



Document Process Data for Injection Moulding
Description PPGF
Application Injection Moulding

Structure	Semicrystalline
Density	0.97 – 1.26 g/cm ³ (10-40% filled)
General Properties	Hard, good reliance. High stiffness. Low hygroscopicity and good thermal stability.
Barell Temperature	(decrease 15°C for flame retardant grades)
	Feed Zone 30 – 50 °C
	Zone 1 160 – 240 °C
	Zone 2 210 – 250 °C
	Zone 3 230 – 250 °C
	Zone 4 230 – 250 °C
	Zone 5 230 – 250 °C
	Nozzle 230 – 250 °C
Melt temperature	230 – 250 °C
Mould temperature	20 – 70 °C
Injection pressure	800 – 1400 bar
Post-pressure	Between 30 and 60% of injection pressure, high post-pressure time
Counterpressure	50 – 200 bar
Injection speed	Medium
Screw speed	Equal to peripheric speed of 1.3 m/s
Metering	0.5 – 4.0 diameters
Cushion	2 – 8 mm, depends on metering and screw diameter
Drying	Not necessary. 1 hour at 70°C if stored in humid place.
Recycle	30% of regrinded material. This percentage decreases for technical and aesthetic parts.
Shrinkage	0.3 – 0.7% (for unfilled product)
Barrel equipment	Standard screw, non-return valve, free-flow nozzle
Quenching	Not necessary to purge with other materials. Purge with natural product suggested after flame retardant processing.