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General guide for injection moulding parameters for Polyethylene HD

Barrel temperatures feed	180°C – 190°C
Barrel temperatures middle	210°C – 240°C
Barrel temperatures forward	210°C – 240°C
Nozzle temperatures	210°C – 240°C

Mould plattern temperatures	10°C – 30°C
Injection pressures	Under pack the mould then build up the shot weight maintaining a screw cushion of 3mm to 6mm depending on the moulding machine and part being moulded.
Injection speed	Consistent with mould filling and part quality at optimum rate.
Holding pressure	To be consistent with maintaining good quality mouldings with no sink marking.
Holding time	To be consistent with maintaining good quality mouldings with no sink marking.
Cooling time	Dependent on the wall thickness and overall size of the part, cooling needs to be consistent with moulding that are dimensionally stable when leaving the mould.
Drying time	Not required
Barrel residence time	30sec – 2min

All information given is for guidance use only