



# Resirene

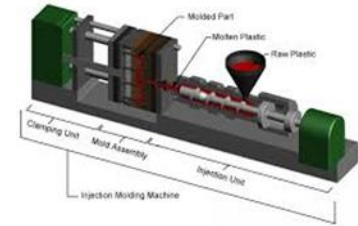
## Processing SMMA

# Processing SMMA

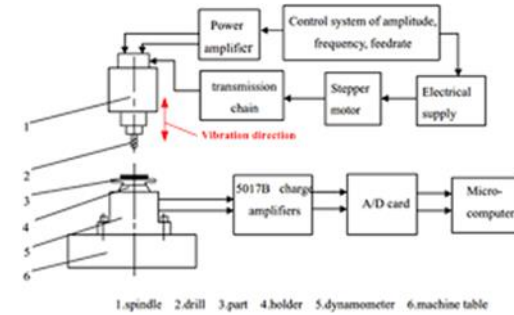
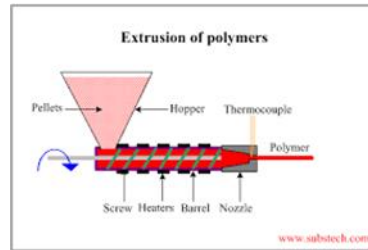
- Extrusion

Film  
Tubing  
Stock shapes

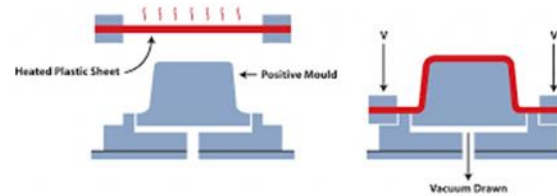
- Thermoforming
- Injection molding
- Blow molding



Copyright © 2007 CustomPartNet

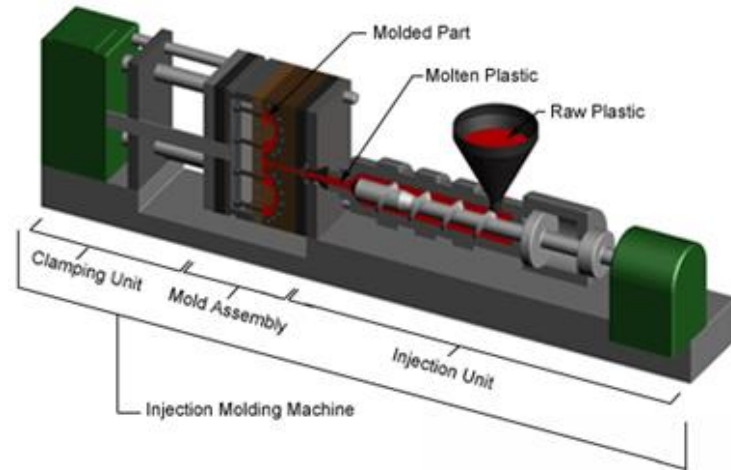


Thermoforming Principle



# Injection molding SMMA

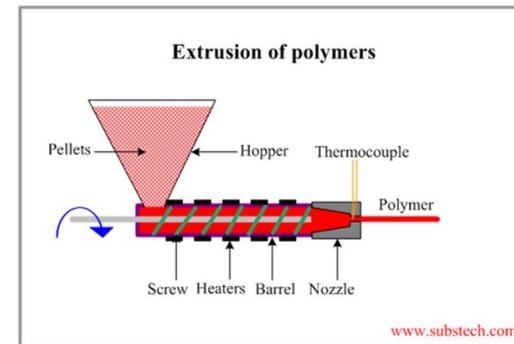
- Drying of CET™ SMMA is not necessary
- Three zone screw with and L/D or 18:1 to 24:1
- Shrinkage is typically 0.4 to 0.6%
- Draft angles on molds for part de-molding
  - 1°
- Processing temps:
  - Rear: 340F - 360F
  - Center: 360F – 375F
  - Front: 390F – 410F
- Mold temperatures
  - 120F to 140F
- Injection pressure
  - 70 -140 MPa
- Injection speed
  - Moderate to high
- Screw rpm
  - 50 – 100 rpm
- Back pressure
  - 5 – 15 Mpa
- Adequate venting



Copyright © 2007 CustomPartNet

# Extruding SMMA

- Can be processed on most extrusion machines
- Drying of CET™ SMMA is not necessary
- Use a three zone screw with a 25-30 L/D or a barrier screw
- Compression ratio
  - 2,75:1
- Processing temperatures
  - Rear: 340F – 360F
  - Middle: 360F – 375F
  - Front: 390F – 410F
- Melt temperature
  - 390F – 425F
- High processing temperatures and/or excessively long residence time can damage the polymer and lead to a reduction in part performance and/or discoloration
- Adequate exhaust ventilation is recommended



# Thank You !