

eurocell[®]

PP moulding trials

1. PREPERATION OF GRANULES

Take a suitable weight of plastic granules in a clean plastic bag.
Add approximately 0.25 to 1.0% of a light oil such as liquid paraffin or plasticiser.
Practice may be necessary to get this addition right.
Any addition required of masterbatch colours or blowing agents in masterbatch form should be added at this stage.
Shake together until granules are light coated with oil.

CAUTION - THE BAG WILL ALSO BE COATED - DO NOT USE TWICE.

2. ADDITION OF Eurocell[®]

Add the desired quantity of Eurocell[®] to the wetted granules and tumble gently together.
(The granules should be partly coated by Eurocell[®] by this action and the bulk of Eurocell[®] agglomerated.)
Avoid too much mixing as segregation can occur.
If the mix is too dry do not try to add more oil after Eurocell[®] is added as this will only serve to cause to local agglomeration of the filler. Start again in this case.

2. MOULDING

The coated / agglomerated material may now be introduced directly into the moulding machine.
Where blowing agent has been added the shot weight should be kept to the absolute minimum to fill the mould.

3. ADDITION

The addition of Eurocell[®] is necessarily limited by weight due to the low density, however, it is certainly possible to add up to 40% by volume to the final material.

Eurocell®

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Eurocell moulding trials at Comallo Sept. 20th / 23rd, 94							
With blowing agent:							
FORMULA 1		pbw	% / V	sgcont	£ / kg		litres
eurocell® 142	0,24	5,00	27,71	0,07	1,80	9,00	20,83
propylene	0,92	50,00	72,29	0,67	0,50	25,00	54,35
RESIN%vol	30,12	55,00	DENSITY	0,73		34,00	75,18
Handle wt	33,30		£ / litre	0,45	£ / kg	0,62	
Wt % saved x 10% Talc		17,78	Theoretical weight		30,12	gms	
FORMULA 2		pbw	% / V	sgcont	£ / kg		litres
eurocell® 142-H	0,24	5,00	27,71	0,07	1,80	9,00	20,83
propylene	0,92	50,00	72,29	0,67	0,50	25,00	54,35
RESIN%vol	30,12	55,00	DENSITY	0,73		34,00	75,18
Handle wt	33,30		£ / litre	0,45	£ / kg	0,62	
Wt % saved x unfPP		12,10					
FORMULA 1		pbw	% / V	sgcont	£ / kg		litres
talc	2,60	5,00	3,78	0,10	1,80	0,50	1,92
propylene	0,92	45,00	96,22	0,89	0,50	22,50	48,91
RESIN%vol	40,09	50,00	DENSITY	0,98		23,00	50,84
Handle wt	40,50		£ / litre	0,45	£ / kg	0,46	
Handel vol	41,18	cc					
In unfPP	37,88	gm					
Without blowing agent:							
FORMULA 1		pbw	% / V	sgcont	£ / kg		litres
eurocell® 142-H	0,30	5,00	23,47	0,07	1,80	9,00	16,67
propylene	0,92	50,00	76,53	0,70	0,50	25,00	54,35
RESIN%vol	31,89	55,00	DENSITY	0,77		34,00	71,01
Handle wt	32,70		£ / litre	0,48	£ / kg	0,62	
Wt % saved x 10% Talc		19,26	Theoretical weight		31,89	gms	
FORMULA 2		pbw	% / V	sgcont	£ / kg		litres
T125W	0,60	16,60	33,73	0,20	1,80	29,88	27,67
propylene	0,92	50,00	6,27	0,61	0,50	25,00	54,35
RESIN%vol	27,61	66,60	DENSITY	0,81		54,88	82,01
Handle wt	33,70		£ / litre	0,67	£ / kg	0,82	
Wt % saved x 10% Talc		16,79	Theoretical weight		33,44	gms	
FORMULA 1		pbw	% / V	sgcont	£ / kg		litres
T150W	0,70	16,60	30,38	0,21	1,80	29,88	23,71
propylene	0,92	50,00	69,62	0,64	0,50	25,00	54,35
RESIN%vol	29,01	66,60	DENSITY	0,85		54,88	78,06
Handle wt	34,00		£ / litre	0,70	£ / kg	0,82	
Wt % saved x unfPP		10,25					