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Processing Guidelines

Material: *Polycarbonate*

GENERAL INJECTION MOLDING PROCESSING GUIDELINES

Property	Data	Units
Clamp Tonnage	2.0-4.0	tons/in ²
Drying Temperature	250	°F
Drying Time	4.0	hr
Drying Time, Maximum	8.0	hr
Front Temperature	560-590	°F
Injection Pressure	10000-15000	psi
Suggested Max Moisture	0.02	%
Suggested Max Regrind	20.0	%
Middle Temperature	540-570	°F
Mold Temperature	180-240	°F
Nozzle Temperature	570-600	°F
Processing (Melt) Temp	550-600	°F
Rear Temperature	520-550	°F
Screw Compression Ratio	2.0:1.0 to 3.0:1.0	
Screw L/D Ratio	20.0:1.0	
Screw Speed	40-80	rpm

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