



Technical centre

Luxus Limited, Belvoir Way, Fairfield Industrial Estate, Louth, Lincolnshire, LN11 0LQ

Tel: + 44 (0) 1507 604941 • Fax: + 44 (0) 1507 609154 • info@luxus.co.uk • www.luxus.co.uk

General guide for injection moulding parameters for Polyethylene HD

Barrel temperatures feed	180°C – 190°C
Barrel temperatures middle	210°C – 240°C
Barrel temperatures forward	210°C – 240°C
Nozzle temperatures	210°C – 240°C
Mould plattern temperatures	10°C – 30°C

Injection pressures

Under pack the mould then build up the shot weight maintaining a screw cushion of 3mm to 6mm depending on the moulding machine and part being moulded.

Injection speed

Consistent with mould filling and part quality at optimum rate.

Holding pressure

To be consistent with maintaining good quality mouldings with no sink marking.

Holding time

To be consistent with maintaining good quality mouldings with no sink marking.

Cooling time

Dependent on the wall thickness and overall size of the part, cooling needs to be consistent with moulding that are dimensionally stable when leaving the mould.

Drying time

Not required

Barrel residence time

30sec – 2min

All information given is for guidance use only