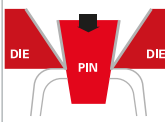
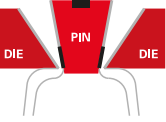
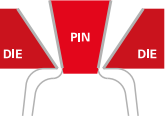


TOOLING CONDITIONING PROCEDURE FOR TIPPLEN R 665 XCLEAR

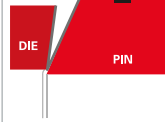
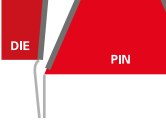
90% TIPPLEN R 665 XCLEAR + 10% NX ULTRACLEAR BM110B MASTER BATCH

CONVERGENT TOOLING

		PURGING		CONDITIONING		PRODUCING
				STEP 1	STEP 2	
				LOWER THE PIN	PIN STANDARD POSITION	PIN STANDARD POSITION
						
		COATING OF THE DIE		COATING OF THE PIN		
MATERIAL		TIPPLEN R 665 XClear + MB*				TIPPLEN R 665 XClear
DIE GAP		Normal gap	Minimal gap (10-30%)	Normal gap	Normal gap	
SCREW SPEED		Standard speed	3 x Standard speed	2 x Standard speed	Standard speed	
TEMPERATURES	EXTRUDER/MANIFOLD	180°C – 200°C	180°C – 200°C	180°C – 200°C	180°C – 200°C	
	HEAD	200°C – 215°C	200°C – 215°C	200°C – 215°C	200°C – 205°C	
	DIE	215°C – 230°C	215°C – 230°C	215°C – 230°C	205°C – 215°C Minimal parison temperature of 210-215°C	
DURATION		Till previous resin completely is purged out – remove and clean pin and die		10 minutes	10 minutes	Production
		MB* = LDR 10% of NX UltraClear BM110B				

SEQUENCE

DIVERGENT TOOLING

		PURGING		CONDITIONING		PRODUCING
				RAISE THE PIN		
						
				COATING OF PIN & DIE		
MATERIAL		TIPPLEN R 665 XClear + MB*				TIPPLEN R 665 XClear
DIE GAP		Normal gap	Minimal gap (10-30%)	Normal gap	Normal gap	
SCREW SPEED		Standard speed	3 x Standard speed	Standard speed	Standard speed	
TEMPERATURES	EXTRUDER/MANIFOLD	180°C – 200°C	180°C – 200°C	180°C – 200°C	180°C – 200°C	
	HEAD	200°C – 215°C	200°C – 215°C	200°C – 215°C	200°C – 205°C	
	DIE	215°C – 230°C	215°C – 230°C	215°C – 230°C	205°C – 215°C Minimal parison temperature of 210-215°C	
DURATION		Till previous resin completely is purged out – remove and clean pin and die		10-15 minutes		Production
		MB* = LDR 10% of NX UltraClear BM110B				

SEQUENCE

RECOMMENDED FINISH FOR TIPLLEN R 665 XCLEAR EBM BOTTLES

S.P.I.® MOLD FINISH GUIDE					
S.P.I. FINISH	GUIDE	R.A. VALUE	S.P.I. FINISH	GUIDE	R.A. VALUE
A-1	#3 DIAMOND BUFF	0-1	B-1	#600 GRIT PAPER	2-3
A-2	#6 DIAMOND BUFF	1-2	B-2	#400 GRIT PAPER	4-5
A-3	#15 DIAMOND BUFF	2-3	B-3	#320 GRIT PAPER	9-10
C-1	#600 GRIT STONE	10-12	D-1	#11 GLASS BEAD	10-12
C-2	#400 GRIT STONE	25-28	D-2	#240 ALUM. OXIDE	26-32
C-3	#320 GRIT STONE	38-42	D-3	#24 ALUM. OXIDE	190-230

For further information and technical data sheet of TIPLLEN R 665 XClear, please contact our Technical Service department on pts@mol.hu

For NX UltraClear BM110B master batch please contact Milliken on the below address:

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9000 Gent
Belgium
Tel: 0032 470 85 12 94
eurochem@milliken.com



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