



ZEON CORPORATION

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Report No. B1013EV2

Injection Blow molding condition of ZEONOR® 1020R

1. Typical Molding Condition

- Mold / Tool 100ml bottle 6 cavity mold
- Molding Machine 3 Station Injection Stretching Blow Molding Machine
SB 3-250 [Aoki Technical Laboratory, Inc](#)
- Screw diameter 54mm
- Molding Condition

Cylinder temperature	Nozzle	280 °C	536 °F
	Zone 1 (Front)	280 °C	536 °F
	Zone 2 (Middle)	278 °C	532 °F
	Zone 3 (Rear)	275 °C	527 °F
	Throat (under Hopper)	Water cooling, N2 purge	
Hot runner temperature		260 ~ 280 °C	500 ~ 536 °F
Mold temperature	Injection mold (Core side)	90 °C	194 °F
	Injection mold Cavity side	95 °C	203 °F
	Blow mold	90 °C	194 °F
Injection time		10 seconds	
Cooling time		12 seconds	
Blowing time		14 seconds	
Cycle time		37 seconds	
Stretching ration (lengthwise)		1.1 times	

2. Preparation

- **Predrying;** Air (Oxygen) dissolved in ZEONOR pellets can cause discoloration, carbide and void, ZEONOR should be dried (heated) to remove air in the pellets for 4 to 12 hours at 70°C to 80°C (158°F to 176°F) before molding. Drying too long period may cause heat deterioration and possibly discoloration in the molded articles.
- **Nitrogen purge;** Nitrogen purge is recommended in barrel throat while molding to avoid oxidative degradation!!!

Please refer to ZEONOR Injection Molding Guide for more details.

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