



14030 Gannet Street, Santa Fe Springs, CA 90670
Phone: (562) 921-0444 Fax: (562) 921-0034

Processing Guidelines

Material: *PC/ABS Alloy*

GENERAL INJECTION MOLDING PROCESSING GUIDELINES

Property	Data	Units
Mold Temperature	120-160	°F
Nozzle Temperature	450-500	°F
Front Temperature	450-500	°F
Middle Temperature	425-470	°F
Rear Temperature	410-445	°F
Processing (Melt) Temp	550-600	°F
Back Pressure	70-210	psi
Screw Speed	40-80	rpm
Suck Back	0.12-0.2	inch
Drying Temperature	195	°F
Drying Time	2-4	hr
Drying Time, Maximum	4	hr
Max Moisture	.04	%

Southland Polymers assumes no liability for the accuracy, completeness, or validity of the information contained in this document. The information or data contained within this document should not be construed as a recommendation from Southland Polymers. Processing and manufacturing equipment and techniques may vary considerably, and any information or data contained in this document may not be suitable under all situations. Any damage to persons or property that result from the use of the information given in this document will be the sole responsibility of the reader and/or end user of this document.