



PROCESS SET UP SHEET

VYTEEN PCGF20BK, PCGF10BK

Drying:	Dry at least 4hrs @ 250°F prior to molding (< 200 ppm moisture)*
Process:	Injection molding
Mold temp:	176 - 230°F
Barrel temp:	Rear: 563 - 581°F Center: 590 - 608°F Front: 608 - 626°F
Nozzle temp:	554 - 590°F
Melt temp:	581 - 617°F
Injection pressure:	Low
Injection speed:	Medium - fast
Pack 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 Vyteen 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.



ISO 17025



Conseil canadien des normes
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