



1. Predrying

In order to obtain good moldings with Multilon, it is necessary to predry the polymer under the conditions listed below. These conditions will allow to avoid problems with deterioration in physical properties, foaming and silver streaking caused by hydrolysis. If the drying time exceeds 8 hours, reduce the temperatures of drying machine and hopper dryer to 10°C Lower than those shown in the following condition table, to avoid discoloration of pellet.

2. Injection Molding

It is recommended that the shot capacity of the injection molding machine be about 1.5-3 times the weight of the molded product. It is also recommended that molding be performed according to the molding conditions as described in the table below. Upon setting the molding conditions, start from a low injection speed. A high injection speed from the start causes the resin to flow through narrow areas such as the nozzle and gates at a high speed, resulting in material burns from shear heat or gas burns at the weld area.

■ Multilon standard molding conditions

Grades	Conditions	Predrying		Molding temperature	Mold temperature	Injection pressure
		Temp.	Time			
T-3750 T-3615Q	TN-3616Q	110°C	4~8h	230~260°C	50~70°C	59~147MPa
TN-7000 TN-7570Z TN-3713B	TN-3715B	80°C	5~8h	230~270°C	50~70°C	59~147MPa
TN-7295		100°C	4~8h	230~290°C	50~80°C	59~147MPa
TN-7500		80°C	5~8h	230~270°C	50~60°C	59~147MPa
TN-7504		80°C	5~8h	230~270°C	40~60°C	59~147MPa
DN-7730M RN-7740M		100°C	4~8h	240~280°C	50~80°C	59~147MPa
T-2711J T-2754 T-2810R T-2850R MK-1000A R-2010 R-2030	T-2716 T-2760B T-2830R MK-2055 R-2020	110°C	4~8h	240~270°C	50~70°C	59~147MPa