# PrimoSpire® PR-250

## Self-Reinforced Polyphenylene

### Solvay Specialty Polymers

#### Message:

PrimoSpire PR -250 resin is injection grade self-reinforced polystyrene (SRP). PrimoSpire SRP is an ultra-high performance amorphous polymer that can be melt processed. The unique properties of the material are mainly derived from its inherently rigid rod-like structure. Compared with other thermoplastics, PrimoSpire SRP has outstanding mechanical properties, scratch resistance, excellent solvent resistance and excellent low temperature performance without fiber reinforcement. In addition, PrimoSpire SRP has high thermal stability, is non-flammable, has higher specific strength compared with many conventional structural materials, and is easy to machine. PrimoSpire SRP's excellent mechanical, chemical, thermal and physical properties make it the preferred material for various products, including aircraft sub-structures, semiconductor components, bushings, bearings, gears, light vehicle suspension systems, medical tubes and other equipment.

black: PrimoSpire PR-250 BK 931

General Information			
Features	Rigidity, high		
	High strength		
	Scratch resistance		
	Good chemical resistance ductility		
	Flame retardancy		
Uses	Semiconductor molding compound		
	Films		
	Gear		
	Electrical/Electronic Applications		
	Aircraft applications		
	Connector		
	Shell		
	Medical/nursing supplies		
RoHS Compliance	RoHS compliance		
Appearance	Black		
	Natural color		
Forms	Powder		
	Particle		
Processing Method	Film extrusion		
	Wire & Cable Extrusion		
	Machining		
	Profile extrusion molding		
	Compression molding		

#### Injection molding

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Meth Mass-Faw Rate (MFR) (380°C/5.04)8.09.10%.09.5TM D1234Water Absorption (24 hr)101%.0ASTM D570Hardness (Class B)32.Morinal ValueUnitTest MethodRochanicalNominal ValueUnitTest MethodBendramical (Class B)552.0MPaASTM D638Tensile Modulus552.0MPaASTM D638Tensile Strength10%.0ASTM D638Percural Modulus600.0MPaASTM D790Percural Modulus600.0MPaASTM D790Percural Modulus600.0MPaASTM D790Percural Modulus69J/mASTM D790Nothed tool Impact69J/mASTM D790Nothed tool Impact1600VmMath D314Defection Temperature Under Load (1.8)Test MethodTest MethodClass Transition Temperature151CASTM D135Class Transition Temperature164CASTM D135Objectric Constant7.02-15Morinal ValueMorinal ValueObjectric Constant3.12-ASTM D130I Matz3.12-ASTM D130I Matz7.62-30Morinal ValueASTM D130I Matz7.62-30Morinal ValueASTM D130I Matz7.62-30-ASTM D130I Matz7.62-30Morinal ValueASTM D130I Matz7.62-30Morinal ValueASTM D130I Matz7.62-30Morinal ValueAS	Physical	Nominal Value	Unit	Test Method
Water Absorption (24 hy)0.10%AFM D570HardnessNorminal ValueUnitTest MethodReckvell Hardnesk (Clack B)32MethodTest MethodMachanialNorminal ValueUnitMethodTensile Moduka52.0MPaASTM D58Tensile Moduka6000MPaASTM D58Tensile Moduka6000MPaASTM D58Reward Strength00MPaASTM D50Reward Strength6000MPaASTM D50Reward Strength6000MPaASTM D50Notchel Izos ImpactNorminal ValueMPaASTM D50Unotched Izod Impact6000J/mASTM D50Unotched Izod Impact6000J/mASTM D50Machanel151CASTM D50Patter Under Load (1.5)Test MethodASTM D56CITE - Flow316.5cr/cr/crASTM D58Olume Resistivity7.0E / ISOOmicASTM D50Olume Resistivity7.0E / ISOOmicASTM D190I Marda3.11CASTM D190I Marda7.0E / ISOASTM D190 <td>Specific Gravity</td> <td>1.19</td> <td>g/cm³</td> <td>ASTM D792</td>	Specific Gravity	1.19	g/cm³	ASTM D792
HardnessNominal ValueUnitTest MethodRockwell Hardness (Class B)32ASTM F18MechanicalNominal ValueUnitTest MethodTensle Modulus5520MPaASTM 0583Tensle Strength12MPaASTM 0583Tensle Etengation (Break)10%ASTM 0583Tensle Strength234MPaASTM 0790Ileural Modulus6000MPaASTM 0790Ileural Modulus6000MPaASTM 0790ImpactNominal ValueUnitTest MethodNothered Izod Impact59//mASTM 0256Unotched Izod Impact50//mASTM 0256Unotched Izod Impact510CASTM 0256Unotched Izod Impact511*CASTM 0548Pelection Temperature UnderLoad (15 MS2, Unonselbed)515CASTM 0548Glass Transition Temperature UnderLoad (15 MS2, Unonselbed)7CASTM 0548Outume Resistivity7.0E-15em/cm/*CASTM 0150Volume Resistivity3.11TSTM 0150STM 0150I fatz3.12STM 0150STM 0150I fatz7.6E-3STM 015	Melt Mass-Flow Rate (MFR) (380°C/5.0 kg)	8.0	g/10 min	ASTM D1238
Rockwell Hardness (Class B)32ASTM E18MechanicalNominal ValueUnitTest MethodTensile Modulus5520MPaASTM D638Tensile Econgation (Break)10%ASTM D638Tensile Econgation (Break)000MPaASTM D638Rexural Modulus6000MPaASTM D638Rexural Strength000MPaASTM D638ImpactNominal ValueUnitTest MethodNotched Izod Impact59J/mASTM D638Notched Izod Impact1660J/mASTM D688Deflection Temperature Under Load (IL8 Me, Unannealed)Nominal ValueUnitTest MethodDeflection Temperature Under Load (IL8 Class Tansition Temperature168°CASTM D688Glass Transition Temperature168°CASTM D688STM D688Olume Resistivity> 7.0E+15ort/cm/*CASTM D690Delectric Constant-ASTM D190STM D190I Mir23.11-ASTM D190I Mir23.01-ASTM D190I Mir27.0E-3-ASTM D190I Mir27.0E-3-ASTM D190I Mir27.0E-3%ASTM D190I Mir27.0E-3%ASTM D190I Mir27.0E-3%ASTM D190I Mir27.0E-3%ASTM D190I Mir27.0E-3%ASTM D190I Mir27.0E-3%ASTM D190I Mir27.0E-3%	Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical Mechanical Mominal ValueUnitTest MethodTensile Modulus5520MPaASTM D638Tensile Strength152MPaASTM D638Tensile Elongation (Break)10%ASTM D638Reural Strength6000MPaASTM D730Reural Strength234MPaASTM D730ImpactNominal ValueUnitTest MethodNotched Izod Impact1600J/mASTM D256Unnotched Izod Impact1600J/mASTM D4812Deflectine Temperature Under Load (1.8) MPa, UnamedianTest MethodTest MethodDeflectine Temperature Under Load (1.8) MPa, UnamedianTest MethodASTM D648Glass Transition Temperature168"CASTM D648ElectricalNominal ValueUnitTest MethodOuter Resistivity> 70E+15ohms cmASTM D149Volume Resistivity> 70E+15ohms cmASTM D150Intert3.12XTM D150STM D150Intert3.12ASTM D150ASTM D150Intert70E-3ASTM D150ASTM D150Int	Hardness	Nominal Value	Unit	Test Method
Tensile ModulusS520MPaASTM D638Tensile Kongution (Break)152MPaASTM D638Tensile Kongution (Break)10%ASTM D638Flexural Modulus6000MPaASTM D790Flexural Modulus6000MPaASTM D790ImpactNominal ValueUnitTest MethodNotcherl Izod Impact600//mASTM D256Unotchel Izod Impact600//mASTM D4912Notcherl Izod Impact1600//mASTM D648Deflection Temperature UnderLoad (I.S. Mas Unamedlu)151CASTM D648Glass Transition Temperature168cm/cm/°CASTM D648Glass Transition Temperature168cm/cm/°CASTM D649CLTE - Flow18-5cm/cm/°CASTM D649Class Transition Temperature318-5cm/cm/°CASTM D130Volume Resistivity> 7.0E-15dms cmASTM D150Volume Resistivity> 7.0E-15dms cmASTM D150Volume ConstantASTM D150Im/cmI M4z0.11ASTM D150I M4z0.12ASTM D150I M4z7.0E-3ASTM D150I M4z0.0C-3ASTM D150I M4z0.0C-3ASTM D150I M4z0.0C-3ASTM D150I M4z0.0C-3ASTM D150I M4z0.0C-3ASTM D150I M4z0.0C-3ASTM D15	Rockwell Hardness (Class B)	32		ASTM E18
Tensile Elongation (Break)152MPaASTM D638Tensile Elongation (Break)100%ASTM D638Feural Modulus6000MPaASTM D790ImpactNominal ValueUnitTest MethodNontoched Izod Impact59J/mASTM D256Unnotched Izod Impact1600J/mASTM D268Defection Temperature Under Load (1.8 MPa, Unannealed)Test MethodMotionDefection Temperature Under Load (1.8 MPa, Unannealed)Test MethodSTM D648Defection Temperature On Monital ValueOntraSTM D159STM D159Outure Resistivity> 70.61-5ContraSTM D150STM D150I M4z3.12STM D150STM D150STM D150I M4z70.62-3STM D150STM D150STM D150I M4z70.63-3StM D150StM D150I M4z70	Mechanical	Nominal Value	Unit	Test Method
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Flexural Xordulus6000MPaASTM D'90Rexural Strength234MPaASTM D'90ImpactNominal ValueUnitTest MethodNotched Izod Impact59J/mASTM D256Unnotched Izod Impact1600J/mASTM D4812ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 MPa, Unanned)151"cASTM D648Glass Transition Temperature168"CASTM DE48CLTE - Flow3.1E-5cm/cm/"CASTM E1356ElectricalNominal ValueUnitTest MethodVolume Resistivity> 7.0E-15ohms cmASTM D149Dielectric Constant3.12KV/mmASTM D150f MHz3.12STM D150ASTM D150f MHz3.01-ASTM D150f MHz7.0E-3%ASTM D150f Mominal UneWinne<	Tensile Strength	152	MPa	ASTM D638
Flexural Strength244MPaASTM D790ImpactNominal ValueUnitTest MethodNorched Izod Impact59J/mASTM D256Unnotched Izod Impact600J/mASTM D4812ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 (1.6)"CASTM D686Giass Transition Temperature151"CASTM D686Class Transition Temperature168"CASTM E1356ElectricalNominal ValueUnitTest MethodOlume Resistivity>7.0E+15ohms-cmASTM D190Olume Resistivity3.12K//mmASTM D190I H4z3.12STM D150STM D150I MHz3.01STM D150ASTM D150I MHz7.0E-3STM D150STM D150I MHz7.0E-3STM D150<	Tensile Elongation (Break)	10	%	ASTM D638
ImpactNominal ValueUnitTest MethodNotched Izod Impact59//mASTM D256Unnotched Izod Impact1600//mASTM D4812ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 MPa, Unannealed)151"CASTM D648Glass Transition Temperature156"CASTM D648ElectricalNominal ValueCm/rcm/"CASTM E1356Volume Resistivity> 7.0E+15ohms cmASTM D190Deflectric Strength20KI/mmASTM D190Delectric Constant3.12ASTM D1501 MHz3.01-ASTM D1501 MHz3.01-ASTM D1501 MHz7.0E-3-ASTM D150 <t< td=""><td>Flexural Modulus</td><td>6000</td><td>MPa</td><td>ASTM D790</td></t<>	Flexural Modulus	6000	MPa	ASTM D790
Notched lzod Impact59//mASTM D256Unnotched lzod Impact1600//mASTM D4812Unnotched lzod ImpactNominal ValueUnitTestMethodPeffection Temperature Under Load (1.8 MPa, Unannealed)151°CASTM D548Glass Transition Temperature168°CASTM D548CLTE - Flow3.1E-5cm/cm/°CASTM E1356ElectricalNominal ValueUnitTest MethodVolume Resistivity> 7.0E+15ohms cmASTM D257Dielectric Strength0.12MSTM D109STM D109Dielectric Constant.ASTM D150STM D1501 Hzlz3.12.ASTM D1501 Hzlz3.11.ASTM D1501 Hzlz7.0E-3.ASTM D1501 HzlzNominal ValueUnitTest Method1 MzlzNominal Value.ASTM D1501 MzlzSo MD19ASTM D1501 MzlzNominal ValueASTM D1501 MzlzSo MD19 <trr>1 MzlzNominal Value<td>Flexural Strength</td><td>234</td><td>MPa</td><td>ASTM D790</td></trr>	Flexural Strength	234	MPa	ASTM D790
Unotched Izod Impact1600J/mASTM D4812ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 MPa, Unannealed)151"CASTM D648Glass Transition Temperature168"CASTM D648Glass Transition Temperature168"CASTM D648CLTE - Flow3.1E-5cm/cm/"CASTM D53ElectricalNominal ValueUnitTest MethodVolume Resistivity> 7.0E+15ohms -cmASTM D129Dielectric Constant-ASTM D150ASTM D1501 Metz3.12-ASTM D1501 Metz3.01-ASTM D1501 Metz7.0E-3-ASTM D1501 Metz1.0E-ASTM D1501 Metz1.0E <td>Impact</td> <td>Nominal Value</td> <td>Unit</td> <td>Test Method</td>	Impact	Nominal Value	Unit	Test Method
ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 MPa, Unannealed)151"CASTM D648Glass Transition Temperature168"CASTM E1356Glass Transition Temperature168"CASTM E1356CLTE - Flow3.1E-5cm/cm/"CASTM E831ElectricalNominal ValueUnitTest MethodVolume Resistivity> 7.0E+15ohms ·cmASTM D1257Dielectric Strength20kV/mmASTM D150Dielectric Constant	Notched Izod Impact	59	J/m	ASTM D256
Deflection Temperature Under Load (1.8MPa, Unannealed)151"CASTM D648Glass Transition Temperature168"CASTM E1356CLTE - Flow3.1E-5cm/cm/"CASTM E831ElectricalNominal ValueUnitTest MethodVolume Resistivity> 7.0E+15ohms ·cmASTM D1297Dielectric Strength20kV/mmASTM D150Dielectric Constant	Unnotched Izod Impact	1600	J/m	ASTM D4812
MPa, Unannealed)151°CASTM D648Glass Transition Temperature168°CASTM E1356CLTE - Flow3.1E-5m/m/°CASTM E031ElectricalNominal ValueUnitTest MethodVolume Resistivity> 7.0E+15ohms · cmASTM D1297Dielectric Ostrant-ASTM D109ASTM D109Dielectric Constant.ASTM D100ASTM D1001 MHz3.12ASTM D100ASTM D1001 MHz3.01.ASTM D1001 MHz7.0E-3.ASTM D1001 MHz7.0E-3.ASTM D1001 MHz7.0E-31 MHz7.0E-32 Ngrun Index5ASTM D1001 MHz1.01 MHz1 MHz1 MHz1 MHz1 MHz1 MHz	Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature168°CASTM E1356CLTE - Flow3.1E-5cm/cm/°CASTM E831CLTE - FlowNominal ValueUnitTest MethodVolume Resistivity> 7.0E + 15ohms·cmASTM D257Dielectric Strength> 7.0E + 15ohms·cmASTM D190Dielectric ConstantASTM D1901 Hdz3.12ASTM D1501 HHz3.11ASTM D1501 HHz3.11ASTM D1501 HHz0.0E-3ASTM D1501 HHz7.0E-31 HHz7.0E-31 HHz7.0E-31 MHzNominal ValueUnitTest Method<	-	151	°C	ASTM D648
Initial Value     Unit     Test Method       Volume Resistivity     > 7.0E+15     ohms·cm     ASTM D257       Dielectric Strength     20     kV/mm     ASTM D149       Dielectric Constant     KV/mm     ASTM D150       60 Hz     3.12     ASTM D150       1 kHz     3.11     ASTM D150       1 MHz     3.01     ASTM D150       Dissipation Factor     7.0E-3     ASTM D150       1 kHz     Nominal Value     Unit       Coxygen Index     55     %     ASTM D2633       Addtional Information     Interversite/Kraft/Kraft/Kraft/Kraft/Kraft/Kraft/Kraft/Kraft/Kraft/Kraft/Kraft/Kraft/Kraf	Glass Transition Temperature	168	°C	ASTM E1356
Volume Resistivity> 7.0E+15ohms·cmASTM D257Dielectric Strength20kV/rmmASTM D149Dielectric Constant.ASTM D15060 Hz3.12.ASTM D1501 kHz3.11.ASTM D1501 MHz3.01.ASTM D150Dissipation Factor.ASTM D15060 Hz7.0E-3.ASTM D1501 MHz7.0E-3.ASTM D1501 MHz7.0E-31 MHz0.0F-31 MHz0.0F-31 MHz0.0E-31 MHz0.0E-31 MHz0.0E-31 MHz0.0E-31 MHzNominal Value0 rygen Index0 rygen Temperature0 rygen Temperature0 rygen Temperature0 rygen Temperature0 rygen Temperature0 rygen Temp	·	3.1E-5	cm/cm/°C	ASTM E831
Dielectric Strength20kV/mmASTM D149Dielectric ConstantASTM D15060 Hz3.12ASTM D1501 kHz3.11ASTM D1501 MHz3.01ASTM D150Dissipation FactorASTM D15060 Hz7.0E-3ASTM D1501 MHz7.0E-3ASTM D1501 MHz7.0E-3ASTM D1501 MHz7.0E-3ASTM D150FlammabilityNominal ValueUnitOxygen Index55%ASTM D2633Stom D2633Additional InformationVinitPrimoSpire PR-250 BK 931bfttiftkliftkliftkliftkliftkliftkliftklif	Electrical	Nominal Value	Unit	Test Method
Dielectric Constant     ASTM D150       60 Hz     3.12     ASTM D150       1 kHz     3.11     ASTM D150       1 MHz     3.01     ASTM D150       Dissipation Factor     ASTM D150     ASTM D150       60 Hz     7.0E-3     ASTM D150       1 kHz     7.0E-3     ASTM D150       1 MHz     7.0E-3     ASTM D150       1 MHz     7.0E-3     ASTM D150       1 MHz     Nominal Value     Unit       Oxygen Index     55     %     ASTM D2863       Additional Information     Vinit     Vinit       PrimoSpire PR-250 BK 931的性能機器优先決測     Yes     Yes       Drying Temperature     149     C     Yes       Drying Time     3.0     hr     Yes <	Volume Resistivity	> 7.0E+15	ohms∙cm	ASTM D257
60 Hz     3.12     ASTM D150       1 kHz     3.11     ASTM D150       1 MHz     3.01     ASTM D150       Dissipation Factor     ASTM D150       60 Hz     7.0E-3     ASTM D150       1 MHz     7.0E-3     ASTM D150       Flammability     Nominal Value     Unit     Test Method       Oxygen Index     55     %     ASTM D2863       Additional Information     Vinial Value     Unit     Test Method       Injection     Nominal Value     Unit     Test Method       Drying Temperature     149     °C     C       Drying Time     3.0     hr     C       Rear Temperature     310     °C     C	Dielectric Strength	20	kV/mm	ASTM D149
1 kHz3.11ASTM D1501 MHz3.01ASTM D150Dissipation FactorASTM D1500 Hz7.0E-3ASTM D1501 kHz7.0E-3ASTM D1501 MHz7.0E-3ASTM D1501 MHzNominal ValueUnitFlammabilityS5% ASTM D28630 xygen Index55% ASTM D2863Additional InformationVVPrimoSpire PR-250 BK 931 bht & Btt Kræller	Dielectric Constant			ASTM D150
1 MHz3.01ASTM D150Dissipation FactorASTM D15060 Hz7.0E-3ASTM D1501 kHz7.0E-3ASTM D1501 MHz7.0E-3ASTM D150FlarmabilityNominal ValueUnitOxygen Index55%ASTM D2863%Additional InformationVPrimoSpire PR-250 BK 931的性能根据优先产出达测得最终规格尚未确定:VPring Temperature149°CDrying Temperature3.0hrRear Temperature310°C	60 Hz	3.12		ASTM D150
Dissipation FactorASTM D15060 Hz7.0E-3ASTM D1501 kHz7.0E-3ASTM D1501 MHz7.0E-3ASTM D150FlammabilityNominal ValueUnitTest Method0xygen Index55%ASTM D2863Additional InformationFFFPrimoSpire PR-250 BK 931的性能根据优先产出txy测得。最终规格尚未确定:FFInjectionNominal ValueUnitCDrying Temperature149°CCDrying Time3.0hrCRear Temperature310°CC	1 kHz	3.11		ASTM D150
60 Hz   7.0E-3   ASTM D150     1 kHz   7.0E-3   ASTM D150     1 MHz   7.0E-3   ASTM D150     Flammability   7.0E-3   ASTM D150     Vorinal Value   Unit   Test Method     0xygen Index   55   %   ASTM D2863     Additional Information   Vorinal Value   Vorinal Value   Vorinal Value     PrimoSpire PR-250 BK 931的性能根据优先步法状测得最终规格尚未确定.   Vorinal Value   Vorinal Value   Vorinal Value     Injection   Nominal Value   Unit   Vorinal Value   Vorinal Value     Injection   Nominal Value   Vorinal Value   Vorinal Value   Vorinal Value     Injection   Nominal Value   Vorinal Value   Vorinal Value   Vorinal Value     Injection   149   °C   Vorinal Value   Vorinal Value     Injing Time   3.0   rc   Vorinal Value   Vorinal Value	1 MHz	3.01		ASTM D150
1 kHz7.0E-3ASTM D1501 MHz7.0E-3ASTM D150FlammabilityNominal ValueUnitTest Method0xygen Index55% 0ASTM D2863Additional InformationSTM D2863STM D2863PrinoSpire PR-250 BK 931 bit £ik	Dissipation Factor			ASTM D150
1 MHz7.0E-3ASTM D150FlammabilityNominal ValueUnitTest MethodOxgen Index5%ASTM D2863Additional InformationPrimoSpire PR-250 BK 931 的性能根据优先学法状态测得最终规格尚未确定:UnitInjectionNominal ValueUnit-Drying Temperature149°CDrying Time3.0hrRear Temperature310°C	60 Hz	7.0E-3		ASTM D150
FlammabilityNominal ValueUnitTest MethodOxygen Index55%ASTM D2863Additional InformationPrimoSpire PR-250 BK 931 bht能根据优达// Stanger & UnitInjectionNominal ValueUnitDrying Temperature149°CDrying Time3.0hrRear Temperature310°C	1 kHz	7.0E-3		ASTM D150
Oxygen Index55%ASTM D2863Additional InformationPrimoSpire PR-250 BK 931的性能根据优于产于状次测得;最终规格尚未确定:InjectionNominal ValueUnitDrying Temperature149°CDrying Time3.0hrRear Temperature310°C	1 MHz	7.0E-3		ASTM D150
Additional Information     PrimoSpire PR-250 BK 931的性能根据优先产出批次测得;最终规格尚未确定.     Injection   Nominal Value   Unit     Drying Temperature   149   °C     Drying Time   3.0   hr     Rear Temperature   310   °C	Flammability	Nominal Value	Unit	Test Method
PrimoSpire PR-250 BK 931的性能根据优先产出比次测得;最终规格尚未确定:     Injection   Nominal Value   Unit     Drying Temperature   149   °C     Drying Time   3.0   hr     Rear Temperature   310   °C	Oxygen Index	55	%	ASTM D2863
InjectionNominal ValueUnitDrying Temperature149°CDrying Time3.0hrRear Temperature310°C	Additional Information			
Drying Temperature149°CDrying Time3.0hrRear Temperature310°C	PrimoSpire PR-250 BK 931的性能根据优先产	品批次测得;最终规格尚未确定.		
Drying Time3.0hrRear Temperature310°C	Injection	Nominal Value	Unit	
Rear Temperature 310 °C	Drying Temperature	149	°C	
	Drying Time	3.0	hr	
Middle Temperature 324 °C	Rear Temperature	310	°C	
•	Middle Temperature	324	°C	

Front Temperature	335	°C	
Nozzle Temperature	341	°C	
Processing (Melt) Temp	343 - 349	°C	
Mold Temperature	129 - 146	°C	
Injection Rate	Slow-Moderate		

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