

Processing of CAPROWAX P™ - Pellets

Injection moulding:	Feed section	RT or 50-60°C (122-140°F)
	Plasticising	150-130°C (302-266°F)
	Die	120-140°C (248-284°F)
	Mould	10-25°C (50-77°F)
	Preferred layer thickness	0,4 – 1,0 mm
Compounds Extrusion	Plasticising	140-100°C (284-212°F)
	Die	80-110°C (176-230°F)
	Pellets by string, die-face pelletiser or by steel belt cooling	
Monofilaments	Drying commended	48-50°C/12h (120°F)/12h
	Feed section	RT or 50-60°C (122-140°F)
	Plasticising	120-100°C (248-212°F)
	Spinneret	100-110°C (212-230°F)
String generation	Water quench/cold-air-duct stretching in hot-air-duct	65-75°C (149-167°F)
	Preferred layer thickness	0,2 – 0,6 mm
Thermoforming	Feed section	RT or 50-60°C (122-140°F)
	Plasticising	110-80°C (230-176°F)
	flat film die	80-90°C (176-194°F)
	Polishing rolls at	10-25°C (50-77°F)
	Preferred layer thickness	0,4 – 1,0 mm
Blow moulding	Feed section	RT or 50-60°C (122-140°F)
	Plasticising	120-90°C (248-194°F)
	Parison die	65-80°C (149-176°F)
	Mould	10-25°C (50-77°F)
	Preferred layer thickness	0,4 – 0,8 mm
Drying of pellets	On demand at	48-50°C/12h (120°F)

Technical Data CAPROWAX P™ - Pellets

Properties	Units	Methods	Hydrophobicity CAPROWAX P™ 6002	Monofilaments, Hotmelt, Binder CAPROWAX P™ 6006 Injection-, Blow moulding, Hotmelt Vacuum forming, Foils/Sheets CAPROWAX P™ 6006-C65-BM42xxx
Density	g/cc	ISO 1183	1,04-1,14	1,1-1,3
Softening	°C (°F)	DSC	56-59 (133-138)	57-63 (135-145)
Vicat VST A/50	°C (°F)	ISO 306	56 (133)	56 (133) / 54 (129)
Shore-Hardness D		ISO 868	54	54 / 52
Residual humidity	%	70°C/2h	<0,2	<0,2

Tensile strength and elongation are dependent from temperature and stretching conditions

*) Changes of viscosity may be occur, because of applied nature products

CAPROWAX P™ compostable of course

