

<DENKA STYROL GPPS Processing Conditions>

Injection Molding

Injection Molding		Set Conditions
Cylinder Temperature	Rear section (hopper side)	190-210 °C
	Center section	200-240 °C
	Front section	210-255 °C
Nozzle Temperature		210-265 °C
Mold Temperature		30-65 °C
Pre-Drying		no need to dry resin

The decomposition temperature of GPPS is 290 °C.
Therefore, please set cylinders temperature below to 270 °C.

Sheet Extrusion

Sheet Extrusion		Set Conditions
Cylinder temperature(°C)	Zone1 (hopper side)	170-200 °C
	Zone2	190-220 °C
	Zone3	220-240 °C
	Zone4	210-240 °C
	Zone5	210-240 °C
	Zone6 (die side)	210-240 °C
Adapter temperature(°C)		210-240 °C
Dies temperature(°C)		220-250 °C
Pre-Drying		no need to dry resin

The decomposition temperature of GPPS is 290 °C.
Therefore, please set cylinders temperature below to 270 °C.

*Data presented in this catalogue are typical values and are intended to serve as guide only.

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