

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