



# TAITA CHEMICAL COMPANY, Limited

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**TAITAREX**

PS Resin

## Processing Guide - Molding condition for injection and extrusion

Character		Option Grades		Extrusion Grades		High strength Injection Grades		Injection Grades		High Flow Grades		HIPS	
Grade		808		818 818K 818L		866N 866B		861B 861N		861F		666 616	
Processing parameters	unit	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
Drying Temperature	°C(°F)	80(176)	85(185)	80(176)	85(185)	80(176)	85(185)	80(176)	85(185)	80(176)	85(185)	80(176)	85(185)
Drying Time	hr	2	4	2	4	2	4	2	4	2	4	2	4
Melt Zone	°C(°F)	180(356)	190(374)	180(356)	190(374)	180(356)	190(374)	180(356)	190(374)	170(338)	180(356)	170(338)	190(374)
Rear Zone	°C(°F)	185(365)	210(410)	185(365)	210(410)	185(365)	210(410)	185(365)	210(410)	180(356)	200(392)	180(356)	210(410)
Middle Zone	°C(°F)	195(383)	225(437)	195(383)	225(437)	195(383)	225(437)	195(383)	220(428)	190(374)	210(410)	190(374)	225(437)
Front Zone	°C(°F)	205(401)	235(455)	205(401)	230(446)	205(401)	230(446)	205(401)	225(437)	195(383)	215(419)	195(383)	230(446)
Nozzle	°C(°F)	210(410)	240(464)	210(410)	235(455)	210(410)	235(455)	210(410)	230(446)	200(392)	220(428)	200(392)	235(455)
Mold Temperature	°C(°F)	35(95)	70(158)	35(95)	70(158)	35(95)	70(158)	35(95)	70(158)	35(95)	70(158)	35(95)	70(158)
Back Pressure	psi(kgf/cm <sup>2</sup> )	71(5)	213(15)	71(5)	213(15)	71(5)	213(15)	71(5)	213(15)	71(5)	213(15)	71(5)	213(15)
Screw Speed	rpm	30	120	30	120	30	120	30	120	30	120	30	120
Molding Pressure	-	Moderate to Moderately High		Moderate to Moderately High		Moderately High to high		Low to Moderate		Low to Moderate		Moderate to Moderately High	
Molding Speed	-	Moderate to Fast		Moderate to Fast		Moderate to Fast		Low to Moderate		Low to Moderate		Moderate to Fast	

Notice – All data listed above are just reference information. It would need to take some adjustment according to different equipment and molding.