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Typical Molding Conditions

Material: PPR-ABS03

<u>Processing temperatures:</u>	<u>Parameters</u>			
	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

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

<u>Other parameters:</u>				
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, %				

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

\*measure with a pyrometer in an air shot