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Versalis

Processing conditions per grade

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## Blown film application

<i>Product code</i>	<i>Recommended temperature</i>	<i>Recommended thickness</i>
AB 10      FC 20	180 - 220°C	60 - 250 µm
FC 30	180 - 220°C	50 - 200 µm
FC 39 D    FC 39 F    FC 39    FC 40	180 - 220°C	40 - 150 µm
FF 20      FF 30      FF 33      FF 33 D    FF 33 F	170 - 200°C	40 - 150 µm
FF 34 D    FF 34      FF 34 F    FF 39 D    FF 39 F		
FH 20      FH 39 D    FH 39 F	160 - 200°C	30 - 100 µm
FL 20 R    FL 23 I    FL 30 I    FL 34 D    FL 34 F	160 - 190°C	25 - 80 µm
FL 34 I    FL 39 F    FL 39 D		
FM 34 I    FM 34 D    FM 34 F	150 - 170°C	18 - 50 µm

## Cast film application

<i>Product code</i>	<i>Recommended temperature</i>	<i>Recommended thickness</i>
GM 20 R                      GM 30 R	260 - 330°C	> 15 µm
GP 20 R	260 - 330°C	> 10 µm

## Injection molding

<i>Product code</i>	<i>Temperature profile of the barrel *</i>	<i>Temperature of the mold</i>
MM 20 R	170 - 230°C	10 - 30°C
MP 20      MP 30 R      MP 31 R      MQ 10 R	160 - 200°C	10 - 30°C
MR 10 R    MT 10 R      MV 10 R		

\*Processing conditions are depending on several parameters: the shape of the part to be manufactured, the localization of the injection point, the injection molding machine and the cooling of the mould.



## Blown film application

<i>Product code</i>				<i>Recommended temperature</i>	<i>Recommended thickness</i>
FF 25 U	FG 20 F	FG 20 U	FG 23 F	190 - 230°C	15 - 50 µm
FG 23 U	FG 30	FG 30 U	FG 33 U		
FH 56 A				190 - 230°C	10 - 50 µm

## Cast film application

<i>Product code</i>				<i>Recommended temperature</i>	<i>Recommended thickness</i>
CL 10	CL 10 F	CL 10 U	CM 50	220 - 270°C	> 15 µm

## Injection molding

<i>Product code</i>			<i>Temperature profile of the barrel *</i>	<i>Temperature of the mold</i>
MR 50 A	MR 50 U	MR 56 A	170 - 230°C	10 - 40°C
MS 20 A	MS 20 U	MS 26 A	160 - 210°C	10 - 40°C
MS 40 A	MS 40 U	MT 40 U		

\*Processing conditions are depending on several parameters: the shape of the part to be manufactured, the localization of the injection point, the injection molding machine and the cooling of the mould.



## Blown film application

<i>Product</i>	<i>Product code</i>			<i>Recommended temperature</i>	<i>Recommended thickness</i>
LLDPE	FF 506	FG 306	FG 336	190 - 230°C	10 - 50 µm
LLDPE	FF 106	FG 106	FG 106A	190 - 230°C	> 15 µm
	FGH 196				
VLDPE	FF D0			190 - 230°C	10 - 50 µm
VLDPE	FGH B0	FGH B3		200 - 230°C	10 - 50 µm
Compound	SH 12			180 - 210°C	40 - 80 µm <sup>1</sup>

<sup>1</sup> for a 3-layer film structure 20 /60 /20.

## Cast film application

<i>Product</i>	<i>Product code</i>			<i>Recommended temperature</i>	<i>Recommended thickness</i>
LLDPE	CL 106	CL 506	CHH 196	220 - 270°C	> 15 µm
	CLH 196				
VLDPE	CH D0	CL B0	CLH D0	220 - 270°C	Used in co-extrusion
VLDPE	CH G0	CHH G0		190 - 270°C	and not pure



## Injection molding

<i>Product</i>	<i>Product code</i>			<i>Temperature profile of the barrel *</i>	<i>Mold temperature</i>
VLDPE	MP D0	MQ B0	MQ F0	160 - 200°C	10 - 40°C

\*Processing conditions are depending on several parameters: the shape of the part to be manufactured, the localization of the injection point, the injection molding machine and the cooling of the mould.

## Rotational molding

<i>Product</i>	<i>Product code</i>			<i>Temperature range**</i>	
Compound	RBH 58	RBH 58 B	RBH 58 U	230 - 280°C	
LLDPE	RL 50 U	RM 50 U	RN 50 U		

\*\*The recommended temperature range for rotational molding depends on the residence time inside the oven.

## Drip irrigation application

<i>Product code</i>	<i>Melt temperature</i>
DFH 20	190 - 230°C



## Blown film application

<i>Product code</i>		<i>Recommended temperature</i>	<i>Recommended die gap</i>	<i>Recommended thickness</i>
FA 506	FB 506	190 - 210°C	1 mm - 1.3 mm	10 - 50 µm
FC 82				

## Injection molding

<i>Product code</i>			<i>Temperature profile of the barrel *</i>	<i>Mold temperature</i>
ML 70 U	MM 70 U	MM 80 U	220 - 275°C	10 - 40°C
MP 90 C	MP 90 U	MQ 70 U	190 - 260°C	10 - 40°C
MR 80 U	MS 80 U			

\*Processing conditions are depending on several parameters: the shape of the part to be manufactured, the localization of the injection point, the injection molding machine and the cooling of the mould.

## Blow molding

Recommended temperatures	<i>BB 76</i>	<i>BB 82</i>	<i>BC 82</i> <i>BC 82 L</i>
<i>Barrel zone 1 -Temperature Setting</i>	180 - 190°C	180 - 190°C	170 - 180°C
<i>Barrel zone 2 -Temperature Setting</i>	190 - 205°C	195 - 205°C	185 - 195°C
<i>Head and Die Temperature Setting</i>	200 - 210°C	195 - 205°C	185 - 190°C
<i>Stock Temperature</i>	200 - 210°C	205 - 215°C	195 - 205°C



## Pipe extrusion

Recommended temperatures	<i>PF 92</i>
<i>Barrel zone 1 -Temperature Setting</i>	170 - 180°C
<i>Barrel zone 2 -Temperature Setting</i>	185 - 195°C
<i>Head and Die Temperature Setting</i>	185 - 195°C
<i>Stock Temperature</i>	200 - 220°C

## Sheet extrusion

<i>Product code</i>	<i>Temperature profile</i>
SB 60	200 - 230°C

## Drip irrigation application

<i>Product code</i>	<i>Temperature profile [mixing screw]</i>	<i>Die gap</i>
DFH 20	190 - 230°C	1,5 - 2,5 mm



## Blown film application

<i>Product code</i>				<i>Recommended temperature</i>	<i>Recommended thickness</i>
FC 45	FC 45 F	FD 20		170 - 200°C	50 - 200 µm
FD 20 F	FD 23	FD 23 F			
FD 50	FD 50 F	FD 53		160 - 190°C	50 - 200 µm
FD 53 F					
FF 35	FF 35 F			170 - 200°C	30 - 150 µm
FF 45	FF 45 F			160 - 190°C	30 - 150 µm
FF 55	FF 55 F			150 - 180°C	30 - 150 µm
FL 25	FL 25 F			170 - 200°C	30 - 150 µm

## Injection molding

<i>Product code</i>				<i>Stock temperature</i>	<i>Mold temperature</i>
MH 40	MH 40 F			140 - 200°C	10 - 30°C
ML 20	ML 20 F			150 - 200°C	10 - 30°C
ML 21	ML 21 F	ML 31	ML 31 F	150 - 210°C	10 - 30°C
ML 30	ML 30 F			150 - 210°C	10 - 30°C
ML 40	ML 40 F	ML 50	ML 50 F	140 - 200°C	10 - 30°C
ML 60	ML 60 F			140 - 190°C	10 - 30°C
MP 34	MP 34 F			140 - 200°C	10 - 30°C
MP 35	MP 35 F	MQ 40	MQ 40 F	140 - 200°C	10 - 30°C

\*Processing conditions are depending on several parameters: the shape of the part to be manufactured, the localization of the injection point, the injection molding machine and the cooling of the mould.

## Hot melt application

<i>Product code</i>			<i>Stock temperature</i>
HN 70	HN 70 F	HS 70	140 - 190°C





## Blow molding

	<i>BC 82 PH</i>
Recommended temperatures	
<i>Barrel zone 1 -Temperature Setting</i>	170 - 180°C
<i>Barrel zone 2 -Temperature Setting</i>	185 - 195°C
<i>Head and Die Temperature Setting</i>	185 - 190°C
<i>Stock Temperature</i>	195 - 205°C

## Blown film application

<i>Product code</i>	<i>Recommended temperature</i>	<i>Recommended thickness</i>
FC 20 PH	180 - 220°C	60 - 250 µm
FL 20 PH	160 - 190°C	25 - 80 µm

## Injection molding

<i>Product code</i>			<i>Temperature profile of the barrel</i>	<i>Temperature of the mold</i>
MP 20 PH	MP 30 PH	MP 31 PH	160 -200°C	10 - 30°C
MR 10 PH	MT 10 PH			
MP 90 PH			190 - 260°C	10 - 40°C

## Coating extrusion

<i>Product code</i>	<i>Temperature profile</i>	<i>Thickness</i>
MP 20 PH	260 - 330°C	<10 µm



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