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Processing Guidelines

Material: *Acetal Copolymer*

GENERAL INJECTION MOLDING PROCESSING GUIDELINES

Property	Data	Units
Drying Temperature	180	°F
Drying Time (Drying is optional)	3.00	hr
Injection Pressure	10000 - 20000	psi
Suggested Max Moisture	0.10	%
Suggested Max Re grind	20.0	%
Rear Temperature	350 - 370	°F
Middle Temperature	360 - 380	°F
Front Temperature	370 - 390	°F
Nozzle Temperature	380 - 390	°F
Mold Temperature	180 - 250	°F
Processing (Melt) Temp	360 - 390	°F
Screw Speed	20 - 40	rpm

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