



STYROVIT®

General Purpose Polystyrene

INJECTION MOULDING PROCESSING GUIDE

PROCESSING PARAMETERS*		UNITS	POLYSTYRENE GRADE		
			104D	110B	116B
Melt volume rate MFR		g/10 min	4	10	16
Processing temperatures					
Mould		°C	40-43	40-43	40-43
Melt		°C	225-240	220-235	215-230
Nozzle		°C	225-240	220-235	210-225
Screw	Front part	°C	225	220	210
	Middle part	°C	220	215	205
	Rear part	°C	195	190	185
Processing pressures					
Injection		MPa	80-82	70-75	65-70
Holding		MPa	52-55	40-43	38-40
Cooling cycle					
		Wall thickness (mm)	Cycle time (sec.)		
		0.5	10-14		
		1.0	15-20		
		1.5	20-25		
		2.0	25-35		
		2.5	30-40		
		3.0	35-45		
		3.5	40-50		
		4.0	45-55		
		4.5	50-60		
		5.0	55-70		

(*) Typical properties, not to be construed as specification limits.

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