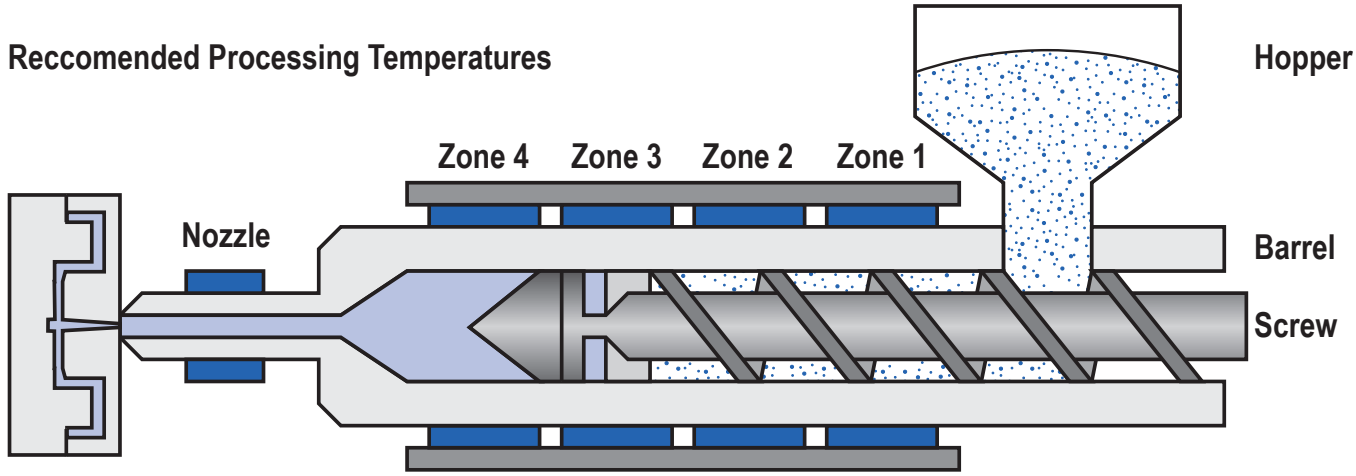
Molding Guide

ZEONEX® 360R

Optical Grade

Property	Value	Test Standard
Density	**1.03 kg/m³**	ASTM D792
Melt flow rate (MFR) (260 ºC, 21.18 N)	**18 g/10min**	JIS K719 ISO 1133
Glass transition temperature (20 ºC/min)	**122 ºC (250 ºF)**	JIS K7121
Pre-drying		
Pre-drying time	**4-8 Hours**	
Pre-drying temperature	**90 ºC (195ºF)**	

Reccomended Processing Temperatures



T_{Mold}	T_{Nozzle}	T_4	T_3	T_2	T_1	T_{Hopper}
100-110 ºC	240-260 ºC	250-270 ºC	250-270ºC	240-260 ºC	230-240 ºC	<70 ºC
210-230 ºF	465-500 ºF	480-520 ºF	480-520 ºF	465-500 ºF	445-465 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 150 ºC (300 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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