

# TOTAL PETROCHEMICALS

**6540**

The following recommendations are intended only as a guide to the initial set up on the moulding machine. Variations in tool geometry, gate and runner design, may result in changes to these settings.

**Melt Temperature: Minimum 180°C  
Maximum 260°C**

**Typical Temperature Profile:**

**200°C → → → 240°C  
Hopper Last zone**

**Injection Pressure: Medium (dependent on melt T°, Inj speed, design of the molded article etc)**

**Injection Speed: 40% → 60%**

**Back Pressure: Low / Medium  
Medium to High if MB addition  
< 15 bar**

**Tool Temperature: 30°C (moving half)  
40°C (fixed half)**

**Pre-drying is not normally required, however this grade can be pre-dried at 70°C for 2 hours before processing.**

**6540 can be reground, and introduced at low levels into virgin material. Care should be taken to ensure that regrind is free from contamination, and ground to a size sufficient to allow consistent feeding.**