



## PROCESSING GUIDE

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### **4MAX<sup>®</sup> Universal Masterbatch**

#### **PROCESSING INSTRUCTIONS FOR INJECTION MOULDING PRE-BLEND**

1. Mix the base polymer with the **4MAX<sup>®</sup>** Universal Masterbatch at the specified letdown ratio, if you are unsure please contact your 4PLAS representative for assistance.
2. Set the injection moulding machine barrel temperatures as required for the base polymer.
3. Feed the required amount of premixed **4MAX<sup>®</sup>** / polymer blend into the hopper.
4. Purge the blend through the barrel using low pressure and screw speed.
5. Follow the processing guide for the base polymer for specific machine settings.
6. When complete use **4PURGE<sup>®</sup>** to fully clean down the machine. This can be purchased by contacting your 4PLAS representative.

#### **PROCESSING INSTRUCTIONS FOR INJECTION MOULDING MIXER UNIT**

1. Set the injection moulding machine barrel temperatures as required for the base polymer.
2. Feed the required amount of base polymer into the hopper.
3. Fill the dosing unit hopper with **4MAX<sup>®</sup>** Universal Masterbatch.
4. Set the letdown blend ratio as specified; if you are unsure please contact your 4PLAS representative for assistance.
5. Purge the blend through the barrel using low pressure and screw speed.
6. Follow the processing guide for the base polymer for specific machine settings.
7. When complete use **4PURGE<sup>®</sup>** to fully clean down the machine. This can be purchased by contacting your 4PLAS representative.

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Test Values: Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/ die, the processing conditions and the colouring.