

# EcoPaXX® Q–KV

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This quick start instruction gives an indication of the key settings for processing EcoPaXX® Q–KV 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://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 N<sub>2</sub> 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	
60 – 100°C 140 – 212°F	260–280°C 500–536°F	260–275°C 500–527°F	260–270°C 500–518°F	260–270°C 500–518°F	255–265°C 491–509°F	

## MELT RESIDENCE TIME

The optimal Melt Residence Time (MRT) for EcoPaXX® Q–KV 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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