

**Typical Injection Molding Parameters**

	Alcryn[®] 2000 & 2300 Series	Alcryn[®] 2100 Series
Injection Pressure	800 - 1200 psi	500 - 800 psi
Injection Speed (fill rate)	1 - 3 cu. in./sec.	2 - 4 cu. in./sec.
Injection Time (1st stage/boost)	0.5 - 2 sec.	1 - 3 sec.
Second Stage Pressure	300 - 600 psi	100 - 400 psi
Second Stage Time	3 - 10 sec.	3 - 10 sec.
Cooling Time	5 - 15 sec.	10 - 25 sec.
Screw Speed	50 - 100 rpm	25 - 75 rpm
Back Pressure	60 - 100%	20 - 50%
Mold Temperature	70°F	110°F

Temperature Profile Barrel

Rear	330°F - 350°F (166°C to 177°C)	260° F - 310°F (127°C to 154°C)
Middle	330°F - 370°F (166°C to 188°C)	290°F - 320°F (143°C to 160°C)
Front	340°F - 370°F (171°C to 188°C)	300°F - 340°F (149°C to 171°C)
Nozzle	350°F - 370°F (177°C to 188°C)	320°F - 340°F (160°C to 171°C)
Mold	70°F - 100°F (21°C to 38°C)	80°F - 120°F (27°C to 49°C)

* NOTE: Shrinkage values and snake flow to follow.

For more information on Alcryn[®]:

Ferro Corporation
Advanced Polymer Alloys
400 A Maple Avenue
Carpentersville, IL 60110

Toll Free (888) 663-6005

Telephone: (847) 836-8119
Fax: (847) 836-8137

Internet/World Wide Web: <http://www.APAinfo.com>

The information contained in this data sheet has been determined through the application of accepted engineering practice and is believed to be reliable. Since the conditions of application and use of our products are beyond our control, no warranty is expressed or implied regarding accuracy of this information, the results to be obtained from the use of the product, so that such use will not infringe on any patent. This information is furnished with the express condition that you will make your own tests to determine the suitability of the product for your particular use.