

# INJECTION GUIDELINE

	MATERIAL	TEMPERATURE (°C)	INJ. PRESSURE (Mpa)	INJ. SPEED	HOLD PRESSURE (Mpa)	BACK PRESSURE	MOULD TEMP. (°C)	DRYING TEMP. (°C)	DRYING TIME (HOURS)
PA 6	UNREINFORCED	220-275	70-120	LOW	60-100	LOW	60-90	80-85	4
	REINFORCED	220-275	70-120	MEDIUM	60-100	LOW	90-110	80-85	4
	IMPACT MODIFIED	225-265	70-120	LOW	60-100	LOW	60-90	80-85	4
	FLAME RET.	240-295	70-120	HIGH	60-100	LOW	90-110	80-85	4
PA 6.6	UNREINFORCED	260-295	70-120	LOW	60-100	LOW	60-90	80-85	4
	REINFORCED	270-295	70-120	MEDIUM	60-100	LOW	90-110	80-85	4
	IMPACT MODIFIED	260-285	70-120	LOW	60-100	LOW	60-90	80-85	4
	FLAME RET.	260-285	70-120	HIGH	60-100	LOW	90-110	80-85	4
PPA	HT00	300-330	100-130	MEDIUM	100-120	LOW	110-140	100-120	4-6
	HT01	300-330	100-130	MEDIUM	100-120	LOW	110-140	100-120	4-6
	HT02	300-330	100-130	MEDIUM	80-100	LOW	110-140	100-120	4-6
	HT03	265-300	100-130	MEDIUM	80-100	LOW	110-140	100-120	4-6
PA / ABS	UNREINFORCED	230-260	50-90	LOW	70-90	LOW	60-80	80-100	2-4
	REINFORCED	240-260	50-90	MEDIUM	70-90	LOW	80-100	80-100	2-4
	IMPACT MODIFIED	230-250	50-90	LOW	70-90	LOW	60-80	80-100	2-4
	FLAME RET.	240-260	50-90	HIGH	70-90	LOW	80-100	80-100	2-4
PBT / PET	UNREINFORCED	230-260	70-100	LOW	80-100	LOW	70-90	120-130	4
	REINFORCED	235-270	70-100	MEDIUM	80-100	LOW	80-100	120-130	4
	IMPACT MODIFIED	220-255	70-100	LOW	80-100	LOW	70-90	120-130	4
	FLAME RET.	220-260	70-100	HIGH	80-100	LOW	80-100	120-130	4
PET	UNREINFORCED	260-295	70-100	LOW	80-100	LOW	60-90	120-130	4
	REINFORCED	270-295	70-100	MEDIUM	80-100	LOW	70-100	120-130	4
	IMPACT MODIFIED	260-285	70-100	LOW	80-100	LOW	60-90	120-130	4
	FLAME RET.	260-285	70-100	HIGH	80-100	LOW	70-100	120-130	4
PBT / ASA	UNREINFORCED	230-260	70-100	LOW	70-90	LOW	70-90	120-140	2-4
	REINFORCED	235-270	70-100	MEDIUM	70-90	LOW	70-90	120-140	2-4
	IMPACT MODIFIED	220-255	70-100	LOW	70-90	LOW	70-90	120-140	2-4
	FLAME RET.	220-260	70-100	HIGH	70-90	LOW	70-90	120-140	2-4
PBT	UNREINFORCED	230-260	70-100	LOW	80-100	LOW	70-90	120-140	2-4
	REINFORCED	235-270	70-100	MEDIUM	80-100	LOW	80-100	120-140	2-4
	IMPACT MODIFIED	220-255	70-100	LOW	80-100	LOW	70-90	120-140	2-4
	FLAME RET.	220-260	70-100	HIGH	80-100	LOW	80-100	120-140	2-4