

Injection molding

● Molding condition

Standard injection molding conditions of Panlite are shown in the following tables.

● Flow characteristics

Since flowability of Panlite is greatly influenced by the grade, wall thickness of product, resin temperature, injection pressure, etc., attention should be paid in designing products to the spiral flow and bar flow lengths (Fig. 47 and 48).

Table of Standard injection conditions

Predrying		120°C×5 hours or more. Ensure thorough drying to reduce the moisture content to 0.02% or below
Injection molding machine		Select a molding machine with a shot capacity of 1.5-3 times as that of the weight of the molded product.
Molding condition	Molding temperature	270-320°C
	Mold temperature	80-120°C
	Screw revolution	40-100rpm
	Injection speed	medium - high
	Injection pressure	98.1MPa - 147.1MPa
	Back pressure	10MPa or less

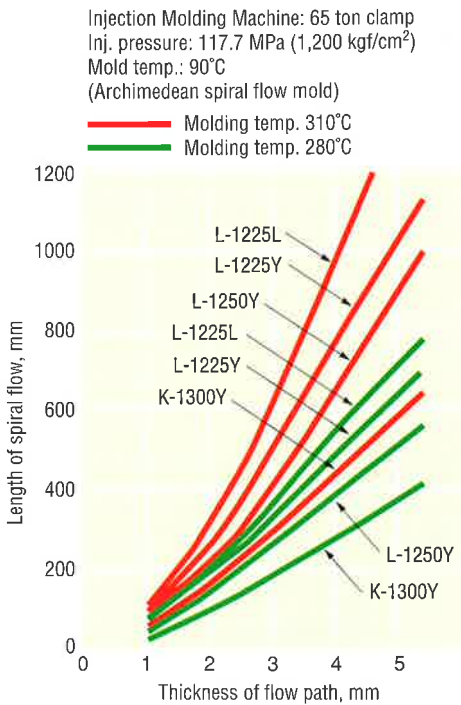


Fig. 47-1 Flowability (Spiral Flow) of Panlite (Thickness of flow path 1-5mm)

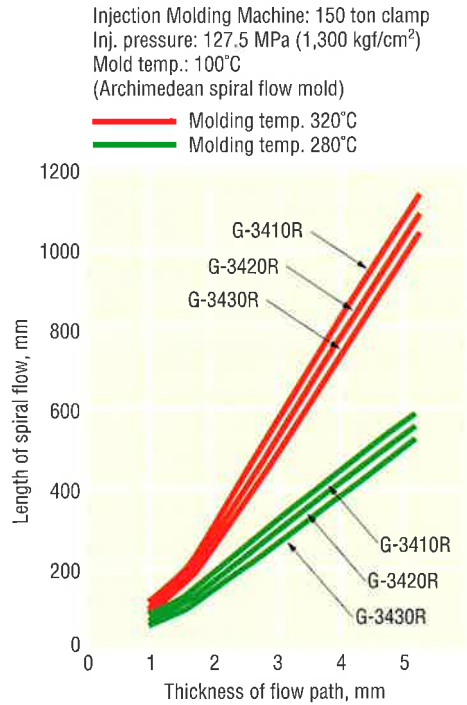


Fig. 48-1 Flowability (Spiral Flow) of Panlite G (Thickness of flow path 1-5mm)

