



ZEON CORPORATION

SPECIALTY PLASTICS DIVISION

1-6-2 Marunouchi, Chiyoda-ku TOKYO, 100-8246 JAPAN

Phone: +81-3-3216-1769

FAX: +81-3-3216-2334

Report No. C1114EV1

Extrusion Blow molding condition of ZEONOR® 1420R

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)	235 °C	455 °F
	Zone 2 (Middle)	235 °C	455 °F
	Zone 3 (Rear)	230 °C	446 °F
	Throat (under Hopper)	Water cooling, N2 purge	
Dice temperature	Head (Upper)	215 °C	419 °F
	Head (Lower)	210 °C	410 °F
Parison temperature	Inner layer	205 °C	401 °F
Mold temperature		118 °C	244 °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 100°C to 105°C (212°F to 221°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.

The test results herein are believed to be accurate but are laboratory tests based on limited sampling, which do not necessarily simulate actual use conditions. NO REPRESENTATIONS, GUARANTEES OR WARRANTIES OF ANY KIND ARE MADE AND ZEON SPECIFICALLY DISCLAIMS THE IMPLIED WARRANTY OF MERCHANTABILITY AND THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE. ZEON shall not be liable for and the customer assumes all risk and liability for any use or handling of any material beyond ZEON's direct control.

A corporate brand "ZEON", a logotype "Z", "ZEONEX", and "ZEONOR" are the registered trademarks of ZEON CORPORATION.