

## PROCESS SET UP SHEET

### VYPET PBT FG GRADES

<b>Drying:</b>	Dry at least 4hrs @ 250°F prior to molding (< 200 ppm moisture)
<b>Process:</b>	Injection molding
<b>Mold temp:</b>	149 – 194 °F
<b>Barrel temp:</b>	Rear: 440 - 470°F Center: 473 - 500°F Front: 482 - 509°F
<b>Nozzle temp:</b>	473- 500°F
<b>Melt temp:</b>	482-509°F
<b>Injection pressure:</b>	Low
<b>Injection speed:</b>	Medium - fast
<b>Pack pressure:</b>	Low
<b>Pack time:</b>	Short
<b>Cooling time:</b>	Medium
<b>Back pressure:</b>	No back pressure
<b>Screw rotation:</b>	Slow
<b>Regrind:</b>	Up to 20 % is acceptable

#### Note on Drying:

The Vypet PBT 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 121°C (250°F) for 4 hours and the humidity content of the material should be maintained below 0.02% during molding.

Rev 2

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