



Processing Conditions Polycarbonate

Typical Injection

Molding Conditions

English

SI Metric

Temperatures		
Rear zone	520 - 550 °F	271 - 288 °C
Center zone	540 - 570 °F	282 - 299 °C
Front zone	560 - 590 °F	293 - 310 °C
Melt	550 - 600 °F	288 - 316 °C
Mold	180 - 250 °F	82 - 121 °C

Pressures		
Injection	10000 - 15000 psi	69 - 103 MPa
Hold	5000 - 12000 psi	34 - 83 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa

Speeds		
Fill	1 - 2 in/sec	25 - 51 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

Drying		
Time & Temperature	4 Hrs @ 250 °F	4 Hrs @ 121 °C
Dew Point	-20 °F	-29 °C
Moisture Content	0.02 %	0.02 %

Comments

- This information is intended to be used only as a guideline for designers and processors of modified thermoplastics for injection molding. Because injection mold design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.
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