

**Saint-Gobain Performance Plastics
Sani-Pro-K Kynar, Fabrication**

Table X

Kynar or Kynar Flex Grade	710	720	740	760	460	2800	320
Barrel °C	182/210	182/210	193/221	202/232	199/232	191/210	193/232
°F	370/410	370/410	380/430	395/450	390/450	375/410	380/450
Barrel Front °C	191/227	191/232	204/243	210/249	210/254	204/249	221/260
°F	375/440	375/450	400/470	410/480	410/490	400/480	430/500
Nozzle °C	182/227	182/232	193/243	204/254	204/254	193/254	232/266
°F	370/440	370/450	380/470	400/490	400/490	380/490	450/510
Mold °C	49/93	49/93	49/93	49/93	49/93	49/93	49/93
°F	120/200	120/200	120/200	120/200	120/200	120/200	120/200

Table X: Recommended Injection Molding Temperatures*

*Optimum molding temperatures can vary with screw design. Elf Atochem North America recommends consulting with our technical department before making parts from Kynar resin. We also suggest that you begin at the lowest temperature +14°C (+25°F) for initial start-up if you are using a reciprocating screw machine; use a slightly higher start-up for a plunger type. Depending on part size and configuration, adjust accordingly.