

# Georgia Gulf Flexible PVC Compounds Injection Molding Processing Guide

Georgia Gulf's Injection Molding Flexible Compounds are available in a wide range of durometer hardness. The recommended melt temperatures will vary slightly depending on the hardness of the compound. Our products are easily processed on any standard reciprocating screw injection-molding machine equipped with a general-purpose screw (compression ratio of 2.2:1 to 2.8:1). Machine nozzles should be as short as possible with a ¼" or larger exit diameter. The use of a free flow check ring tip is recommended for shot consistency.

## Typical Set-Up Conditions

Hardness	Zone 1	Zone 2	Zone 3	Nozzle	Melt Temp.
50-70A	330 F	340 F	350 F	360 F	350-375 F
70-80A	340 F	350 F	355 F	360 F	360-385 F
80A-60D	345 F	355 F	360 F	360 F	370-395 F

Mold Temperatures should be in the range of 50 to 100 F.

Back Pressure should be in the range of 50 PSI to 100 PSI.

Screw RPM: just fast enough to recover the screw before the mold opens.

**Note:** Georgia Gulf flexible compounds will shrink anywhere from 0.010 to 0.030 depending on the hardness of the compound. Softer compounds will shrink more and harder compounds will shrink less. Highly filled compounds tend to shrink less than lower or unfilled compounds. Other factors that can affect part shrinkage are wall thickness, melt temperature, injection speed/pressure and mold cooling time.

Please contact a Georgia Gulf Technical Service Engineer for any question/concerns you may have regarding our products, processing or design recommendations.

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