

TYPICAL PROCESSING CONDITIONS AAROPRENE® ATPR 2000 & 2100 SERIES

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

TYPICAL CYLINDER TEMPERATURES ° F (°C)

FEED ZONE	175 (80)
CENTER ZONE	410 (210)
FRONT ZONE	440 (225)
NOZZLE	455 (235)

INJECTION PRESSURE

(PSI)

HIGH	700
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LOW	500
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INJECTION TIME	1
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(SEC)

HOLD TIME

(SEC)	5
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CLAMP TIME

(SEC)	7
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SCREW RPM	40
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BACK PRESSURE

(PSI)	50
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CYCLE TIME

(SEC)	15
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INJECTION RATE	FAST
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2. TYPICAL EXTRUSION CONDITIONS

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

LOW COMPRESSION RATIOS

DEEP FLIGHTED METERING SECTIONS

MELT TEMPERATURE 375 – 475 °F (190 -230°C)

FEED ZONE 175 °F (80 ° C)

BARREL 375°F (190 °)

DIE 455 °F (235 °C)

3. EXTRUSION FILMS:

POLISH ROLLS

DIE PRESSURE IS LOW

MELT TEMPERATURES 400 - 475 °F (205-245°C)