



**EcoLene™**  
**ENGINEERING RESIN**

## **Guide to Molding** **EcoLene™ PP8150-BK1**

*50% Glass-Reinforced Polypropylene Resin (Homopolymer)*

<b>Screw Machine</b>	<b>°F</b>	<b>°C</b>
<b>Rear Zone</b>	<b>420 - 470</b>	<b>216 - 243</b>
<b>Middle Zone</b>	<b>420 - 470</b>	<b>216 - 243</b>
<b>Front Zone</b>	<b>430 - 480</b>	<b>221 - 249</b>
<b>Nozzle Temp</b>	<b>430 - 480</b>	<b>221 - 249</b>
<b>Mold Temp</b>	<b>90 - 150</b>	<b>33 - 66</b>
<b>Injection Pressure</b>	<b>10,000 – 15,000 PSI</b>	<b>69 – 103 MPa</b>
<b>Back Pressure</b>	<b>50 - 150 PSI</b>	<b>0.34 – 1.03 MPa</b>
<b>Screw RPM</b>	<b>30 – 100 RPM</b>	<b>30 – 100 RPM</b>

### **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](http://www.wellmaner.com) or call 1 800 821-6022.