



## Injection Molding Processing Conditions ACRYLITE® Satinice df21 OV45(x) acrylic polymers

The ACRYLITE® Satinice df21 OV45(x) polymers should be pre-dried for a minimum of three to four hours at **180°F** in a desiccant type dryer. The typical Melt Flow Rate is **2.0 g/10 min** at 230°C & 3.8 kg.

Condition	Suggested Range	Starting Point
Feed Section Temperature, °F	440 – 470	460
Center Section Temperature, °F	460 – 500	470
Front Section Temperature, °F	460 – 500	470
Nozzle Temperature, °F	460 – 500	470
Melt Temperature, °F	450 – 500	470
Mold Temperature, °F	140 – 180	140
Injection Pressure, psi	6,000 – 15,000	8,000 (800 gauge)
Clamp Pressure, psi	2.5 tons/in <sup>2</sup> of projected area for flow length/wall thickness <100/1 5 tons/in <sup>2</sup> of projected area for flow length/wall thickness >100/1	
Screw Speed, rpm 2:1 compression ratio 3.5:1 Compression ratio	75 – 150 60 – 130	100 80
Ram Speed, in/sec Small Gates Large Gates	0.5 – 1.5 1 – 4	1 2
Back Pressure, psi	25 – 100	25

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