



Resirene

Processing SMMA

Processing SMMA

- Extrusion

Film

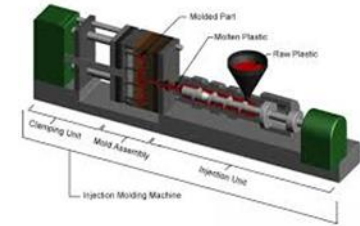
Tubing

Stock shapes

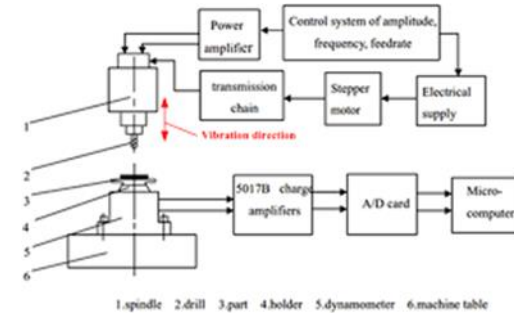
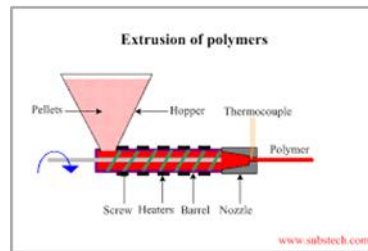
- Thermoforming

- Injection molding

- Blow molding

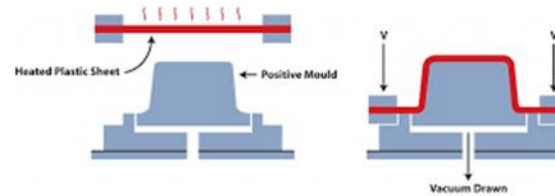


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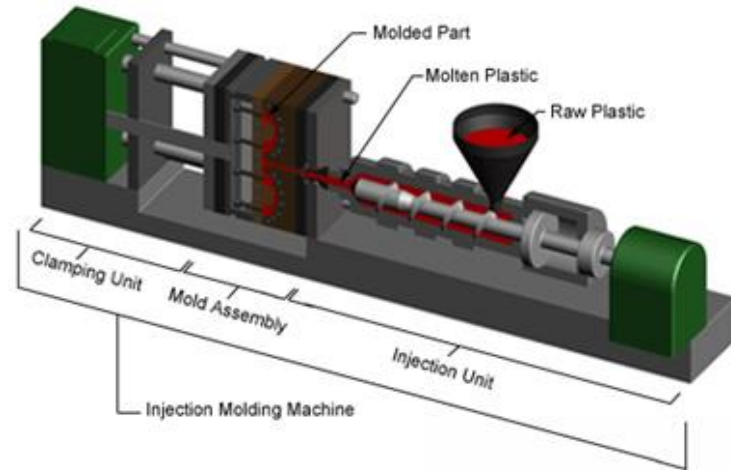
1.spindle 2.drill 3.part 4.holder 5.dynamometer 6.machine table

Thermoforming Principle



Injection molding SMMA

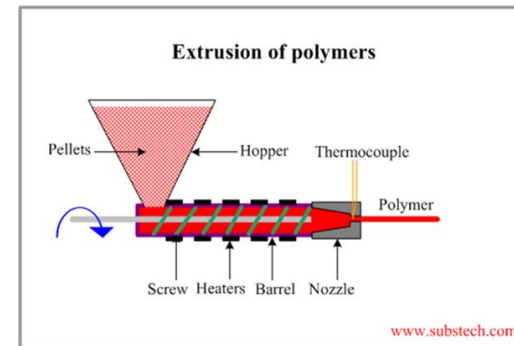
- Drying of CET™ SMMA is not necessary
- Three zone screw with and L/D or 18:1 to 24:1
- Shrinkage is typically 0.4 to 0.6%
- Draft angles on molds for part de-molding
 - 1°
- Processing temps:
 - Rear: 340F - 360F
 - Center: 360F – 375F
 - Front: 390F – 410F
- Mold temperatures
 - 120F to 140F
- Injection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



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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 !