



EcoLene™
ENGINEERING RESIN

Guide to Molding

EcoLene™ PP8000-BK1

Unfilled Polypropylene Resin (Homopolymer)

Screw Machine	°F	°C
Rear Zone	390 - 430	199 - 221
Middle Zone	390 - 430	199 - 221
Front Zone	400 - 440	204 - 227
Nozzle Temp	400 - 440	204 - 227
Mold Temp	90 - 120	33 - 49
Injection Pressure	10,000 – 15,000 PSI	69 – 103 MPa
Back Pressure	50 - 150 PSI	0.34 – 1.03 MPa
Screw RPM	30 – 100 RPM	30 – 100 RPM

DRYING

EcoLene™ polypropylene resins shipped in bags are ready to mold with moisture content below 0.15% .

Material drying is typically not required, but for some thin walled parts, drying may be required. If needed, dry at 160°F for 1 to 3 hours and check moisture level before molding. When drying **EcoLene™** polypropylene resins, circulating air ovens fitted with effective desiccant dehumidifying units, or vacuum ovens, are best.

For further technical information please go to www.wellmaner.com or call 1 800 821-6022.