

## Processing Guideline for TecoMax™ PGA M-2000

June, 2025

### 1) Material preparation:

- Recommend to pre-dry the material at 120°C for 6 hours or more with dry air at dew point of -40 °C or lower before injection molding or extrusion.
- Target moisture content below 100ppm, ideally below 50ppm.
- Keep material dry during the whole production process. Do not use materials left in open air for more than a few hours or moisture content above 300ppm.

### 2) Injection molding/extrusion:

- Use extruder with low compression ratio screw.
- Purge extruder thoroughly with commercial purging materials (polypropylene, polyethylene, etc.)
- Recommended melt temperature: 230~260 °C, not higher than 270°C.
- Recommended mold temperature: 80~120°C.
- Purge extruder thoroughly after PGA production or prolonged unexpected shutdown.

### 3) Annealing:

- If needed, anneal molded or extruded parts.
- Anneal parts under dry atmosphere, using dry nitrogen or vacuum.
- Ramp up temperature by 5~10°C/hour
- Hold temperature 150°C for 4~8 hours.
- Cool down by -5°C/hour.

### 4) Molded parts packaging

- Package the molded parts right after production in sealed moisture proof bags with a desiccant. Store in a dry and cool environment.