

FASAL BIO 465 - instructions for processing

Please read the following information exactly before processing the material.

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
- predrying of FASAL BIO 465 for 4 h at 100 °C
- **Temperature:**
 - feed zone: 160 °C
 - zone 1: 180 °C
 - zone 2: 180 °C
 - nozzle: 190 °C
- temperature of the mould 20 °C - 60 °C (higher temperature of the mould causes a nicer and smoother surface mostly)
- 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. 30 % 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 210° 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 - 60° C

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.

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