

Processing Guidelines

Extrusion



ROMILOY® ASA/PC Blends

General

ROMILOY ASA/PC can be processed using all techniques convenient for thermoplastic resins. In particular it can be extruded without difficulty on usual extruder machines.

Based on its good processing properties and due to the thermal stability of the product, the material is easy to process.

Storage

ROMILOY ASA/PC should be stored dry in closed rooms. ASA/PC 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/PC leaves the plant with moisture content < 0.1 % (Karl-Fischer-Titration).

ROMILOY ASA/PC can absorb moisture if stored in inconvenient places. We therefore recommend to dry the material in a dry air dryer at 70 - 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 < 0.05 %. The pellet hopper used should be heatable.

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

Processing

ROMILOY® ASA/PC - Blend	Standard	Flame retardant
Drying temperature	80 - 100°C	< 80°C
Drying time	2 - 4 h	2 - 4 h
Barrel temperatures	210 - 250°C *	200 - 240°C *
Melt temperature	< 260°C	< 250°C

*a rising temperature profile is preferred

The above mentioned processing parameter are only approximate and depend on the tool geometry and the machine used. It should be considered that flame retardant material is shear and temperature sensitive.

Recycling

Defective parts from ROMILOY ASA/PC 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 use of regrind from flame retardant materials has to be limited. Trials are necessary to evaluate the maximum possible amount.

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.

ROMIRA GMBH Siemensstrasse 1-3 D-25421 Pinneberg
Fon -No.:+49 41 01 / 706 - 03 Fax No.: +49 41 01 / 706 - 300