

EcoPaXX[®] Q–DWX12

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This quick start instruction gives an indication of the key settings for processing EcoPaXX[®] Q–DWX12 to ensure best crystallization and prevent material degradation as a result of hydrolysis or thermal load. It is a summary of the Injection Molding Recommendations which can be found in our Plastics Finder at <https://envalior.plasticsfinder.com>. Our online guidelines are recommendations to help with material processing and/or to evaluate and resolve potential processing issues.

MATERIAL HANDLING

Drying

EcoPaXX[®] grades are hygroscopic and absorb moisture from the air relatively quickly. Moisture absorption is fully reversible under the following drying conditions without compromising material quality. Preferred driers are de-humidified driers with dew points maintained between –30 and –40°C / –22 and –40°F. Vacuum driers with N₂ purge can also be used. Hot air ovens or hopper driers are not suitable for pre-drying EcoPaXX[®] grades; the use of such driers may result in non-optimum performance.

Moisture content	Time	Temperature	
[%]	[h]	[°C]	[°F]
0.1–0.2 and as delivered	2–4	80	176
0.2–0.5	4–8	80	176

TEMPERATURE SETTINGS

Barrel temperature

Optimal settings are governed by barrel size and residence time. Furthermore, the level of glass and/or mineral reinforcement and the presence or absence of flame retardant have to be taken into account.

Mold/Tool	Measured melt	Nozzle	Front	Center	Rear	
100 – 140°C 212 – 284°F	275–310°C 527–590°F	270–300°C 518–572°F	270–290°C 518–554°F	260–280°C 500–536°F	250–270°C 482–518°F	

MELT RESIDENCE TIME

The optimal Melt Residence Time (MRT) for EcoPaXX[®] Q–DWX12 is ≤ 6 minutes with preferably at least 50% of the maximal shot volume used. The MRT should not exceed 10 minutes.

A full self-service MRT calculation can be done using the following [link](#).

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