

Asahi Kasei Plastics North America, Inc.

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THERMYLENE® PP—Glass Reinforced

PROCESSING GUIDE

Drying Conditions: Maximum acceptable moisture is 0.15%

Hours: 2 Temperature: 160° F (71)°C

Special Considerations: None

General Recommendations for Barrel Temperatures

	<u>Fahrenheit</u>	<u>Celsius</u>
Rear	380 to 400	193 to 204
Middle	400 to 420	204 to 215
Front	420 to 450	215 to 232
Nozzle	430 to 460	221 to 237
Mold Temperature	80 to 150	26 to 65

Pressures:

Injection (Boost)	12,000 to 16,000 Psi	(83 to 110) Mpa
Holding	10,000 to 15,000 Psi	(69 to 103) Mpa
Back	50 Psi	(.345) Mpa

Injection Speed: Medium—Fast Screw Rpm: Normal

Cooling Time: Short Screw Type: General

Notes: (1) Slightly longer cycle times may be required to mold wall thicknesses over 1/4 inch

(6.35 mm).

(2) Slightly higher injection pressures and mold temperatures may be required to mold wall thicknesses below 0.100 inches (2.54 mm).

DISCLAIMER OF WARRANTY AND LIABILITY.

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