

Iupilon™ EMI shielding grade

Recommended molding conditions

	ES1030R
Pre-drying	120 °C, 4~8 hr
Cylinder Temperature (Rear)	270 ~ 290 °C
Cylinder Temperature (Middle)	280 ~ 310 °C
Cylinder Temperature (Front)	280 ~ 320 °C
Nozzle Temperature	280 ~ 320 °C
Mold Temperature	80 ~ 115 °C
Injection Pressure	50 ~ 150 MPa
Screw Rotation Speed	50 ~ 100 rpm

Note: Molding conditions may need to be changed depending on the mold and molding machine used.

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