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Processing Guidelines

Material: *Acrylonitrile - Ethylene-Propylene - Styrene (AES) Resin*

GENERAL INJECTION MOLDING PROCESSING GUIDELINES

Property	Data	Units
Drying Temperature	180 - 200	°F
Drying Time	2.0 - 3.0	hr
Drying Time, Maximum	4.0	hr
Injection Pressure	10000 - 12000	psi
Suggested Max Regrind	20.0	%
Rear Temperature	370 - 410	°F
Middle Temperature	390 - 435	°F
Front Temperature	410 - 460	°F
Nozzle Temperature	410 - 460	°F
Mold Temperature	104 - 140	°F

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