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Typical Molding Conditions

Material: PPR-HDPE01

Processing temperatures:	Parameters			
	min.	max.	min.	max.
Stock*, F (C)	380	450	193	232
Rear, F (C)	370	450	188	232
Middle, F (C)	370	450	188	232
Front, F (C)	360	440	182	227
Nozzle, F (C)	380	450	193	232
Mold, F (C)	60	120	16	49

Processing pressures:				
Injection, psi (MPa)	500	6,000	3	41
Hold, psi (MPa)	400	5,000	3	34
Back (plasticizing), psi (MPa)	0	150	0	1

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, %				

Drying parameters:	Usually not necessary			
Temperature, F (C)	170	180	77	82
Time, hrs	2	4		
Maximum moisture content, %		0.2		

*measure with a pyrometer in an air shot