



Quality Reinforced and Custom Colored Engineering Plastics
 1240 E. Glenwood Place ~ Santa Ana, CA 92707
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PROCESSING GUIDE

MATERIAL: MN66-FG40

PRE-PROCESS	DATA	UNITS
DRYING TEMPERATURE	175	F
DRYING TIME	2-4 ¹	hours
MAX MOISTURE IN PROCESS	0.20	%
DRYER DEWPOINT	0	F
SUGGESTED SHOT SIZE	50-80	%
THERMAL		
REAR TEMPERATURE	530-570	F
MIDDLE TEMPERATURE	530-580	F
FRONT TEMPERATURE	530-580	F
NOZZLE TEMPERATURE	540-580	F
PROCESSING (MELT) TEMPERATURE	530-580	F
MOLD TEMPERATURE	150-225	F
MECHANICAL		
INJECTION PRESSURE	10,000-17,000	psi
INJECTION RATE	MODERATE	
BACK PRESSURE	50-100	psi
SCREW SPEED	50-100	rpm
CLAMP TONNAGE		tons/square inch
SCREW L/D RATIO	--	
SCREW COMPRESSION RATIO	--	

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