

Injection Moulding - Processing guideline

RAVAGO VERPLEN[®] PP Prime 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 VERPLEN[®] PP Prime Compound grades is provided in the relevant Material Safety Data Sheets.
 RAVAGO VERPLEN[®] PP Prime 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 80 to 100°C) is recommended, e.g.:

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

Equipment

RAVAGO VERPLEN[®] PP Prime 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.

Processing parameters

RAVAGO VERPLEN [®] PP	Unfilled	Mineral filled	Glass filled
Pre-drying	(80-100°C/2-4 h)	(80-100°C/2-4 h)	(80-100°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.

Ravago Group Headquarters