Salflex Polymers Ltd.

SALFLEX 815C
15% Glass-Fiber Reinforced COPP
Process Sheet

GENERAL

Good manufacturing practices should be employed while processing any plastic material. Avoid contact with the hot melt. Provide good ventilation to prevent inhalation of fume. Implement safe procedures for the operation of polymer processing equipment. Avoid contaminating the material with PVC or polyacetals. Those materials may emit noxious fume at high temperatures.

DRYING

Glass-fiber reinforced polypropylenes are hygroscopic and therefore adsorb atmospheric moisture. It is important that the pellets and any regrind be dried in a desiccating dryer prior to processing. Drying for 2-4 hours at 80-100°C (180-210°F) is recommended. This will improve part appearance and processing characteristics.

PROCESSING

This material is used for either extrusion or blow-molding. Temperature settings for the process equipment are given below. They are general guidelines only. Typical value for screw speed is about 50% and may vary according to part size. Screw speeds may affect melt temperature as much as the machine temperature settings.

PROCESSING CONDITION

Processing Method	**Blow Molding**	
Set Point Temperature	**+/- 5 °C**	**+/- 10 °F**
Rear of Barrel	185-215	365-420
Middle of Barrel	185-225	365-440
Front of Barrel	185-225	365-440
Head	185-225	365-440
Die	185-230	365-445
Ideal Melt Temperature	185-220	365-430
Mold Temperature	50-90	120-195

REGRIND

The material is relatively heat stable and can be easily reprocessed. The best performance, when reprocessing regrind, will be achieved by grinding to uniform size in a grinder with sharp blades.

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