

## Processing instructions **Lifocork**



Cork is a natural product. It is gained out of the cork bark which contains a lot of moisture as well as dyestuff. Through the compounding process a lot of moisture is extracted. However, there still remains a residue of moisture in the compound. As cork absorbs moisture from the air please take care that the cork is pre-dried before processing.

**It is necessary to dry Lifocork for 2 - 3 h at 70°C in a dry air dryer (dehumidifying dryer; desiccant air dryer) for getting best results.**

In principle Lifocork has to be processed very carefully. We recommend using a slow screw speed, the lowest dynamic pressure and a slow injection speed. Recommended temperatures from the feed to the die are: 150 °C, 170 °C, 175 - 185 °C, 175 °C. Processing is possible up to 190°C.

Please ensure that there is a material in the machine which flows very good at the desired temperatures. We suggest using LDPE or EVA.

Extremely important is the injection. If the cork is injected slowly it will keep the natural colour. The mould should be filled only with the injection moulding pressure, so that the mould is properly filled. Otherwise, the water is squeezed out of the cork and causes that the cork becomes dark and burned. The natural light colour disappears and the cork smells strong and bad.

If the cork compounds are processed in series the tools have to be protected against corrosion. During the injection process always some water is released which can attack the surface of the mould. After having made tests with cork compounds the tools should be cleaned properly.

Important: For getting best results it is very important, that all gates / hot running systems / nozzles have a diameter bigger than 1 mm (better 1.2 mm). The wall thickness should be at least 1.0 mm, if you produce larger parts at least 2.0 mm.

**In case of further questions please do not hesitate to contact us  
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