rotuba

SCENTED ACETATE

TYPICAL MOLDING CONDITIONS

Auracell™

Scented Cellulose Acetate
Barrel Temp Starting Profile.

Flow	MSS	MS	M	MH	H	H2	H3
Rear	350°- 370°F	340°- 360°F	360°- 380°F	380°- 400°F	400°- 420°F	420°- 450°F	450°- 470°F
Center	350°- 370°F	340°- 360°F	360°- 380°F	380°- 400°F	400°- 420°F	420°- 450°F	450°- 470°F
Front	350°- 370°F	340°- 360°F	360°- 380°F	380°- 400°F	400°- 420°F	420°- 450°F	450°- 470°F
Nozzle(1)	370°- 390°F	360°- 380°F	380°- 400°F	390°- 410°F	410°- 430°F	430°- 460°F	460°- 480°F

Scented Cellulose Acetate Propionate
Barrel Temp Starting Profile.

Flow	MH	H	H2	H3
Root	280°- 290°F	290°- 300°F	300°- 310°F	315°- 325°F
Rear - Root	290°- 300°F	300°- 310°F	310°- 320°F	325°- 335°F
Rear - Center	300°- 310°F	310°- 320°F	320°- 330°F	335°- 345°F
Center	325°- 335°F	335°- 345°F	345°- 355°F	360°- 370°F
Front	355°- 375°F	365°- 385°F	375°- 395°F	390°- 410°F
Nozzle	355°- 375°F	365°- 385°F	375°- 395°F	390°- 410°F

Pressures

Flow	MSS	MS	M	MH	H	H2	H3
Moveable Half	1100 / 950 PSIG	1200 / 1000 PSIG	1300 / 1100 PSIG	1400 / 1100 PSIG	1500 / 1200 PSIG	1600 / 1200 PSIG	1700 / 1300 PSIG
Back Pressure	0 – 50 PSI	0 – 50 PSI	0 – 50 PSI	0 – 50 PSI	0 – 50 PSI	0 – 50 PSI	0 – 50 PSI

Mold Temperatures (2)	SOFT FLOWS BELOW MS	-	100°F – 140°F
	HARDER FLOWS	-	100°F – 180°F
Cycle Times	INJECTION (3)	-	8 – 12 sec.
	BOOSTER	-	6 – 12 sec.
	CURE	-	40 – 70 sec.

Drying Conditions: It is preferred to use desiccant dryers, at reduced temperatures and drying times. 150°F for 2 hours is a target with dew point between -20°F and -40°F. Too high of temperatures and drying times will burn out the fragrance. In the absence of a desiccant dryer, the injection molding machine hopper may be used. Tray dryers may also be used.

Tooling: The mold vent for the tool should be .002" to .003". If this is not the case, mold temperatures could be elevated to help drive off volatiles thereby reducing surface blushing. (180°F – 220°F)

Mold Temp. Regulation: Most molding thermolators use hot water as their medium. In the case of elevated mold temperatures as shown above, oil thermolators should be used as they can achieve high temperatures of 220°F and higher without turning to steam.

(1) Use straight flow through or revers nozzle. Nozzle orifice should be 1/16" smaller than sprue orifice at end of mold.
(2) Do not exceed 160°F without oil medium. Higher mold temps may be used to burn of surface plasticizer. Use thermolator to heat mold or clean water (just cracked) . Never use a chiller.
(3) Injection time may be increased; depends on part thickness, part size, and number of cavities.

●Rotuba Extruders, Inc.
1401 Park Avenue South
Linden, NJ 07036
Tel (908) 486-1000
Fax (908) 486-0874
info@rotuba.com
www.rotuba.com