



EcoLene™
ENGINEERING RESIN

Guide to Molding **EcoLene™ PP8004-BK1**

20% Glass-Reinforced Polypropylene Resin (Homopolymer)

| Screw Machine | °F | °C |
|---------------------------|----------------------------|------------------------|
| Rear Zone | 420 - 470 | 216 - 243 |
| Middle Zone | 420 - 470 | 216 - 243 |
| Front Zone | 430 - 480 | 221 - 249 |
| Nozzle Temp | 430 - 480 | 221 - 249 |
| Mold Temp | 90 - 150 | 33 - 66 |
| 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.