



*“Speed, Quality, Economy...”*

## **BA Guidelines**

### *Use of Blowing Agents in Polyethylene*

#### **How much *AccelMax*<sup>™</sup> blowing agent should be used?**

Usage levels are generally calculated as a percentage of the resin weight. With experimentation, the optimum level of **ACCEL Color** blowing agent can be established for the particular application, but as a guide, the following “Rules of Thumb” can be used:

- |  |       |
|--|-------|
| ▶ Extrusion – weight & density reduction             | 0.80% |
| ▶ Extrusion – profile, sheet and film                | 0.50% |
| ▶ Structural foam molding (as primary blowing agent) | 1.00% |
| ▶ Structural foam molding (as nucleating agent)      | 0.80% |
| ▶ Injection molding (for sink marks)                 | 0.20% |

#### **Typical addition rates based on a 50% active formula concentrate:**

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|---------------------|---------------|
| ▶ Weight reduction  | 0.25% - 0.75% |
| ▶ Injection molding | 0.15% - 0.20% |
| ▶ Structural foam   | 1.15% - 1.25% |