

PROCESSING GUIDELINES FOR RMPP141 POLYPROPYLENE

	<u>RECOMMENDATION</u>	<u>REMARKS</u>
OVEN TEMPERATURE:	Heat quickly to 570°F within 3 – 4 minutes	Range 540°F to 600°F
EXTERNAL MOLD SURFACE TEMPERATURE:	500°F	Range 480°F to 520°F
PIAT:	440°F	Range 435°F to 455°F
MOLD RELEASE:	None to little	
ROTATION:	Similar to that used for PE	
OVEN TIME:	15% > LMDPE	1 min per .010" of wall thickness
COOLING:	Delay ~ 5 minutes after removing from oven: then force cool	
DEMOLD:	Crystallises at ~ 255°F: can be removed below 240°F	Wear protective equipment
SHRINKAGE:	1.5% (1% less than PE)	Range 1.5 to 2.5%
USE OF “SMART” OR “SUPAVENTS”:	Can help reduce pinhole voids	Passive pressurisation
DELAY TESTING PROPERTIES:	For 48 to 72 hours after molding	Optimising crystallization
PROPERLY CURED PART	Check no pinholes – bubbles – smooth/satin inside surface	If not correct:- review above parameters

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