

MW-1 Molding Conditions

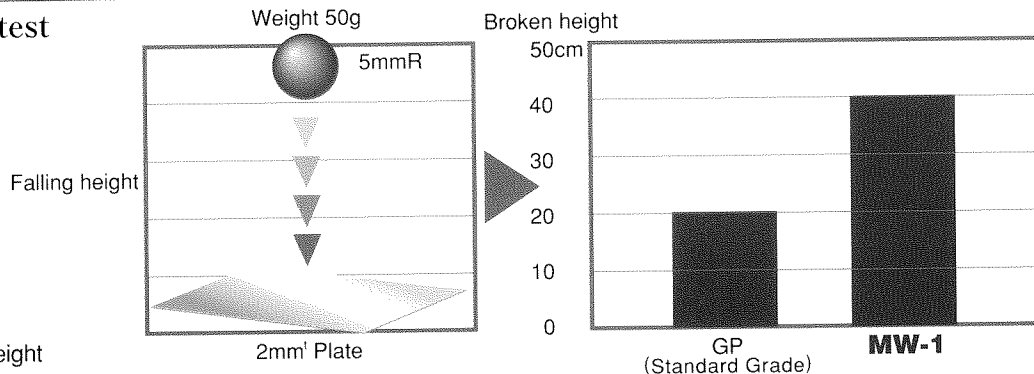
Typical molding conditions for MW-1 are listed below table.

Molding temperature should be controlled below 280°C in order to avoid the decomposition of resin.

When mold temperature is too low, an increase in residual strain is seen, which may cause loss of strength in mold areas or create layers near mold gates.

Injection Molding	Inline Screw Type
Cylinder Temperature	H-1 190-210°C
	H-2 200-230°C
	H-3 210-240°C
Nozzle Temperature	210-240°C
Mold Temperature	38-60°C
Back Pressure	1,000-4,000psi
Injection Pressure	5,000-30,000psi
Pre-drying	no need to dry resin

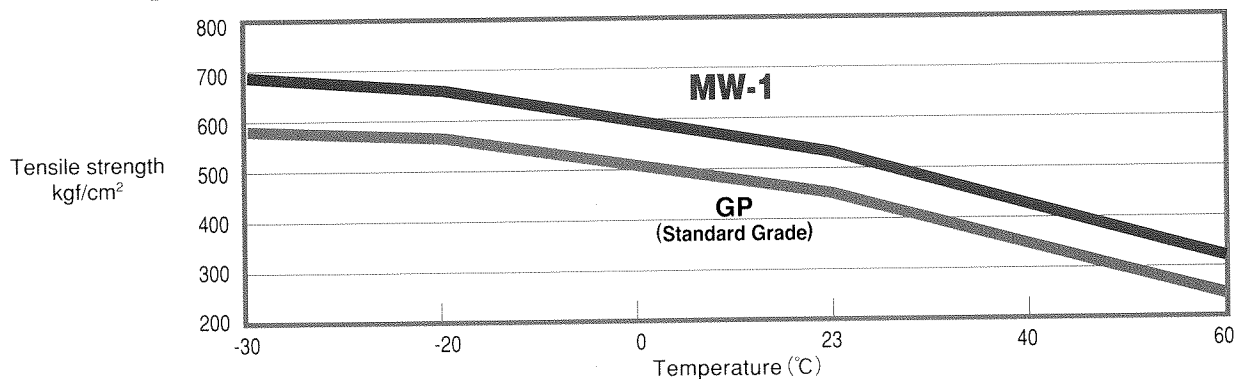
Falling weight test



*Definition of falling height

● The height from which a weight is dropped and cracks occur.

Relationship between tensile strength and temperature



Relationship between flexural strength and temperature

