

# Xytron™ G3084E

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This quick start instruction gives an indication of the key settings for processing Xytron™ G3084E 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

Hot air ovens or hopper driers can be used for pre-drying Xytron™ grades, however preferred driers are de-humidified driers with dew points maintained between  $-30$  and  $-40^{\circ}\text{C}$  /  $-22$  and  $-40^{\circ}\text{F}$ . Vacuum driers with  $\text{N}_2$  purge can also be used.

Moisture content	Time	Temperature	
[%]	[h]	$[^{\circ}\text{C}]$	$[^{\circ}\text{F}]$
as delivered	2–6	130–140	266–284

## TEMPERATURE SETTINGS

### Barrel temperature

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

Mold/Tool	Measured melt	Nozzle	Front	Center	Rear	
140 – 150°C 284 – 302°F	310–340°C 590–644°F	310–340°C 590–644°F	320–340°C 608–644°F	310–330°C 590–626°F	300–320°C 572–608°F	

## MELT RESIDENCE TIME

The optimal Melt Residence Time (MRT) for Xytron™ G3084E is  $\leq 6$  minutes with preferably at least 50% of the maximal shot volume used. The MRT should not exceed 8 minutes.

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

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