

Asahi Kasei Plastics North America,  
Inc.

One Thermofil Way · Fowlerville, MI 48836 · Phone (517) 223-2000 · Fax (517) 223-2002 · E-mail:  
asahikaseiplastics.com

THERMYLENE®  
PP—Glass Reinforced

PROCESSING GUIDE

Drying Conditions: Maximum acceptable moisture is 0.15%

Hours: 2      Temperature: 160° F      (71)°C

Special Considerations: None

General Recommendations for Barrel Temperatures

-	<u>Fahrenheit</u>	<u>Celsius</u>
Rear	380 to 400	193 to 204
Middle	400 to 420	204 to 215
Front	420 to 450	215 to 232
Nozzle	430 to 460	221 to 237
Mold Temperature	80 to 150	26 to 65
Pressures:		
Injection (Boost)	12,000 to 16,000 Psi	(83 to 110) Mpa
Holding	10,000 to 15,000 Psi	(69 to 103) Mpa
Back	50 Psi	(.345) Mpa

Injection Speed: Medium—Fast      Screw Rpm: Normal

Cooling Time: Short      Screw Type: General

- Notes:
- (1) Slightly longer cycle times may be required to mold wall thicknesses over 1/4 inch (6.35 mm).
  - (2) Slightly higher injection pressures and mold temperatures may be required to mold wall thicknesses below 0.100 inches (2.54 mm).

DISCLAIMER OF WARRANTY AND LIABILITY.

Notice: Although the information and recommendations set forth herein are presented in good faith and believed to be correct, Asahi Kasei Plastics North America, Inc. expressly disclaims any and all representations and warranties as to the completeness and accuracy thereof. Information is supplied upon the express condition that the persons receiving same will make their own determination as to its suitability for their purposes prior to use. Asahi Kasei Plastics North America warrants only that this product will perform according to the technical specifications provided in the MSDS and other materials provided by it. No other representations or warranties, expressed or implied, whether oral or arising by usage or trade or course of dealing, without limitation, any warranties of fitness or merchantability, shall be given any legal effect by this product or these materials. This product has not been designed, tested, or intended for any use other than that for which it has been contracted for sale. This product is not warranted against injuries or damages of any kind caused by uses for which this product was not designed, tested or intended. Nothing contained herein is to be construed as a recommendation to use any product, process, equipment or formulation in conflict with any patent, and Asahi Kasei Plastics North America, Inc. makes no representation or warranty, express or implied, that the use thereof will not infringe any patent.



