



PROCESSING GUIDE

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4PET® Polyethylene Terephthalate (PET)

PROCESSING CONDITIONS

	Unreinforced	Impact Modified	Reinforced	Flame Retardant
Drying (°C/Hour)	-	120-140/4	120-140/2-4	120-140/2-4
Maximum Moisture Content (%)	-	0.02	0.02	0.02
Feed Throat Temperature (°C)	-	50 - 70	50 - 70	50 - 70
Processing Temperature (°C)	-	260 - 280	270 - 290	260 - 280
Mould Temperature (°C)	-	90 - 140	90 - 140	90 - 140
Hold Pressure (MPa)	-	60 - 100	60 - 100	60 - 100
Back Pressure	-	Low	Low	Low
Injection Speed	-	Medium - Fast	Fast	Medium - Fast
Maximum Screw Speed (rpm)	-	200	200	200

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Test Values: Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/ die, the processing conditions and the colouring.