

## Typical Injection Molding Conditions

Molding conditions are affected by type and capacity of molding machine, shape and weight of molding products, and/or structure of mold. Typical injection molding conditions of each grade of SUMIPEX® are recommended below.

Grade		LG/LG2	MH	MGSS	HT55X/HT01X
Pre-drying Conditions	Temp. °C	70 - 80	80 - 90	80 - 85	80 - 85
	Time hr	4 - 6	4 - 6	4 - 6	4 - 6
Barrel Temp.	Front °C	225 - 245	240 - 260	220 - 235	240 - 260
	Middle °C	220 - 240	230 - 260	215 - 225	230 - 245
	Back °C	210 - 220	220	210	220
Mold Temp.	°C	60 - 85			
Injection Pressure	MPa	140 - 160			
Hold Pressure	MPa	20 - 100	20 - 80		
Back Pressure	gage MPa	1.1 - 1.4	0.9 - 1.4		
Screw Speed	rpm	30 - 70	40 - 60		
Cooling Time	sec.	20 - 60			

<Note> Typical Injection Molding Conditions of other HT grade will be provided upon request

## Typical Annealing Conditions

To reduce internal stress which may lead to crazing, please refer to the table below for annealing conditions.

Grade	EX/MH/MGSS/HT/55X/HT01X	LG/LG2
Temp. °C	75-85	60-80
Time hr	4	4

## Typical Extrusion Molding Conditions

Please refer to the table below for typical extrusion molding conditions.

Item		MH/EX/HT55X/HT01X
Screw L/D		30-35
Cylinder Temperature °C	Hopper Side	200-210
	Center Side	230-240
	Die Side	240-245
Die Temperature °C		235-245