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Typical Molding Conditions

Material: PPR-PS01

| 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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