



PROCESSING GUIDE

Page : 1 / 1
Revision : 005
Rev. Date : May 2014

4PROP® Polypropylene Homopolymer (PP HP)

PROCESSING CONDITIONS

	Unreinforced	Impact Modified	Reinforced	Flame Retardant
Drying (°C/Hour)	-	-	-	-
Maximum Moisture Content (%)	-	-	-	-
Feed Throat Temperature (°C)	20 - 60	20 - 60	20 - 60	20 - 60
Processing Temperature (°C)	200 - 240	200 - 240	200 - 240	200 - 240
Mould Temperature (°C)	20 - 50	20 - 50	20 - 50	20 - 50
Hold Pressure (MPa)	40 - 80	40 - 80	40 - 80	40 - 80
Back Pressure	Low	Low	Low	Low
Injection Speed	Medium - Fast	Medium - Fast	Medium	Medium
Maximum Screw Speed (rpm)	400	400	200	200

This information and our technical advice - whether verbal, in writing or by way of trials - is given in good faith but without warranty, and this also applies where proprietary rights of third parties are involved. Our advice does not release you from the obligation to verify the information currently provided - especially that contained in our safety data and technical information sheets - and to test our products as to their suitability for the intended processes and uses. The application, use and processing of our products and the products manufactured by you on the basis of our technical advice are beyond our control and, therefore, entirely your own responsibility. Our products are sold in accordance with the current version of our General Conditions of Sale and Delivery.

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.