

Back Pressure	50.0 psi
Screw Speed	20 to 100 rpm
Screw Compression Ratio	3.0:1.0 to 4.5:1.0

Injection Notes

Mold Temperature: > 120°F

Injection Speed: 1-5 Seconds

Drying Conditions: Usually not necessary

Cooling Time: Short

Screw Type: General

Slightly longer cycle times may be required to mold wall thicknesses over 1/4 inch.

Slightly higher injection pressures and mold temperatures may be required to mold wall thicknesses below 0.100 inches.

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	374	°F
Cylinder Zone 2 Temp.	392	°F
Cylinder Zone 3 Temp.	410	°F
Melt Temperature	356 to 410	°F

Notes

¹ Typical properties: these are not to be construed as specifications.



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