

PROCESS SET UP SHEET

VYPET MODIFIED PBT AND ALLOYS, FG GRADES

Drying:	Dry at least 4hrs @ 120°C (250°F) prior to molding (< 200 ppm moisture)
Process:	Injection molding
Mold temp:	65 - 90°C (150 – 195 °F)
Barrel temp:	Rear: 245 - 260°C (470 - 500°F) Center: 250 - 265°C (480 - 510°F) Front: 255 -270°C (490 - 520°F)
Nozzle temp:	260 - 270°C (500 - 520°F)
Melt temp:	255 - 270°C (490 - 520°F)
Injection pressure:	Low
Injection speed:	Medium - fast
Back pressure:	Low
Pack time:	Short
Cooling time:	Medium
Back pressure:	No back pressure
Screw rotation:	Slow
Regrind:	Up to 20 % is acceptable

Note on Drying:

The Vypet Modified PBT And Alloys - FG grades process easily but must be thoroughly dried before molding, preferably in a dehumidifying desiccant hopper dryer, operating with an air flow rate of min 1.0 CFM/lb, dew point of -18°C (-40°F) or lower. The material should be dried at 120°C (250°F) for 4 hours and the humidity content of the material should be maintained below 0.02% during molding.

MN47 r 1 / PP PBT ALLOYS-FG REV1

8800, Crescent 1 Ville d'Anjou, (Québec) Canada H1J 1C8

Tel. : 514-354-5757 Fax. : 514-354- 3087 Email : lavergne@lavergne.ca

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