



220A Engelwood Drive, Orion, Michigan 48359 USA  
 (Toll Free) 1-877-777-4514 (Intl) 248-845-4515 (Fax) 248-287-4515  
 www.PremierPlasticResins.com info@premierplasticresins.com

Typical Molding Conditions

Material: PPR-HDPE02

<u>Processing temperatures:</u>	<u>Parameters</u>			
	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

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

<u>Other parameters:</u>				
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, %				

<u>Drying parameters:</u>	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