



## General guide for injection moulding parameters for Polystyrene

Barrel temperatures feed	160°C – 190°C
Barrel temperatures middle	180°C – 230°C
Barrel temperatures forward	210°C – 250°C
Nozzle temperatures	210°C – 250°C
Mould plattern temperatures	10°C – 50°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

### Purging

Purge the moulding machine with PP after use

All information given is for guidance use only