



## 5. Recommended Processing Conditions

The following is the recommended injection molding conditions for the first trial:

Condition	Barrel Temp.	Nozzle Temp.	Mold Temp.	Screw Speed	Injection Pressure	Injection Rate	Holding Pressure
Value	190 – 210	200 – 210	< 40	50 – 100	85 – 100	80 – 90	85 – 100
Unit	°C	°C	°C	rpm	kg/cm <sup>2</sup>	%	kg/cm <sup>2</sup>

\* For extrusion sheeting process, the barrel temperature between 180 and 210 °C is recommended, with configuring general purpose screws with L/D ratios from 24 to 30 and compression ratios between 2.5:1 and 3:1.

## 6. Recommended Storage Conditions

Store Greemas® 80104 in cool and dry place. Protect from direct sunlight, rain and violent temperature fluctuation. Fire is inhibited around storage area. No special restrictions on storage with other products. The recommended storage duration is five years.

## 7. Appearance and Packaging

Greemas® 80104 is in pellet form with a package of 25 Kg net weight per paper bag.