

Typical Molding Conditions

	TPN1125, TPN1124	TPN1122, TCF1140, TPN1022	TPN2131, TPN2140, TPN2354, TPN2560
Preliminary drying	120 °C, 4 to 6 hours	100 °C, 4 to 8 hours	100 °C, 4 to 8 hours
Cylinder temp.	300 to 320 °C	280 to 300 °C	260 to 280 °C
Nozzle temp.	310 to 330 °C	290 to 310 °C	280 to 290 °C
Mold temp.	100 to 120 °C	70 to 100 °C	50 to 90 °C
Injection pressure	50 to 150 MPa	50 to 150 MPa	50 to 150 MPa
Screw revolution	50 to 150 rpm	50 to 150 rpm	50 to 150 rpm

Injection molding of Lupilon™ thermal conductive PCs is generally easier to produce good products when the following molding conditions are used:

- ✓ High mold temperature
- ✓ High injection speed
- ✓ High injection pressure

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