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Typical Molding Conditions

Material: PPR-PA601

Processing temperatures:	Parameters			
	min.	max.	min.	max.
Stock*, F (C)	490	570	254	299
Rear, F (C)	460	540	238	282
Middle, F (C)	480	560	249	293
Front, F (C)	480	560	249	293
Nozzle, F (C)	470	550	243	288
Mold, F (C)	150	200	66	93

Processing pressures:				
Injection, psi (MPa)	2,000	15,000	14	103
Hold, psi (MPa)	1,500	12,000	10	83
Back (plasticizing), psi (MPa)	0	100	0	1

Other parameters:				
Injection rate	moderate-fast			
Screw speed	slow-moderate			
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)	160	180	71	82
Time, hrs	2	4		
Maximum moisture content, %		0.2		

*measure with a pyrometer in an air shot