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Typical Molding Conditions

Material: PPR-POM01

Processing temperatures:	Parameters			
	min.	max.	min.	max.
Stock*, F (C)	390	440	199	227
Rear, F (C)	370	430	188	221
Middle, F (C)	365	420	185	216
Front, F (C)	365	420	185	216
Nozzle, F (C)	380	410	193	210
Mold, F (C)	180	220	82	104

Processing pressures:				
Injection, psi (MPa)	10,000	16,000	69	110
Hold, psi (MPa)	6,000	12,000	41	83
Back (plasticizing), psi (MPa)	0	50	0	0

Other parameters:				
Injection rate	moderate-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, %	25			

Drying parameters:	usually not necessary			
Temperature, F (C)	170	190	77	88
Time, hrs	2	4		
Maximum moisture content, %	0.2			

\*measure with a pyrometer in an air shot