

Processing Condition of HU-650

INJECTION MOLDING		
Mold Temperature	degree C ()	40 – 70 (104 – 158)
Melt Temperature	degree C ()	220 – 250 (420 – 480)
Nozzle	degree C ()	220 – 250 (420 – 480)
Front	degree C ()	220 – 250 (420 – 480)
Middle	degree C ()	210 – 235 (410 – 450)
Rear	degree C ()	200 – 220 (390 – 430)
Screw Speed	rpm	40 – 80
Back Pressure	Kg/cm² (psi)	5 – 15 (70 – 210)
Suck Back	mm (inch)	3 – 5 (0.118 – 0.197)
Drying Temperature	degree C ()	80 – 90 (175 – 195)
Drying Time	h	2 – 4
Moisture Content, max	%	0.04%