



PROCESSING GUIDE

Page : 1 / 1
Revision : 001
Rev. Date : Sept 2014

4TECH[®] Polyphenylene Oxide/Polystyrene (PPO)

PROCESSING CONDITIONS

	High Flow	General Purpose	High Heat
Drying (°C/Hour)	70 - 90/2 - 3	70 - 90/2 - 3	70 - 90/2 - 3
Maximum Moisture Content (%)	0.02	0.02	0.02
Feed Throat Temperature (°C)	60 - 80	60 - 80	60 - 80
Processing Temperature (°C)	240 - 260	270 - 300	270 - 330
Mould Temperature (°C)	60 - 80	80 - 120	80 - 120
Hold Pressure (MPa)	60 - 120	60 - 120	60 - 120
Back Pressure	Low	Low	Low
Injection Speed	Medium - Fast	Low - Medium	Fast
Maximum Screw Speed (rpm)	250	250	250

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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.