



VIP_HTELEC SF 75 Batch

Processing Instructions for VIPHTelec SF 75 Batch

1. Dosage:

Our batch is 75% filled with stainless steel fibers, and the binder material is tailored to the polymer being processed. The dosage depends on the desired fiber content in the finished part and the desired conductivity value.

2. Barrel Temperatures:

Depends on the polymer being processed. Please refer to the material manufacturer's processing instructions.

3. Injection Speed:

Depends on your part geometry, sprue design, and machine size.

The general rule is "as slow as possible, as fast as necessary" to fill the part with minimal shear.

4. Screw Peripheral Speed:

During dosing, only apply the shear force necessary to evenly disperse the steel fibers without damaging them. A relatively slow screw peripheral speed is beneficial for better homogeneity with reduced shear stress. Assuming consistent feed behavior, you can use almost the entire remaining cooling time for dispensing.

5. Back pressure:

The specific back pressure depends on the base polymer being processed..

6. Optimal ratio of dispensing stroke to screw diameter:

The optimal dispensing stroke is 1.5 - 2.5D.

7. Mold temperature:

Depends on the polymer being processed. Please observe the processing instructions of the base polymer material manufacturer.