

# Important Points in Injection Molding LIMEX

LIMEX is a composite material that is a distributed non-filler type of composite material that contains over 50% of inorganic materials including Calcium Carbonate. When using LIMEX as masterbatch, it is possible for the level of Calcium Carbonate may fall below the prescribed level (over 50% of inorganic materials including Calcium Carbonate). Please contact TBM's representative if LIMEX were to be diluted during use.

## ■ Important Points

- LIMEX is a material that can be used for general injection molding machines.
- LIMEX absorbs water relative to others, so please dry them enough before molding.
- **The recommended temperature is 90 degrees Celsius (194 degrees Fahrenheit) for 2 hours using a dehumidifying dryer.** In the event that a silver streak or a flash occurs, the temperature would be 100 degrees Celsius (212 degrees Fahrenheit) for 2 hours.
- **We recommend 60 to 90 degrees Celsius (140 to 194 degrees Fahrenheit) for mold temperature.** Please note that if the temperature is lower than 60 degrees Celsius (140 degrees Fahrenheit), inferior quality of surface occurs and there is a possibility that weld lines are easier to notice.
- **We recommend 190 to 210 degrees Celsius (374 to 410 degrees Fahrenheit) for the cylinder temperature.** Please lower the cylinder temperature down to idling temperature if the machine with pellets in it were not to be used for a long time since pellets may burn or change color if they are left inside the machine at high temperature.
- **Please avoid submarine gate, horn gate as much as possible when gate shaping. Direct gate, side gate and film gate should not have problems.**
- Hot runner can be used, but it is necessary to conduct a purging before changing pellets—just like for colored pellets.
- For food-related application, a coating is a must. For non-food application, the coating is not necessary.

## ■ Product Use Instructions

- Avoid storing in places with high temperature or direct sunlight.
- This product can be affected from humidity/moisture. As such, store it inside where it will not come into contact with water including raindrops and there is certain temperature control.
- **After opening package, use as quickly as practicable.**
- **After opening package, avoid moisture, dust and dirt by storing and packaging with a tight seal. We recommend drying once it is opened again.**
- Avoid use near fire.