

Large amounts of film scrap are available due to the short lifetime associated with packaging and industrial film materials such as carrier bags, dustbin liners and plastic sacks. A typical lifetime of products of this type is only two years. 100% recycle material may be used in low grade applications such as bin liners, other products such as carrier bags may incorporate scrap with the virgin material.

Again, like blow moulding, film blowing has specific material requirements in terms of melt strength, viscosity and inflation characteristics. Generally film blowing is limited to polyolefin materials, the majority of usage being of low density polyethylene (LDPE), linear low density polyethylene (LLDPE) and high density polyethylene (HDPE).

1.4.6 Intrusion Moulding

The intrusion process is suited to mixed plastics. Generally they are finely ground before processing to aid dispersion. The process has elements of extrusion in that a plasticating unit is used to homogenise the mixture, which is then fed into an open mould. Once the plastic has cooled it can be ejected or removed depending on the type of mould that is used. The process is tolerant to contaminants such as mixed plastics, sand, glass, wood and paper and providing a minimum polyolefin fraction of around 40% is present. Other contaminants become embedded in this low melting fraction. This process is generally used to produce large, geometrically simple shapes such as profiles and panels for wood replacement applications such as fencing, posts and scaffolding.

1.4.7 Injection-Compression Moulding

The injection-compression moulding process combines elements of both the injection moulding process and the compression moulding process.

Compared with injection moulding, there is a big reduction in the filling pressures required. There is also less orientation of the material, which can improve properties and reduce anisotropy. This can be of special importance in moulding thin-walled components where dimensional stability is important, and with transparent mouldings where good optical properties are required.

Figure 1.18 shows the formation of an injection-compression moulded product. A pre-set amount of material is injected into a partly closed mould (a). The mould then closes to the size of the desired final component, squeezing the material by compression to complete cavity filling (Figure 1.18b).

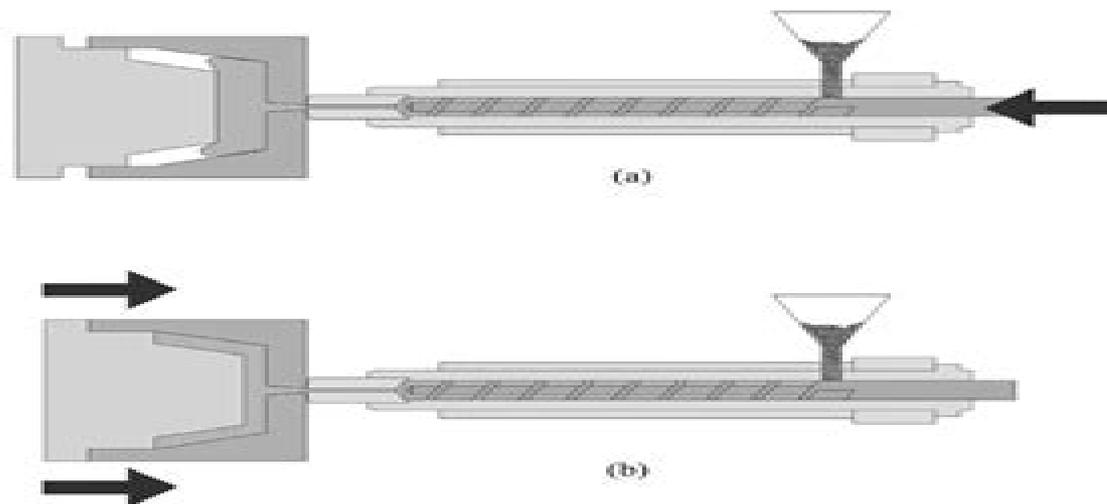


Figure 1.18 Injection-compression moulding

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