

Injection Moulding Processing Guide for Perflex TPE GP series

Processing Temperature

| Temperatures | VALUE(Metic) |
|------------------|--------------|
| 1st Zone-Rear | 185-190 °C |
| 2nd Zone-Center | 195-200 °C |
| 3rd Zone-Front | 200-215 °C |
| 4th Zone-Nozzle | 190-200 °C |
| Mold Temperature | 30-40 °C |

Pressure, Velocity, Recovery, Timers

| Pressure | VALUE(Metic) |
|-----------------|----------------------------|
| 1st Stage-Boost | 50-100 kg/ cm ² |
| 2nd Stage-Hold | 25-50 % of Boost |
| Back Pressure | 5-10 kg/ cm ² |

Velocity

| | |
|--------------------|-------------------|
| Injection Velocity | Fast 30-80 mm/sec |
|--------------------|-------------------|

Recovery

| | |
|-------------|------------|
| Screw Speed | 75-125 RPM |
|-------------|------------|

Timers

| | |
|-----------------------|----------|
| Hold Time(Thick part) | 4-10 sec |
| Hold Time(Thin part) | 1-3 sec |

Drying

| | |
|--------------------|---------|
| Drying Temperature | 50-60°C |
| Drying Time | 1-2 hrs |

Purging

Purge thoroughly before and after use of this product with a low flow (0.5-3 MFR) polypropylene(PP) or polyethylene(PE)

Coloring

Color concentrates with polypropylene (PP), ethylene Vinyl acetate (EVA), or low density polyethylene (LDPE) Carries are most suitable for coloring, concentrates based on PVC should not be used. The final determination of color concentrate be determined by the customer.

Regrind

Regrind levels up to 20% can be used with minimal property loss, provided that the regrind is free of contamination.

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