



## PROCESS SET UP SHEET

**VNT 835;930;440;335;340;340A;**  
**VNT 615HP;630;630FR;645;652C;**  
**VNT 915;**  
**VNT 55530-10;5530-25;**

<b>Drying:</b>	Dry at least 4hrs @ 250°F prior to molding (< 200 ppm moisture)*
<b>Process:</b>	Injection molding
<b>Mold temp:</b>	200 - 250°F
<b>Barrel temp:</b>	Rear: 500 - 520°F Center: 510 - 530°F Front: 520 - 560°F
<b>Nozzle temp:</b>	530 - 570°F
<b>Melt temp:</b>	530 - 570°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 VNT 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



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