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Processing Guidelines

Material: *Acrylonitrile Butadiene Styrene*

GENERAL INJECTION MOLDING PROCESSING GUIDELINES

Property	Data	Units
Clamp Tonnage	2.0-3.0	tons/in ²
Drying Temperature	180 - 200	°F
Drying Time	2.00 - 4.00	hr
Drying Time, Maximum	8.0	hr
Injection Pressure	10000 - 12000	psi
Suggested Max Moisture	0.10	%
Suggested Max Regrind	20.0	%
Rear Temperature	370 - 410	°F
Middle Temperature	400 - 460	°F
Front Temperature	420 - 460	°F
Mold Temperature	120 - 160	°F
Nozzle Temperature	425 - 500	°F
Processing (Melt) Temp	425 - 500	°F
Screw Compression Ratio	2.0:1.0 to 3.0:1.0	
Screw L/D Ratio	20.0:1.0	
Screw Speed	30 - 60	rpm

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