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Report No. D1014EV1

Extrusion Blow molding condition of ZEONEX® 690R

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 ZEONEX pellets can cause discoloration, carbide and void, ZEONEX 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 ZEONEX Injection Molding Guide for more details.