

## FASAL BIO 322 - instructions for processing

Please read the following information exactly before processing the material.

### STORAGE

- at no higher temperature than 40 °C

### TECHNICAL REQUIREMENTS

- thermoplastic or PVC-screw
- open nozzle
- polished direct gating
- hot-runner system without reduction
- **no** insulating channel system

### PROCEDURE DURING PROCESSING

- flush out with LD-PE
- predry FASAL BIO 322 at **max. 70°C** for 4h, duration depends on the type of dryer, after predrying do not leave FASAL BIO 322 in the dryer (**FIRE RISK**)
- **Temperature:**
  - feed zone: 170 °C
  - zone 1: 180 °C
  - zone 2: 180 °C
  - nozzle: 190 °C
- temperature of the mould 20° C ± 10 °C
- set higher screw speed continuously. Increase step by step to avoid development of burrs !
- set screw speed at 60 - 70% of maximum
- set plasticising delay time
- set dynamic pressure at 40% of maximum
- use injection pressure approx. 20 % higher than with plastics
- set holding pressure continuously. Increase step by step to avoid development of burrs !
- at the beginning cooling time must be twice higher than for plastics, subsequently reduce slowly until effective cooling time is reached
- use a mould lubricant spray for the first parts
- after injection moulding flush out the screw with LD-PE at the same temperature, now the screw is cleaned for further plastic applications

**For possible sources of error see overleaf**

## Sources of error

## Cause and correction

### Feed problems

- check cooling water in the feed zone
- reduce holding pressure

### Smell of burning and discoloration

- temperature is too high, if necessary adjust  
ATTENTION !! Temperature not higher than 200° C
- screw speed or dynamic pressure is too high

### Bad demoulding, sticking in the mould

- adjust the mould, because the material does not shrink
- reduce speed of the mould opening
- temperature of the mould 20°C ± 10° C
- granulates are humid, ATTENTION: Don't leave predried material in an open bag !

### Parts are damaged by the ejector

- reduce the ejector speed

### Parts are not filled

- gate is too small
- flush out after long standstill

### PLEASE NOTE:

At flushing out Fasal only a plastic cord can be seen, because Fasal does not melt in the usual sense.

If the output of the cord is not continuous, the temperature profile is too high => let the machine cool off !

If you have problems in spite of our detailed instructions for processing, don't hesitate to call us. Mr. Frech will answer your questions: tel. +43-2272-66280-355.