



ZEON CORPORATION

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Extrusion Blow molding condition of ZEONEX[®] 790R

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)	260 °C	500 °F
	Zone 2 (Middle)	250 °C	482 °F
	Zone 3 (Rear)	240 °C	464 °F
	Throat (under Hopper)	Water cooling, N2 purge	
Dice temperature	Head (Upper)	260 °C	500 °F
	Head (Lower)	260 °C	500 °F
Parison temperature	Inner layer	250 °C	482 °F
Mold temperature		130 °C	266 °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 140°C (284°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.

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