

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	75 - 80	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 275	°C	-
Mold temperature	55 - 75	°C	-
Zone 1	215 - 265	°C	-
Zone 2	225 - 270	°C	-
Zone 3	240 - 275	°C	-
Screw speed	20 - 100	rpm	-
Back pressure	0.3 - 0.7	MPa	-

Characteristics

Processing

Injection Molding

Special Characteristics

Flame retardant

Additives

Flame retarding agent

Regional Availability

Asia Pacific