

» PROCESSING GUIDE

# Trilliant™

HC8910 AND HC8920



## TRILLIANT HC8910 AND HC8920

Trilliant™ HC chemically resistant blends give outstanding protection to products that must maintain tensile strength integrity after repeated exposure to disinfectants.

### Injection Molding Parameters

The barrel temperatures below should be used only as a reference point. Actual melt temperatures should be measured using a pyrometer to ensure consistent and accurate processing.

Barrel Temperatures	English (°F)		Metric (°C)		Comments
Zone 1 - Rear	410°F	450°F	210°C	230°C	If smoking starts to occur, purge machine immediately and reduce mold and barrel temperatures.
Zone 2 - Center	420°F	460°F	215°C	235°C	
Zone 3 - Front	430°F	470°F	220°C	240°C	
Nozzle	440°F	480°F	225°C	250°C	

Melt & Mold Temperatures	English (°F)		Metric (°C)		Comments
Melt Temperature	440°F	480°F	225°C	250°C	Wipe down mold surface after each production run.
Mold Temperature	125°F	200°F	50°C	90°C	

Drying Conditions	English (°F)	Metric (°C)
Temperature	180°F	80°C
Duration	2-4 Hours	
Moisture Level Allowable	0.05%–0.20%	

Processing	
Screw Speed	Typical screw speeds are recommended
Back Pressure	Lower back pressure is recommended
Pack Pressure	60 - 80% of max injection pressure
Hold Pressure	40 - 60% of max injection pressure
Cool Time	10 - 30 seconds (depends on part geometry and dimensional stability)

## Notes

These guidelines are based on lab results, and their values may not reflect actual processes using different machinery. Using these guidelines is not a guarantee that acceptable parts will be produced.

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