PermaFlex® 45 PROCESSING GUIDE **RAUH** Polymers, Inc. DRYING DRYING = Desecant Dryer @ 170° - 180° F (77°-82° C) for 2 - 4 Hours to achieve .02% Moisture TYPICAL INJECTION MOLDING CONDITIONS REAR 350 - 360° F Injection Pressure 16,000 - 20,000 PSI MIDDLE 370 - 380° F Hold pressure 10,000 - 13,000 PSI **FRONT** 380 - 390° F Back Pressure 17%

Note: This material is processable from 340° F to 420° F without degredation - giving much wider process windows than other material, some experimentation may be necessary to optimize production.

Screw Speed Medium

Injection Speed Medium

395 - 410° F

380 - 420° F

70 - 90° F

NOZZLE

MELT TEMPERATURE

MOLD TEMPERATURE

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DRYING		
DRYING = Desecant Dryer @ 170° - 180° F (77°-82° C) for 2 - 4 Hours to achieve .02% Moisture		
TYPICAL INJECTION MOLDING CONDITIONS		
REAR	400 - 410° F	Injection Pressure 12,000 - 13,000 PSI
MIDDLE	440 - 450° F	Hold pressure 10,000 - 11,000 PSI
FRONT	440 - 450° F	Back Pressure 0 - 400 PSI
NOZZLE	450 - 460° F	Screw Speed Medium
MELT TEMPERATURE	450 - 510° F	Injection Speed Medium
MOLD TEMPERATURE	130 - 150° F	
Note: This material is processable from 390° E to 520° E without degredation - giving much wider process		

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DRYING = Desecant Dryer @ 170° - 180° F (77°-82° C) for 2 - 4 Hours to achieve .02% Moisture		
TYPICAL INJECTION MOLDING CONDITIONS		
REAR	410 - 420° F	Injection Pressure 13,000 - 14,000 PSI
MIDDLE	430 - 440° F	Hold pressure 10,000 - 11,000 PSI
FRONT	440 - 450° F	Back Pressure 17%
NOZZLE	460 - 470° F	Screw Speed Medium
MELT TEMPERATURE	470° F	Injection Speed Medium
MOLD TEMPERATURE	130 - 150° F	

Note: This material is processable from 390° F to 500° F without degredation - giving much wider process windows than other material, some experimentation may be necessary to optimize production.

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REAR	350 - 360° F	Injection Pressure 16,000 - 20,000 PSI
REAR MIDDLE	350 - 360° F 370 - 380° F	Injection Pressure 16,000 - 20,000 PSI Hold pressure 10,000 - 13,000 PSI
REAR MIDDLE FRONT	350 - 360° F 370 - 380° F 380 - 390° F	Injection Pressure 16,000 - 20,000 PSI Hold pressure 10,000 - 13,000 PSI Back Pressure 17%

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DRYING = Desecant Dryer @ 170° - 180° F (77°-82° C) for 2 - 4 Hours to achieve .02% Moisture

TYPICAL INJECTION MOLDING CONDITIONS		
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