Green Isoglass®

Document	Process Data for Injection Moulding
Description	**rPP (glass fiber reinforced recycled Polypropylene)**
Application	Injection Moulding

Structure	Semicristalline	
General Properties	Hard, good resilience. High stiffness. Low hygroscopicity and good thermal stability.	
Barrel Temperature		
	Feed Zone	30 – 50 °C
	Zone 1	160 – 200 °C
	Zone 2	190 – 220 °C
	Zone 3	195 – 220 °C
	Zone 4	195 – 220 °C
	Zone 5	195 – 220 °C
	Nozzle	200 – 230 °C
Melt temperature	200 – 220 °C	
Mould temperature	20 –70 °C	
Injection pressure	800 – 1400 bar	
Post-pressure	Between 30 and 60% of injection pressure, high post-pressure time	
Counterpressure	50 – 200 bar	
Injection speed	Medium	
Screw speed	Equal to peripheric speed of 1.3 m/s	
Metering	0.5 – 4.0 diameters	
Cushion	2 – 8 mm, depends on metering and screw diameter	
Drying	Suggested : 1 hour at 70°C.	
Recycle	30% of regrinded material. This percentage decreases for technical and aesthetic parts.	
Shrinkage	0.3 – 0.7 %, complete after 40 hours.	
Barrel equipment	Standard screw, non-return valve, free-flow nozzle	
Quenching	Not necessary to purge with other materials.	
Other recommendations	Suggested barrel volume/shot ratio : from 1,5 to 3. Excessive residence time inside the barrel should be avoided, to decrease material degradation and odor.	

Sirmax s.p.a.
E.A.R. N° 91334
P.IVA 00168180248
sirmax@sirmax.com

Group Headquarter:
Viale dell'Artigianato, 42
35013 Cittadella (PD) – Italy
Tel. +39 049 9441111 – Fax +39 049 9441112

SIRMAX GROUP