



ALLOY EXCHANGE

RECYCLING... FOR OUR FUTURE

Suggested Machine Conditions For Injection Molding Of ABS/PC Reprocessed Pellets

Rear Zone ¹	450°-490°F (232°-254°C)
Middle Zone ¹	460°-500°F (238°-260°C)
Front Zone ¹	470°-510°F (243°-266°C)
Nozzle ¹	480°-520°F (249°-271°C)
Melt	500°-545°F (260°-285°C)
Mold ²	(Surface Temperature) 140°-200°F (60°-93°C)
Back Pressure	50-100 psi
Resin Drying.....	2-3 hours at 180°F (82°C)

¹ The barrel and nozzle temperatures should be set to achieve the recommended mold temperatures.

² Mold temperatures reflect the skin temperature of the mold and not the actual mold temperature settings.

NOTE: For functional parts it is critical to mold at the optimum temperatures.
Material should be dried prior to molding.