



Quality Reinforced and Custom Colored Engineering Plastics  
 1240 E. Glenwood Place ~ Santa Ana, CA 92707  
 (714) 546-4667 ~ FAX (714) 546-0401

# PROCESSING GUIDE

**MATERIAL: MN66-FG10**

<b>PRE-PROCESS</b>	<b>DATA</b>	<b>UNITS</b>
DRYING TEMPERATURE	175	F
DRYING TIME	2-4 <sup>1</sup>	hours
MAX MOISTURE IN PROCESS	0.20	%
DRYER DEWPOINT	0	F
SUGGESTED SHOT SIZE	50-80	%
<b>THERMAL</b>		
REAR TEMPERATURE	510-550	F
MIDDLE TEMPERATURE	510-560	F
FRONT TEMPERATURE	520-560	F
NOZZLE TEMPERATURE	530-560	F
PROCESSING (MELT) TEMPERATURE	510-570	F
MOLD TEMPERATURE	150-225	F
<b>MECHANICAL</b>		
INJECTION PRESSURE	10,000-17,000	psi
INJECTION RATE	MODERATE	
BACK PRESSURE	50-70	psi
SCREW SPEED	50-70	rpm
CLAMP TONNAGE		tons/square inch
SCREW L/D RATIO	--	
SCREW COMPRESSION RATIO	--	

<sup>1</sup> DESSICANT TYPE DRYER REQUIRED FOR THESE DRYING PARAMETERS. ALWAYS CHECK MOISTURE CONTENT BEFORE PROCESSING.