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Typical Molding Conditions

Material: PPR-ABSPC02

Processing temperatures:	Parameters			
	min.	max.	min.	max.
Stock*, F (C)	520	580	271	304
Rear, F (C)	460	520	238	271
Middle, F (C)	480	540	249	282
Front, F (C)	490	550	254	288
Nozzle, F (C)	490	550	254	288
Mold, F (C)	180	205	82	96

Processing pressures:				
Injection, psi (MPa)	8,000	14,000	55	97
Hold, psi (MPa)	6,000	12,000	41	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)	190	210	88	99
Time, hrs	2	4		
Maximum moisture content, %	0.02			

*measure with a pyrometer in an air shot