



## KOCETAL K300 BLACK PROCESSING GUIDELINES

<b>Drying Temperature</b>	<b>180°F</b>
<b>Drying Time</b>	<b>3 h</b>
<b>Suggested Max Re grind</b>	<b>25%</b>
<b>Rear Temperature</b>	<b>340°F</b>
<b>Middle Temperature</b>	<b>360°F</b>
<b>Front Temperature</b>	<b>370°F</b>
<b>Nozzle Temperature</b>	<b>380°F</b>
<b>Processing (Melt) Temp</b>	<b>360-390°F</b>
<b>Mold Temperature</b>	<b>170-200°F</b>
<b>Injection Pressure</b>	<b>14500-20000 psi</b>
<b>Holding Pressure</b>	<b>13000-20000 psi</b>
<b>Back Pressure</b>	<b>0-50 psi</b>
<b>Cushion</b>	<b>0.125-0.25 in</b>
<b>Screw Speed</b>	<b>20-40 rpm</b>
<b>Clamp Tonnage</b>	<b>3-5 tons/in<sup>2</sup></b>
<b>Screw L/D Ratio</b>	<b>16.0:1.0-24.0:1.0</b>

