

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	Injection moulding CAPROWAX P™ 6002-00-000	Vacuum forming, Blow moulding, Monofilaments, Foils, Hotmelt, Binder CAPROWAX P™ 6006-00-000/6006-11-000
Density	g/cc	ISO 1183	1,04-1,14	1,03-1,14
MVR 90°C/2,16 kg	cc/10 min.	ISO 1133	4,0-10,0 *)	2,5-10,0 *)
Softening	°C (°F)	DSC	56-59 (133-138)	57-63 (135-145)
Vicat VST A/50	°C (°F)	ISO 306	56 (133)	56 (133)
Shore-Hardness D		ISO 868	54	54
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

