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Typical Molding Conditions

Material: PPR-GPPS01

Processing temperatures:	Parameters			
	min.	max.	min.	max.
Stock*, F (C)	400	550	204	288
Rear, F (C)	350	425	177	218
Middle, F (C)	375	525	191	274
Front, F (C)	375	525	191	274
Nozzle, F (C)	375	525	191	274
Mold, F (C)	50	160	10	71

Processing pressures:				
Injection, psi (MPa)	5,000	40,000	34	276
Hold, psi (MPa)	4,000	30,000	28	207
Back (plasticizing), psi (MPa)	10	500	0	3

Other parameters:				
Injection rate	fast			
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, %				

Drying parameters:	generally not necessary			
Temperature, F (C)	170	190	77	88
Time, hrs	2	4		
Maximum moisture content, %		0.02		

*measure with a pyrometer in an air shot

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