

RAUH Polymers, Inc.		PermaFlex® 45 PROCESSING GUIDE
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%
NOZZLE	395 - 410° F	Screw Speed Medium
MELT TEMPERATURE	380 - 420° F	Injection Speed Medium
MOLD TEMPERATURE	70 - 90° F	
Note: This material is processable from 340° F to 420° F without degradation - giving much wider process windows than other material, some experimentation may be necessary to optimize production.		

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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° F to 520° F without degradation - giving much wider process windows than other material, some experimentation may be necessary to optimize production.		

RAUH Polymers, Inc.		PermaFlex® 75 PROCESSING GUIDE
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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 degradation - giving much wider process windows than other material, some experimentation may be necessary to optimize production.		

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