

# TYPICAL PROCESSING CONDITIONS

## AAROPRENE® ATPR 1000 SERIES

### 1. TYPICAL INJECTION MOLDING CONDITIONS FOR SBS TYPE ELASTOMERS RECIPROCATING SCREW TYPE :

#### TYPICAL CYLINDER TEMPERATURES ° F (°C)

FEED ZONE	175 (80)
CENTER ZONE	350 (175)
FRONT ZONE	380 (195)
NOZZLE	390 (200)
INJECTION PRESSURE	
( PSI )	
HIGH	700
LOW	500
INJECTION TIME	3
(SEC)	
HOLD TIME	
(SEC)	
	5
CLAMP TIME	
(SEC)	
	10
SCREW RPM	30
BACK PRESSURE	
(PSI)	
	50
CYCLE TIME	
(SEC)	
	20
INJECTION RATE	MODERATE

### 2. TYPICAL EXTRUSION CONDITIONS

TYPICAL SCREW USED FOR EXTRUSION LENGTH /DIAMETER: 24:1

LOW COMPRESSION RATIOS

DEEP FLIGHTED METERING SECTIONS

MELT TEMPERATURE 300 – 380 °F (105 –200 °C)

FEED ZONE 175 °F (80 °C)

BARREL 300°F (105°C)

DIE 380° F (190 °C)

### 3. EXTRUSION FILMS:

POLISH ROLLS

DIE PRESSURE IS LOW

MELT TEMPERATURES 325 –375 °F (160-190 °C)