

## PROCESSING GUIDELINES FOR RMPP141 POLYPROPYLENE

	<u>RECOMMENDATION</u>	<u>REMARKS</u>
<b>OVEN TEMPERATURE:</b>	Heat quickly to 300°C within 3 – 4 minutes	Range 280°C – 315°C
<b>EXTERNAL MOULD SURFACE TEMPERATURE:</b>	260°C	Range 250°C – 270°C
<b>PIAT:</b>	225°C	Range 225°C – 235°C
<b>MOULD RELEASE:</b>	Non to little	
<b>ROTATION:</b>	Similar to that used for PE	
<b>OVEN TIME:</b>	15% > LMDPE	4 min/1mm of wall thickness
<b>COOLING:</b>	Delay ~ 5 minutes after removing from oven: then force cool	
<b>DEMOULD:</b>	Crystallises at ~ 125°C: can be removed below 115°C	Wear protective equipment
<b>SHRINKAGE:</b>	1.5% (1% less than PE)	Range 1.5 to 2.5%
<b>USE OF “SMART” OR “SUPAVENTS”:</b>	Can help reduce pinhole voids	Passive pressurisation
<b>DELAY TESTING PROPERTIES:</b>	For 48 to 72 hours after moulding	Optimising crystallisation
<b>PROPERLY CURED PART</b>	Check no pinholes – bubbles – smooth/satin inside surface	If not correct:- review above parameters

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