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Processing Guidelines

Material: *Acrylic*

GENERAL INJECTION MOLDING PROCESSING GUIDELINES

Property	Data	Units
Clamp Tonnage	2.0 - 4.0	tons/in ²
Drying Temperature	140 - 160	°F
Drying Time	4.0 - 6.0	hr
Drying Time, Maximum	8.0	hr
Injection Pressure	10000-16000	psi
Suggested Max Moisture	0.02	%
Suggested Max Regrind	20.0	%
Rear Temperature	360 - 440	°F
Front Temperature	380 - 460	°F
Middle Temperature	380 - 460	°F
Nozzle Temperature	380 - 460	°F
Mold Temperature	140 - 180	°F
Annealing Temperature	140 - 160	°F
Annealing Time	3.0 - 5.0	hr

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