Polycarbonate Processing Parameters

General Recommendations:
- Reciprocating screw machines
- General purpose screw
- Flow through nozzle
- Reverse taper nozzle
- High hardness tool
- Optimal shot size: 40-60% of barrel capacity
  - Should never be greater than 75% of barrel capacity

Drying Conditions:
- 4 hours at 250°F in a dehumidifying oven or hopper dryer is recommended
- Material should be dried to a 0.04% moisture level

Injection Speed and Injection Pressure:
- To obtain the best possible surface finish, a moderate to fast injection speed is recommended. With glass and mineral filled materials, fast injection speeds are recommended. To achieve 95% mold fill of the part during the first injection state, a minimum injection pressure should be utilized and hold pressure should be 30-75% of the initial pressure.

Processing Conditions:
- Melt Temperature 580°-620°F
- Target Temperature 600°F
- Mold Temperature 180°-250°F
- Target Temperature 210°F
- Cylinder Temperature 580°-655°F
- Back Pressure 50-100 psi
- Screw Speed 30-60 RPM
- Target Screw Speed 50 RPM
- Hold Pressure 30-75% of the injection pressure
- Cycle Time
  - Varies with part size and mold temperature

Use of Regrind:
- It is not recommended to use more than 20% of regrind material and expect slight decreases in mechanical properties when it is utilized.

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