

	min.	average	
Pre-drying		not required	
Melt temperature (°C)	220	250	280
		flat temperature profile or slightly hotter towards hopper	
Mould temperature (°C)	20	50	80
Back pressure (specific, not oil!) (bar)	0 (preferred)	As low as possible (e.g. 10 bar)	150 (only for specific screws)
Screw speed		As low as possible (Target: plasticizing during complete cooling and machine time)	
Injection speed		Moderate	
Holding pressure (bar)	300	50 to 80% of injection pressure or ca. 400	
Holding time t = 1.5 mm t = 2 mm t = 3 mm (s) t = 4 mm	3 6 10 20	5 10 15 25	
Cooling time (including holding) t = 1.5 mm (s) t = 2 mm t = 3 mm t = 4 mm	8 15 25 40	12 20 40 65	