



## PROCESS SET UP SHEET

### VYPET PC 1020

<b>Drying:</b>	Dry at least 4hrs @ 210°F prior to molding (< 200 ppm moisture)
<b>Process:</b>	Injection molding
<b>Mold temp:</b>	18°C - 74°C ( 65°F – 165°F )
<b>Barrel temp:</b>	Rear: 243°C - 254°C ( 470°F – 490°F ) Center: 249°C - 260°C ( 480°F - 500°F ) Front: 254°C - 266°C ( 490°F – 510°F )
<b>Nozzle temp:</b>	257°C - 268°C ( 495°F – 515°F )
<b>Melt temp:</b>	260°C - 277°C ( 500°F - 530°F )
<b>Injection pressure:</b>	69 Mpa – 139 Mpa ( 10 000 – 20 000 PSI )
<b>Injection speed:</b>	Slow to moderate
<b>Pack pressure:</b>	Low
<b>Pack time:</b>	Short
<b>Back pressure:</b>	0.34 Mpa – 0.69 Mpa ( 50 - 100 PSI )
<b>Regrind:</b>	Up to 20 % is acceptable

#### Note on Drying:

The Vypet 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 99°C (210°F) for 4 hours and the humidity content of the material should be maintained below 0.02% during molding.



ISO 17025



Conseil canadien des normes  
Standards Council of Canada

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

Tel. : 514-354-5757 Fax. : 514-354- 3087 Email : [lavergne@lavergne.ca](mailto:lavergne@lavergne.ca)

The information in this data sheet is to our knowledge, true and accurate. We do not guarantee the applicability or accuracy of this information or suitability of our products in any given situations. Users of our products should make their own tests to determine the suitability of each product for their particular applications.