



Suggested Machine Conditions For Injection Molding Of ABS Reprocessed Pellets

Machine Areas

Rear Zone ¹	390°-450°F (198°-232°C)
Middle Zone ¹	400°-450°F (204°-232°C)
Front Zone ¹	425°-500°F (218°-260°C)
Nozzle ¹	425°-500°F (218°-260°C)
Melt	425°-525°F (218°-274°C)
Mold ²	(Surface Temperature) 80°-150°F (27°-66°C)
Back Pressure	150-500 psi
Resin Drying.....	2 hours at 180°-200°F (82°-93°C)

¹ The barrel and nozzle temperatures should be set to achieve the recommended mold temperatures.

² Mold temperatures reflect the skin temperature of the mold and not the actual mold temperature settings.

NOTE: For functional parts it is critical to mold at the optimum temperatures.
Material should be dried prior to molding.