



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-PA6601

Processing temperatures:	Parameters			
	English		S.I.	
	min.	max.	min.	max.
Stock*, F (C)	540	570	282	299
Rear, F (C)	540	580	282	304
Middle, F (C)	530	570	277	299
Front, F (C)	520	570	271	299
Nozzle, F (C)	510	560	266	293
Mold, F (C)	100	200	38	93

Processing pressures:

Injection, psi (MPa)	8,000	20,000	55	138
Hold, psi (MPa)	6,000	15,000	41	103
Back (plasticizing), psi (MPa)	0	100	0	1

Other parameters:

Injection rate	moderate-fast			
Screw speed	slow			
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)	165	185	74	85
Time, hrs	2	4		
Maximum moisture content, %		0.2		

*measure with a pyrometer in an air shot