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Typical Molding Conditions

Material: PPR-PPCO04

Processing temperatures:	Parameters			
	min.	max.	min.	max.
Stock*, F (C)	400	480	204	249
Rear, F (C)	410	460	210	238
Middle, F (C)	410	460	210	238
Front, F (C)	400	470	204	243
Nozzle, F (C)	410	460	210	238
Mold, F (C)	80	140	27	60

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	slow-moderate			
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:	usually not necessary			
Temperature, F (C)	100	160	38	71
Time, hrs	2	4		
Maximum moisture content, %		0.2		

*measure with a pyrometer in an air shot