PROCESSING GUIDELINES

UDMAX™ GPP 45-70 TAPE LAMINATE

UDMAX™ GPP 45-70 can be molded or processed in a temperature- controlled static mold press. The press must be able to be heated and cooled. To obtain a nice and smooth surface of the laminate/part, the plates/mold should be treated with a mold release. UDMAX™ GPP 45-70 tape is based on a high flow polypropylene, due to this fact it can be processed close above the melting temperature of polypropylene homopolymer (166°C). The polypropylene contains a relative high level of processing additives to stabilize the material to an oxidizing environment, but too long processing times in contact with air can consume the total amount of stabilizer. If this happens the material starts to smoke.

BASIC STEPS FOR MOLDING

• Heat the press to the desired temperature. Be sure that all the plates/mold are also heated
• When the press reaches the desired temperature place the tape/laminate inside
• Close the press at the recommended pressure and let the tape/laminate reach the melting temperature. Be sure that the pressure is not too much because the polymer can be squeezed out
• When the tape/laminate reaches the temperature that is set, let it rest for the recommended time at that temperature
• Cool the laminate/part below the removal temperature
• Open the press and remove the laminate/part from the plates/mold
• Check the laminate/part. If it looks as expected, the pressure and temperature were correct.
Sometimes it will be necessary to do some trials with temperature/pressure to obtain the desired laminate/part because of the different machinery

Recommended processing parameters

Matrix	Mold/plate temperature (°C)	Pressure (bar)	Time @ melt (s)	Cool rate	Removal temperature (°C)
PP	180	< 2.0	60	N.D.	< 70

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