Processing parameters

SICOSTIROLO CR	GPPS	HIPS
Pre-drying	(60-80 °C / 2-3 h)	(60-80 °C / 2-3 h)
Maximum moisture	0,05 %	0,05%
Cylinder temperatures	190-245 °C	190-245°C
Melt temperature (air shot)	220-245 °C	220-245 °C
Mould temperatures	20-65 °C	20-65 °C
Holding pressure	50-60% of injection pressure	

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