



ZEON CORPORATION

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Report No. B1014EV1

Extrusion Blow molding condition of ZEONOR® 1020R

1. Typical Molding Condition

- Mold / Tool 100ml, 1 cavity
- Molding Machine TB 90-45 [Suzuki Tekkojo](#)
Single Head
Blowing Way: Upper side
Screw diameter: 45mm
Dies diameter: 18mm
Nozzle diameter: 13mm

- Molding Condition

Cylinder temperature	Zone 1 (Front)	220~230 °C	428~446 °F
	Zone 2 (Middle)	220~230 °C	428~446 °F
	Zone 3 (Rear)	220~230 °C	428~446 °F
	Throat (under Hopper)	Water cooling, N2 purge	
Dice temperature	Head (Upper)	210 ~ 220 °C	410 ~ 428 °F
	Head (Lower)	210 ~ 220 °C	410 ~ 428 °F
Parison temperature	Inner layer	200 ~ 215 °C	392 ~ 419 °F
Mold temperature		110 °C	230 °F
Blowing time	10 seconds		
Evacuation time	2 seconds		
Holding time	17 seconds		
Total cycle time	25 seconds		
Blowing pressure	5.5 kg/cm2		

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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