

The Processing condition of Injection & Extrusion Molding for TAIRIPRO PP resin

Item	Homo Polymer					Random Copolymer		Impact Copolymer		
	Extrusion Blow Molding	Flat Yarn	Film	Injection Molding	Multi-filament	Injection Molding	Film	Injection Molding		Extrusion & Blow Molding
Grade	T1002	S1003	F2003AR	K1108	S1803	K4015	F4002	K7005	K9010	T7002
	T1202	S1005	F2003AT	K1011	S1023	K4038	F4006	K7025	K9017	T8002
	T2502		F2003AM	K1023	S1040	K4502	F4007	K8802	K3004	B8001
	B1101		F2011	K1525	S2023	K4515	F4008	K8003	BC03ZX	
			F1611	K1035	S2123	K4535	T4002	K8003AN	K3009AN	
			F2003	K2038	S2035	K4635		K8005	K3009AU	
				K2051	S1019	K4715		K8009	KP03B	
				K2065		K4750		K8025	K3029	
				K1060		T3002		K8050	K7009AH	
				K1080		K4650		K8065	K7005AX	
			K1011AG				K9003	K7005AG		
							K7009	K7005AN		
							K8095	K9030		
Molding Shrinkage(%)	1.5~1.9	---	---	1.4~1.8	---	1.5~2.0	---	1.4~1.8		1.4~1.8
Screw Temperature(°C )	200~230	200~270	220~260	200~290	220~260	220~240	190~220	180~230		200~230
Injection Pressure (kg/cm <sup>2</sup> )	---	---	---	80~120	---	40~90	---	30~60		---
Molding Temperature(°C )	190~210	280~290	230~250	30~50	220~240	30~50	220~240	30~50		190~210
Casting Roll / Cooling water Temperature (°C )	---	30/50~60	30/30~40	---	30/50~60	---	30/30	---		---/30~50
Chilling water Temperature (°C )	---	---	12~18	---	---	---	---	---		---

Notes : Products quality from injection process depends on the following factors:

1. Wall thickness of Products
2. Mold cooling loop design
3. Mold gate and runner design