

## Injection Moulding Processing Guide for Perflex TPE SA-(A) series

### Processing Temperature

Temperatures	VALUE(Metic)
1st Zone-Rear	185-195 °C
2nd Zone-Center	200-205 °C
3rd Zone-Front	210-220 °C
4th Zone-Nozzle	205-215 °C
Mold Temperature	40-50 °C

### Pressure, Velocity, Recovery, Timers

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

#### Velocity

Injection Velocity	Fast 30-80 mm/sec
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#### Recovery

Screw Speed	75-125 RPM
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#### Timers

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

### Drying

Drying Temperature	60-70°C
Drying Time	2-3 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.

CP Chemie Resources (Malaysia) Sdn Bhd

URL: [www.cpchemie.com](http://www.cpchemie.com)

Email: [info@cpchemie.com](mailto:info@cpchemie.com)

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