

Typical Molding Conditions

Grades	CFH2515KL CFH2525KL
Preliminary drying	120 °C, 4 to 8 hours
Cylinder Temp. rear part central part front part nozzle	290 to 320 °C 280 to 310 °C 280 to 310 °C 270 to 300 °C
Mold Temp.	80 to 120 °C
Injection Pressure	50 to 150 Mpa
Screw revolution	50 to 100 rpm

The molding conditions need to be changed depending on the mold tool and the molding machine.

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