

Processing Condition of SAN335

INJECTION MOLDING		
Mold Temperature	degree C (F)	40 – 70 (104 – 158)
Melt Temperature	degree C (F)	200 – 230 (390 – 450)
Nozzle	degree C (F)	200 – 230 (390 – 450)
Front	degree C (F)	200 – 230 (390 – 450)
Middle	degree C (F)	190 – 215 (370 – 420)
Rear	degree C (F)	180 – 200 (360 – 390)
Screw Speed	rpm	40 – 80
Back Pressure	Kg/cm² (psi)	5 – 15 (70 – 210)
Suck Back	mm (inch)	3 – 5 (0.118 – 0.197)
Drying Temperature	degree C (F)	80 – 90 (175 – 195)
Drying Time	h	2 – 4
Moisture Content, max	%	0.04%