



220A Engelwood Drive, Orion, Michigan 48359 USA
 (Toll Free) 1-877-777-4514 (Intl) 248-845-4515 (Fax) 248-287-4515
 www.PremierPlasticResins.com info@premierplasticresins.com

Typical Molding Conditions

Material: PPR-ABS04

Processing temperatures:	Parameters			
	min.	max.	min.	max.
Stock*, F (C)	440	500	227	260
Rear, F (C)	440	490	227	254
Middle, F (C)	450	500	232	260
Front, F (C)	450	500	232	260
Nozzle, F (C)	470	490	243	254
Mold, F (C)	120	170	49	77

Processing pressures:				
Injection, psi (MPa)	700	8,000	5	55
Hold, psi (MPa)	500	6,500	3	45
Back (plasticizing), psi (MPa)	0	150	0	1

Other parameters:				
Injection rate	moderate-fast			
Screw speed	moderate-fast			
Cushion, in (mm)	0.25	0.50	6.35	12.7
Decompression, in (mm)	0.15	0.30	3.81	7.6
Regrind, %				

Drying parameters:				
Temperature, F (C)	170	180	77	82
Time, hrs	2	4		
Maximum moisture content, %	0.2			

*measure with a pyrometer in an air shot