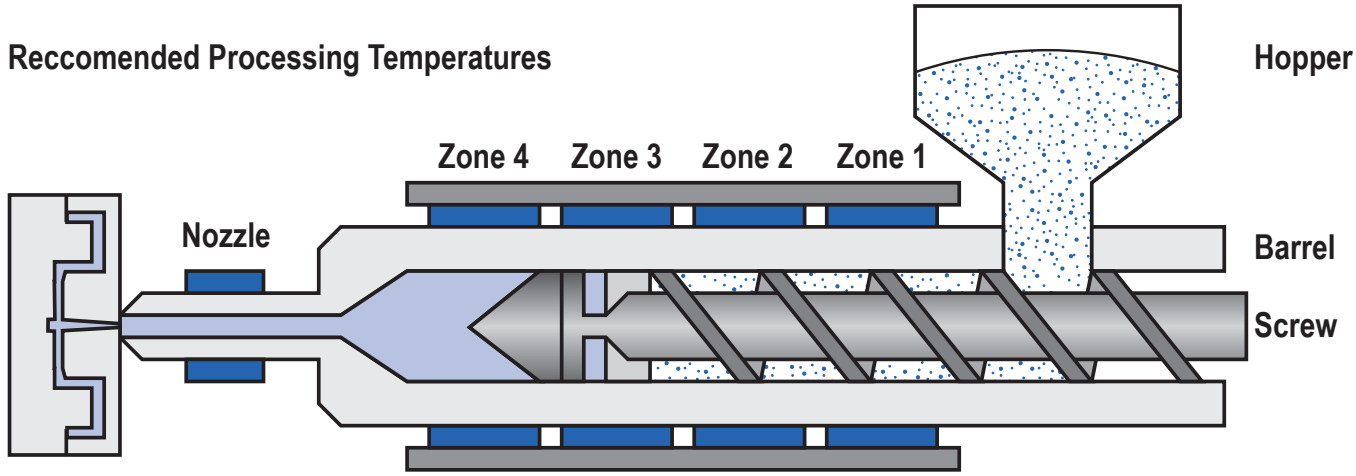
Molding Guide

ZEONEX® 690R
Medical Grade

Property	Value	Test Standard
Density	**1.02 kg/m³**	ASTM D792
Melt flow rate (MFR) (280 ºC, 21.18 N)	**17 g/10min**	JIS K719 ISO 1133
Glass transition temperature (20 ºC/min)	**136 ºC (275 ºF)**	JIS K7121
Pre-drying		
Pre-drying time	**4-8 Hours**	
Pre-drying temperature	**100 ºC (210ºF)**	

Reccomended Processing Temperatures



T_{Mold}	T_{Nozzle}	T_4	T_3	T_2	T_1	T_{Hopper}
90-135 ºC	250-290 ºC	260-300 ºC	260-300 ºC	250-290 ºC	230-270 ºC	<70 ºC
195-275 ºF	480-555 ºF	500-570 ºF	500-570 ºF	480-555 ºF	445-520 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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