

Injection Molding

1. Predrying

In order to obtain good moldings with Multilon, it is necessary to predry the polymer under the conditions listed below. This will also allow one to avoid problems with deterioration in physical properties, foaming and silver streaking caused by hydrolysis. In case the drying time exceeds 8 hours, lower the temperature of the drying machine and hopper dryer to 100°C for standard grades and automobile grades, and to 80°C for TN-3800 and DN-3500 grades, to avoid discoloration.

2. Injection Molding

It is recommended that the shot capacity of the injection molding machine be about 1.5-3 times the weight of the molded product. It is also recommended that molding be performed according to the molding conditions as described in the table below. Upon setting the molding conditions, start from a low injection speed. A high injection speed from the start causes the resin to flow through narrow areas such as the nozzle and gates at a high speed, resulting in material burns due to shear heat or gas burns at the weld area.

■ Molding conditions of Multilon

Grades	Conditions	Predrying		Molding Temp.	Mold Temp.	Injection Pressure
		Temp.	Time			
T-3011 T-3714		110°C	4~8h	230~260°C	50~70°C	59~118 MPa
RN-3130BK		110°C	4~8h	240~270°C	60~80°C	59~118 MPa
T-2711		110°C	4~8h	240~270°C	50~70°C	59~118 MPa
TN-3811VW TN-3813BW	TN-3812BW	100°C	4~8h	230~270°C	50~70°C	59~118 MPa
DN-3510F DN-3520F		100°C	4~8h	260~280°C	60~80°C	59~147 MPa