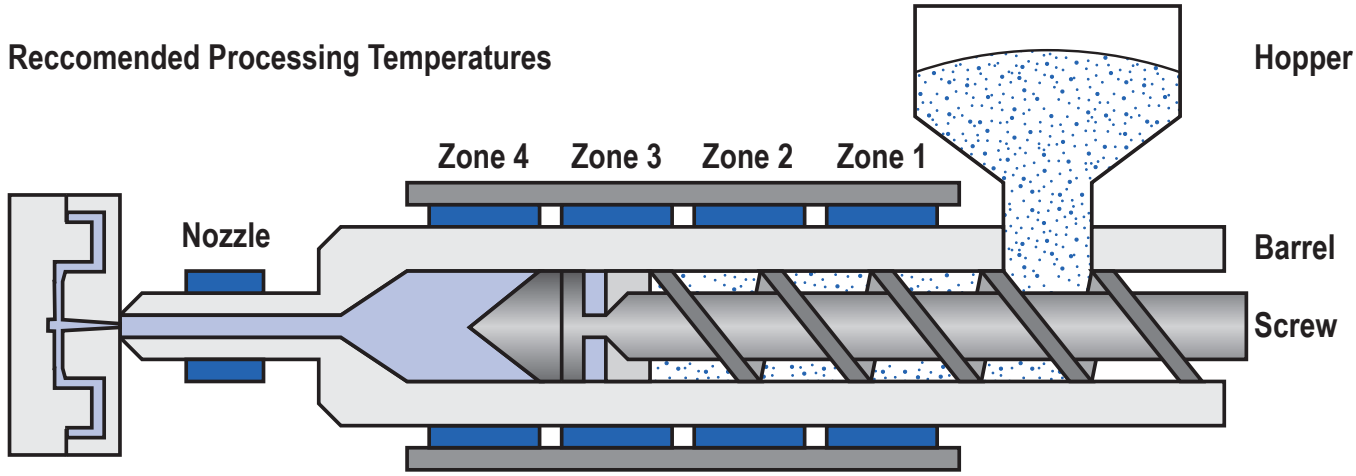
Molding Guide

ZEONOR® 1020R
Medical Grade

Property	Value	Test Standard
Density	**1.02 kg/m³**	ASTM D792
Melt flow rate (MFR) (280 ºC, 21.18 N)	**20 g/10min**	JIS K719 ISO 1133
Glass transition temperature (20 ºC/min)	**100 ºC (220 ºF)**	JIS K7121
Pre-drying		
Pre-drying time	**4-8 Hours**	
Pre-drying temperature	**80 ºC (175ºF)**	

Reccomended Processing Temperatures



T_{Mold}	T_{Nozzle}	T_4	T_3	T_2	T_1	T_{Hopper}
60-95 ºC	240-280 ºC	250-290 ºC	250-290 ºC	240-280 ºC	220-260 ºC	<70 ºC
140-195 ºF	465-535 ºF	480-555 ºF	480-555 ºF	465-535ºF	430-500 ºF	<160 ºF

Molding	
Injection Pressure	**Set as low as possible to ensure shape accuracy of molded product**
Holding Pressure	**50-150 MPa**
Back Pressure	**5-20 MPa**
Screw Rotation Speed	**20-40 rpm**
Injection Speed	**5-30 mm/s**
Residence time	**Max 15 min; lower barrel temperature to 110 ºC (230 ºF)**

Notes

- Typical shrinkage factor is 0.1-0.7% but varies depending on the molded part and molding conditions.
- A pressurized water temperature controller is recommended for mold temperature control.
- Higher mold temperatures are reccomended to increase part replication accuracy. Do not exceed the T_g of the resin.

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