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Processing Guidelines

Material: *Polystyrene (High Impact, Crystal)*

GENERAL INJECTION MOLDING PROCESSING GUIDELINES

Property	Data	Units
Drying Temperature	180	°F
Drying Time	2.0	hr
Injection Pressure	700 - 1000	psi
Holding Pressure	570 - 860	psi
Back Pressure	70 - 210	psi
Suggested Max Regrind	25	%
Middle Temperature	350 - 375	°F
Mold Temperature	86 - 140	°F
Nozzle Temperature	355 - 375	°F
Rear Temperature	320	°F

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