



## CELLULOSE ACETATE - TYPICAL MOLDING CONDITIONS

### Barrel Temp.

Flow	MSS	MS	M	MH	H	H2
Rear	350° - 370°F	340° - 360°F	360° - 380°F	380° - 400°F	400° - 420°F	420° - 450°F
Center	350° - 370°F	340° - 360°F	360° - 380°F	380° - 400°F	400° - 420°F	420° - 450°F
Front	350° - 370°F	340° - 360°F	360° - 380°F	380° - 400°F	400° - 420°F	420° - 450°F
Nozzle (1)	370° - 390°F	360° - 380°F	380° - 400°F	390° - 410°F	410° - 430°F	430° - 450°F

### Pressures

Flow	MSS	MS	M	MH	H	H2
Injection Pressure	1100 / 950 PSIG	1200 / 1000 PSIG	1300 / 1100 PSIG	1400 / 1100 PSIG	1500 / 1200 PSIG	1600 / 1200 PSIG
Back Pressure	0-50 PSI	0-50 PSI	0-50 PSI	0-50 PSI	0-50 PSI	0-50 PSI

### Mold Temp. (2)

Flow	MSS	MS	M	MH	H	H2
Movable Half	100° - 120°F	110° - 130°F	110° - 130°F	110° - 130°F	110° - 130°F	110° - 130°F
Stationary Half	100° - 120°F	110° - 130°F	110° - 130°F	110° - 130°F	110° - 130°F	110° - 130°F

### Cycle Time

Flow	MSS	MS	M	MH	H	H2
Injection (3)	8-10 sec	8-10 sec	8-10 sec	8-10 sec	8-12 sec	8-10 sec
Booster	6-8 sec	6-8 sec	6-8 sec	6-8 sec	6-10 sec	6-10 sec
Cure (4)	40-60 sec	40-60 sec	40-60 sec	40-60 sec	40-70 sec	40-70 sec

(1) Use straight flow through or reverse nozzle. Nozzle orifice should be 1/16" smaller than sprue orifice at end of mold.

(2) Do not exceed 160° F; higher mold temperatures may be used to burn off surface plasticizer. Use thermometer to heat mold or "city water" just cracked. Never use a chiller.

(3) Injection time may be increased; depends on part thickness, part size, and number of cavities.

(4) Cure time may be cut down; it depends on part thickness, part size, and number of cavities. Also, parts should be put in warm water to reduce cure time.

(5) Drying - Material should be dried using dehumidifying hopper dryers. The dew point should be between -20° F and -40° F. The acetate should be drying at a temperature of 150° F to 170° F for 2-4 hours.