



## PROCESSING GUIDE

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### 4TECH<sup>®</sup> Polyetherimide (PEI)

PROCESSING CONDITIONS		
	Unfilled	Reinforced
<b>Drying (°C/Hour)</b>	150 / 4 - 6	150 / 4 - 6
<b>Maximum Moisture Content (%)</b>	0.02	0.02
<b>Feed Throat Temperature (°C)</b>	60 - 80	60 - 80
<b>Processing Temperature (°C)</b>	350 - 400	350 - 400
<b>Mould Temperature (°C)</b>	135 - 165	135 - 165
<b>Hold Pressure (MPa)</b>	50 - 70	50 - 70
<b>Back Pressure</b>	Low	Low
<b>Injection Speed</b>	Medium - Fast	Medium - Fast
<b>Maximum Screw Speed (rpm)</b>	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.