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Typical Molding Conditions

Material: PPR-PPCO08

<u>Processing temperatures:</u>	<u>Parameters</u>			
	min.	max.	min.	max.
Stock*, F (C)	380	450	193	232
Rear, F (C)	380	450	193	232
Middle, F (C)	370	440	188	227
Front, F (C)	370	440	188	227
Nozzle, F (C)	390	430	199	221
Mold, F (C)	60	130	16	54

<u>Processing pressures:</u>				
Injection, psi (MPa)	500	8,000	3	55
Hold, psi (MPa)	400	6,500	3	45
Back (plasticizing), psi (MPa)	0	50	0	0

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

<u>Drying parameters:</u>	generally 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