

## Recommended processing temperatures for Ipethene® grades

Product name	MFR (dg/min)	Recommended processing temperature (°C)	Processing technique
Ipethene 4203	0.2	180-230	Blown film*
Ipethene 100	0.3	180-220	Blown film*
Ipethene 111	0.7	160-180	Blown film*
Ipethene 113	0.7	160-175	Blown film*
Ipethene 213	1.0	160-175	Blown film*
Ipethene 320	2.0	155-180	Blown film*
Ipethene 322	2.0	155-175	Blown film*
Ipethene 323	2.0	155-175	Blown film*
Ipethene 470	4.5	260-330	Extrusion Coating
Ipethene 600	7.0	160-210	Injection Molding**
Ipethene 670	7.5	260-330	Extrusion Coating
Ipethene 810	20	160-210	Injection Molding**
Ipethene 830	20	160-210	Injection Molding**
Ipethene 900	50	160-210	Injection Molding**

\* Due to differences in screw and die head designs, processing conditions should be optimized for each production line.

\*\* Due to differences in machine type, part shape and mold design, processing conditions should be optimized for each production line. Typical mold temperature 10-40°C.

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Certificate A1617; Issue: 29/12/2015