

Guide to Molding

EcoLene™ PP8004-BK1

20% Glass-Reinforced Polypropylene Resin (Homopolymer)

Screw Machine	°F	°C
Rear Zone	420 - 470	216 - 243
Middle Zone	420 - 470	216 - 243
Front Zone	430 - 480	221 - 249
Nozzle Temp	430 - 480	221 - 249
Mold Temp	90 - 150	33 - 66
Injection Pressure	10,000 – 15,000 PSI	69 – 103 MPa
Back Pressure	50 - 150 PSI	0.34 – 1.03 MPa
Screw RPM	30 – 100 RPM	30 – 100 RPM

DRYING

EcoLene™ polypropylene resins shipped in bags are ready to mold with moisture content below 0.15% .

Material drying is typically not required, but for some thin walled parts, drying may be required. If needed, dry at 160°F for 1 to 3 hours and check moisture level before molding. When drying **EcoLene™** polypropylene resins, circulating air ovens fitted with effective desiccant dehumidifying units, or vacuum ovens, are best.

For further technical information please go to www.wellmaner.com or call 1 800 821-6022.