



Northwest Engineered Materials, Inc.
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Process Sheet

Styrene 200-Natural High Impact-Natural

Temperatures: lower than average
Nozzle: 400+/- 10° F
Zone #1: 400° F
Zone #2: 390° F
Zone #3: 390° F
Zone #4: 380° F (closest to feed)
Water: 80° F

Injection Set Up: varies with part
Hydraulic: Limit 1200
Transfer 1200
Set 1200

Pack: Shorter Pack Time is Optimal

Screw RPM: 50 – 75

Back Pressure: 50 – 100

Color: NO less than 2%, or 4% at 50% letdown