

Typical Molding Conditions

	Hi-dielectric m-PPE	Hi-dielectric PC
	HD7006, 7007	PCR140045, 84, 85
Preliminary drying	100 to 110 °C, 2 to 4 hours	120 °C, 4 to 6 hours
Cylinder temp. (rear)	260 to 290 °C	270 to 290 °C
Cylinder temp. (center)	270 to 300 °C	280 to 300 °C
Cylinder temp. (front)	280 to 320 °C	290 to 310 °C
Nozzle temp.	280 to 310 °C	290 to 310 °C
Mold temp.	80 to 110 °C	80 to 120 °C
Injection pressure	50 to 150 MPa	50 to 150 MPa
Screw revolution	50 to 100 rpm	50 to 100 rpm

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

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