

Xytron™ U1535E

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This quick start instruction gives an indication of the key settings for processing Xytron™ U1535E 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°C / -22 and -40°F. Vacuum driers with N₂ purge can also be used.

Moisture content	Time	Temperature	
		[°C]	[°F]
as delivered	6-8	70-90	158-194

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
130 – 140°C 266 – 284°F	290–310°C 554–590°F	290–310°C 554–590°F	290–310°C 554–590°F	280–300°C 536–572°F	270–290°C 518–554°F

MELT RESIDENCE TIME

The optimal Melt Residence Time (MRT) for Xytron™ U1535E is ≤ 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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