



## KOCATEL K300 NATURAL INJECTION MOLDING PROCESSING GUIDE

|                                    |              |                        |
|------------------------------------|--------------|------------------------|
| <b>Drying Temperature</b>          | <b>180°F</b> |                        |
| <b>Drying Time</b>                 |              | <b>3.00 hours</b>      |
| <b>Front Cylinder Temperature</b>  |              | <b>370°F</b>           |
| <b>Injection Pressure</b>          |              | <b>14500-20000 psi</b> |
| <b>Maximum Re grind</b>            |              | <b>25.0 %</b>          |
| <b>Middle Cylinder Temperature</b> |              | <b>360°F</b>           |
| <b>Mold Temperature</b>            |              | <b>170-200°F</b>       |
| <b>Nozzle Temperature</b>          |              | <b>380°F</b>           |
| <b>Processing Temperature</b>      |              | <b>360-390°F</b>       |
| <b>Rear Cylinder Temperature</b>   |              | <b>340°F</b>           |
| <b>Screw RPM</b>                   |              | <b>20-40 RPM</b>       |

