

Processing Molded Product

(1) Preparatory drying

To dry Teonex, if you use a box type hot air drier, make the pellet layer less than 3 cm. For drying temperature and conditions, refer to the table below. Heat the hopper to prevent the pellets from absorbing moisture. If you dry the product consecutively using the hopper, the appropriate hopper would be the one with a molding capacity of more than 4 hour. For the temperature inside the hopper, refer to the table below. (You can expect more efficient drying with dehumidifying drier).

(2) Injection molding

Choose the injection molding machine whose injection capacity is 1.5 to 3 times larger than the weight of molded product. For the appropriate cylinder temperature, mold temperature, and injection pressure, refer to the table below. Residual resin inside cylinder leads to inferior appearance and properties of final product. When you do not use the molding machine for a long time, lower the cylinder temperature to around 150 °C. Purge to remove the residual resins completely, before you restart the machine.

Items	Unit	Teonex
Molding temperature	°C	280 ~ 310
Mold temperature	°C	40 ~ 90
Injection molding pressure	MPa	60 ~ 140
Drying material temperature	°C	150 ~ 160
Drying material time	hr	5 ~ 8
Temperature inside the hopper	°C	100 ~ 120