



Mitsui Chemicals



Meerbuscher Straße 64-78/Haus 6a  
D-40670 Meerbusch / Germany  
Phone: +49 (0) 2159-81531-0  
Fax: +49 (0) 2159 81531-29  
info@dreyplas.com  
[www.dreyplas.com](http://www.dreyplas.com)

## Injection molding conditions for LUBMER™

Molding conditions	Grade	L3000	L4000	L5000	LS4140
Molding temp. (°C)	C <sub>1</sub>	210	220	240	220
	C <sub>2</sub>	230	240	260	240
	C <sub>3</sub>	230	240	260	240
	Nozzle	230	245	265	245
Injection speed	Primary	MS	MS	HS	MS
	Secondary	LS	LS	LS	LS
Injection pressure (MPa)	Primary	160	160	160	160
	Secondary	40	40	80	50
Molding time (sec)	Injection	4	4.5	5	4
	Dwelling	10	10	10	10
	Cooling	15	15	15	15
Mold temp.		24 ~ 40°C (Water cooling)			60°C

HS: High Speed MS: Middle Speed LS: Low Speed