

Injection Moulding Processing Guide for Perflex TPE SA-(B) 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	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

Email: info@cpchemie.com

All Information supplied by or on behalf of CP Chemie Resources (M) Sdn Bhd in relationship to its product, whether in nature of data, recommendations or otherwise, is supported by research and believed reliable, but the Company assume no liability whatsoever in respect of application, processing or use made of the aforementioned information and products, or any consequence thereof. This data provided shall not absolve the customer of the responsibility to make test for his intended purpose or process. Therefore, the Company makes no warranties and assumes no liability in connection with any use of this data.