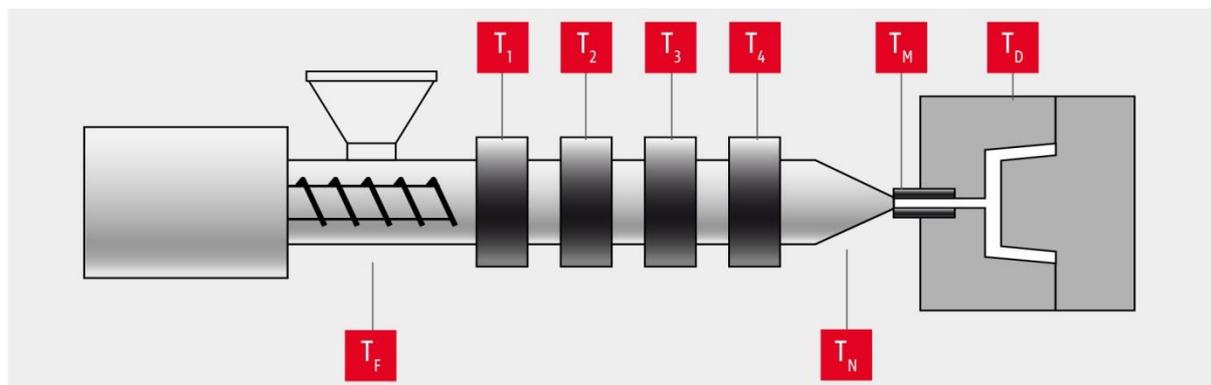


TOPAS[®] Elastomer E-140

Cyclic Olefin Copolymer

Processing Conditions for Injection Molding



Processing Temperatures

T_F	T_1	T_2	T_3	T_4	T_N	T_M	T_D
< 30 °C	270-290 °C	270-300 °C	275-300 °C	275-300 °C	275-300 °C	270-300 °C	20-30 °C
< 86 °F	518-554 °F	518-572 °F	68-86 °F				

Max. Residence Time	< 15 min; short interruption to cycle: reduce $T_x = 100\text{ °C}$ 212 °F !
Injection Pressure	$P_{Sp} = 500 - 1500\text{ bar}$ 7- 21 kpsi (specific)
Hold on Pressure	$P_N = 300 - 600\text{ bar}$ 4- 9 kpsi (specific)
Back Pressure	$P_{St} = 150\text{ bar}$ 2200 psi max. (specific)
Screw Speed	$n_s = 50 - 100\text{ rpm}$
Injection Speed	moderate to fast (50 mm/sec - 150 mm/sec)
Nozzle Type	free - flow
Note	Shrinkage is dependent on processing conditions and part design TOPAS Advanced Polymers recommends only external heated hot runner system

