TYPICAL PROCESSING CONDITIONS
AAROPRENE® ATPO 3000 SERIES

1. TYPICAL INJECTION MOLDING CONDITIONS FOR TPO

TYPICAL CYLINDER TEMPERATURES ° F (°C)

MELT TEMPERATURE		**360 – 430 °F (180 –220 °C)**
BARREL TEMPERATURE - REAR		**350 – 420 °F (175 – 215 °C)**
	MIDDLE	**350 – 420 °F (175 – 215 °C)**
	FRONT	**350 – 420 °F (175 – 215 °C)**
	NOZZLE	**370 – 430 °F (185 – 220 °C)**
MOLD TEMPERATURE		**50 – 150 °F (10 – 65 °C)**
SCREW SPEED		**100 –200 RPM**
BACK PRESSURE	**10-150 PSI**	

SCREW 20:1 L/D RATIO

2. EXTRUSION CONDITIONS

MELT TEMPERAURE		**380 – 420 °F (190 – 215 °C)**
BARREL TEMPERATURE REAR		**360 – 400 °F (180 – 205 °C)**
	TRANSTION	**360 – 400 °F (180 – 205 °C)**
	METERING	**370 –410 °F (185 – 210 °C)**
	FRONT	**370 – 410 °F (185 – 210 °C)**
	DIE	**380 – 420 °F (195 – 215 °C)**
ROLL TEMPERATURE		**70 – 120 °F (21- 49 °C)**
SCREEN PACK		**20 TO 60 MESH**

SCREW 3:1 COMPRESSION RATIO