

Processing Guidelines

Injection Moulding



ROMILOY ASA/PBT

General

ROMILOY ASA/PBT can be processed on general injection moulding machines. However the particular type of screw used is important for the resulting properties of the moulding. High shear stresses during the processing can lead to thermal and mechanical degradation.

Storage

ROMILOY ASA/PBT should be stored dry in closed rooms. ASA/PBT have to be protect against direct sun shine. If the material is stored outside the packs can be easy damaged and the granulate becomes faster yellow. Thus the mechanical and optical properties can be affected.

Drying

ROMILOY ASA/PBT leaves the plant with moisture content < 0.1 % (Karl-Fischer-Titration).

ROMILOY ASA/PBT absorb moisture if stored in inconvenient places. We therefore recommend to dry the material in a dehumidified air dryer at 90 - 100 °C for about 2-4 hours (circulation air drying oven, vacuum dryer, fixed hopper). If the material will not be dried properly, streaks on the surface can occur. Furthermore, we recommend to dry the material up to moisture content < 0.04 %. The pellet hopper used should be heatable.

The drying time should be limited to 2h if the material is coloured in light colour.

Processing

Depending on the size of the injection moulding machine and the component, the processing conditions should be controlled regular and very careful. Following conditions apply for assistance whilst processing:

ROMILOY® ASAS/PBT-Blend	reinforced grades
Drying temperature	90 - 100 °C
Drying time	2 - 4 h
Barrel temperature	240 - 260 °C
Melt temperature	< 260 °C
Mould temperature	75 - 100 °C
Injection speed	moderate
Peripheral screw speed	0,2 m/s max 0,3 m/s
Back pressure	<10bar hydraulic pressure
Holding pressure	moderate to high



26.02.07



Recycling

Defective parts and sprues from ROMILOY ASA/PBT without any contaminations can be reprocessed as a regrind. The amount of the regrind used should be chosen in dependence on the colour and degree of reinforcing. We recommend to start with 5% regrind and to control changes of the mechanical and optical properties. However, if there are specific properties requested, only prime material should be used.

The above processing guidelines should advise without commitment. The statements given are based on our experience and are correct to the best of the knowledge at the time of printing. No liability should be assumed as a result of this information.

