

Injection Molding Condition Recommendation 射出成型參數建議

PP Homopolymer & Impact Copolymer / PP 單聚合物 & 耐衝共聚合物

Melt Flow Rate 熔融流率 (g/10min)	< 2	2 - 10	10 - 25	25 - 60
Homopolymer Grade 單聚合物型號	PT181, 6733, PT100, PT101N	PC366-3, PC366-5, 6524, 6331-8,	6331-11, 6331, PD943, PT331M, 6331, 657H, 6231-20, 6560, 6570	PT231, PT231M, HP600S
Impact Copolymer Grade 耐衝共聚合物型號	7011, 7012, 7633, 7633U,	7633-3, 7533, 7533N, 749U, 7433, 7433-9	ST031	7233N, ST751, 7872
Advanced Material Grade 改性材料型號	667A	-	-	7520

Melt Flow Rate 熔融流率 (g/10min)	<u>< 2</u>	<u>2 - 10</u>	<u>10 - 25</u>	<u>25 - 60</u>
Rear Zone 料管後段 (°C)	200-220	195-215	190-205	185-195
Middle Zone 料管中段 (°C)	210-240	200-230	200-220	195-210
Front Zone 料管前段 (°C)	220-260	215-250	205-240	195-230
Nozzle 射嘴 (°C)	220-260	215-250	205-240	195-230
Injection pressure 射壓 (MPa)	4-10	4-10	4-10	4-10
Back pressure 背壓 (kg/ cm ²)	5-15	5-15	5-15	5-15
Screw speed 螺桿轉速 (rpm)	60-120	60-120	60-120	60-120
Mold temperature 模溫 (°C)	15-50	15-50	15-50	15-50

- The actual molding condition should be determined based on machine and mold situation. 實際加工條件需依照機台狀況與模具來決定。

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PP Random Copolymer / PP 無規共聚物

Melt Flow Rate 熔融流率 (g/10min)	<u>≤ 2</u>	<u>2-10</u>	<u>10-25</u>	<u>25-60</u>
Random Copolymer Grade 耐衝共聚物型號	8001, 8002, ST611, ST611M, ST611K, ST612	ST861, ST866K, ST866, STM866	ST868M, ST868K, 868H, 8681, 9580	ST757M, ST869K. ST860K
Advanced Material Grade 改性材料型號	8191	8491, 8493, 8494		8691

Melt Flow Rate 熔融流率 (g/10min)	<u>≤ 2</u>	<u>2 - 10</u>	<u>10 - 25</u>	<u>25 - 60</u>
Rear Zone 料管後段 (°C)	190-210	190-210	180-200	180-195
Middle Zone 料管中段 (°C)	200-230	200-230	190-210	190-210
Front Zone 料管前段 (°C)	210-250	205-240	195-230	190-220
Nozzle 射嘴 (°C)	210-250	205-240	195-230	190-220
Injection pressure 射壓 (MPa)	4-10	4-10	4-10	4-10
Back pressure 背壓 (kg/ cm ²)	5-15	5-15	5-15	5-15
Screw speed 螺桿轉速 (rpm)	60-120	60-120	60-120	60-120
Mold temperature 模溫 (°C)	15-50	15-50	15-50	15-50

- For grades highlighted in blue, nozzle & front zone above 210°C is required for optimal clarity. 藍色註明的型號，射嘴&前段溫度需高於 210°C，才能獲得理想透明度。
- For grades highlighted in red, which contains latest clarifying technology, nozzle & front zone just above 190°C is required for optimal clarity. 紅色註明的型號，射嘴&前段溫度高於 190°C，即可獲得理想透明度。
- The actual molding condition should be determined based on machine and mold situation. 實際加工條件需依照機台狀況與模具來決定。