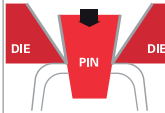
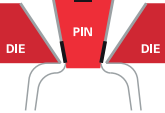
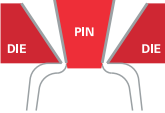


TOOLING CONDITIONING PROCEDURE FOR TIPPLEN R 665 TST

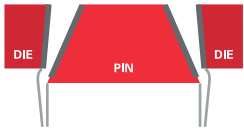
90% TIPPLEN R 665 TST + 10% NX ULTRACLEAR BM110B MASTER BATCH

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 R665 TST + MB*	Tipplen R665 TST + MB*	Tipplen R665 TST + MB*	Tipplen R665 TST
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 R665 TST + MB*	Tipplen R665 TST + MB*	Tipplen R665 TST
DIE GAP		Normal gap	Minimal gap (10-30%)	Normal gap
SCREW SPEED		Standard speed	3 x Standard speed	Standard speed
TEMPERATURES	EXTRUDER/MANIFOLD	180°C - 200°C	180°C - 200°C	180°C - 200°C
	HEAD	200°C - 215°C	200°C - 215°C	200°C - 205°C
	DIE	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

ROU

▶ MOLGROUP

▶ MOL

ROU

▶ MOLG

LGROUP

ROU

▶ MOL

GROUP

IP

▶ MO

GROUP

▶ MOL

GROUP

MOLGROUP

▶ MOL

GROUP

RECOMMENDED FINISH FOR TIPPLEN R 665 TST 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 TIPPLEN R 665 TST, please contact our Technical Service department on pts@mol.hu

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

Milliken Chemical
Ham 18
9000 Gent
Belgium
Tel: 0032 470 85 12 94
eurochem@milliken.com

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PETROCHEMICALS



Slovnaft

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