



"Speed, Quality, Economy..."

Processing Guidelines

AccelMax™ WFC Wood Fiber Composites

- DESCRIPTION:** Colorants, stabilizers, process aids and foaming agents for all thermoplastic wood fiber composites.
- DRYING:** **AccelMax™ WFC** composites and concentrates must be thoroughly dried before processing. We suggest 0.30% moisture content or less. This is typically accomplished by drying for 2-5 hours at temperatures of 120-160 F.
- STORAGE:** Unused material should be kept sealed due to the hygroscopic nature of the material.
- TEMPERATURE:** Stock (melt) temperature should be controlled under 375 F to insure that the wood flour does not degrade.
- FILL RATES:** Slow fill rates with the lowest possible pressures will help to limit any degradation that may occur due to excessive shear. Because of the shear sensitivity of these products, a general-purpose, low-compression screw is recommended. It is also recommended that minimal backpressure is used, enough to stabilize processing only.
- Wood-filled compounds are ideally suited for large gates. Small-diameter subgates or very thin fan gates could create shear problems.
- SCREEN PACKS:** Screw packs finer than 20 mesh are not recommended.
- RETENTION TIME:** If the wood fiber will be in the barrel for over 15 minutes, purging is recommended. Wood fiber composites purge easily with straight resin or conventional purging compounds.
- BLOWING AGENTS:** Low-temperature blowing agents can be effectively used.