

PROCESSING GUIDE

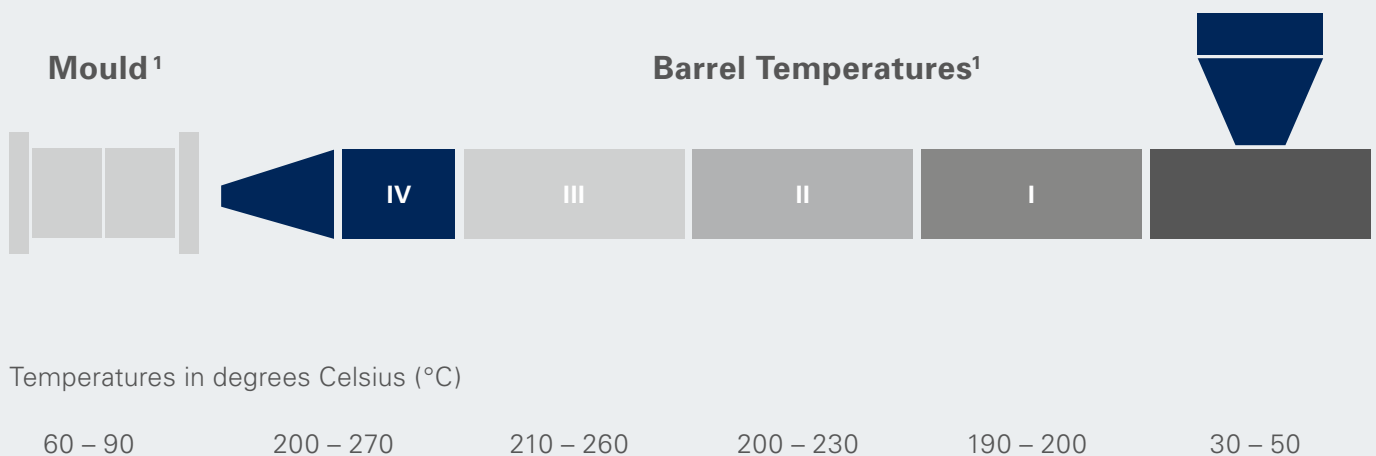
ALCOM[®] LB PP is a Polypropylene, a semi cristalline thermoplastic, filled with special additives for an optimal light blocking and light reflecting.

PRE-TREATMENT

ALCOM[®] LB PP is a non-hygroscopic polymer. Although, as specific reinforced and addivated products they require pre-drying. Storage at ambient temperature before use will minimise condensation risk. See corresponding Technical Data Sheet.

PROCESSING

ALCOM[®] LB PP may be processed on all standard injection moulding machines. Wear protected plasticising units are advised.



Temperatures in degrees Celsius (°C)

¹ Guide values. Standard starting profile might be in the middle, for higher density products a rather higher temperature profile.

	Unit	Notes	
Properties			
Polymer abbreviation		PP	
Density (ISO 1183)	g/cm ³	1.16 – 1.27 (see Technical Data Sheet)	
Injection Machinery			
Screw stroke		Metering stroke between 1 x D and 3 x D	
Screw type		Three zone screw with L/D ratio 18:1 to 22:1	
Nozzle type		Open or shut-off possible	
Hopper type		Standard	
Pre-processing			
Storage		Dry, protected from heat and light	
Dryer type		Air circulating	Dry air
Drying time	h	3 – 4	2 – 4
Drying temperature	°C	60 – 90	60 – 90
Permissible moisture content	%	< 0.2	
Processing Conditions			
Melt temperature range	°C	200 – 270	
Mould temperature range	°C	60 – 90	
Coolant		Water	
Throughput coolant		To ensure turbulent flow	
Peripheral screw speed	mm/s	50 – 300, e.g. screw speed of 35rpm with a screw diameter of 50mm	
Back pressure (specific)	bar	50 – 150	
Residence time	minutes	4 – 8	
Injection speed		Profile for constant flow front speed	
Shrinkage²			
Shrinkage range (ISO 294-4)	%	0.7 – 1.5	

² Shrinkage is influenced by the part geometry, the wall thickness of the moulding, the position and size of the gate and the processing parameters.

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