

Typical Molding Conditions

| | HE9119HR PCR140045, PCR140084 |
|-------------------------------|--|
| Preliminary drying | 120 °C, 4 to 6 hours |
| Cylinder temperature (rear) | 270 to 290 °C |
| Cylinder temperature (center) | 280 to 300 °C |
| Cylinder temperature (front) | 290 to 310 °C |
| Nozzle temperature | 290 to 310 °C |
| Mold temperature | 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.

