RAUH Polymers, Inc.		**OPTIMUM® 800** PROCESSING GUIDE
DRYING		
DRYING = Desecant Dryer @ 170° - 180° F (77°-82° C) for 2 - 4 Hours to achieve .02% Moisture		
TYPICAL INJECTION MOLDING CONDITIONS		
REAR	500 - 510° F	Injection Pressure 8,000 - 10,000 PSI
MIDDLE	510 - 520° F	Hold pressure 6,000-8,000 PSI
FRONT	510 - 520° F	Back Pressure 0 - 400 PSI
NOZZLE	525 - 530° F	Screw Speed Medium
MELT TEMPERATURE	450 - 510° F	Injection Speed Medium
MOLD TEMPERATURE	180 - 200° F	
Note: This material is processable from 400° F to 590° F (204 - 310° C) without degredation - giving much wider process windows than other material, some experimentation may be necessary to optimize production. Keep the feed throat water cooling off.		

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TYPICAL INJECTION MOLDING CONDITIONS		
REAR	400 - 420° F	Injection Pressure 8,000 - 10,000 PSI
MIDDLE	400 - 440° F	Hold pressure 6,000-8,000 PSI
FRONT	420 - 450° F	Back Pressure 0 - 400 PSI
NOZZLE	440 - 475° F	Screw Speed Medium
MELT TEMPERATURE	440 - 450° F	Injection Speed Medium
MOLD TEMPERATURE	70 - 100° F	
Note: This material is processable from 400° F to 590° F (204 - 310° C) without degredation - giving much wider process windows than other material; some experimentation may be necessary to optimize production.		
FOR EXTRUSION		
Set Extruder to deliver polymer @ approximately 400 deg. F		

POLISHING ROLL	DOWN STACK	UP STACK	
Top	185 - 200° F	185 - 200o F	
Middle	185 - 165° F	175 - 190o F	
Bottom	185 - 200° F	170 - 180o F	

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