

Injection Molding of EMERGE™ PC/PET 9500CR Advanced Resin

Drying Recommendations

Moisture Content: It is recommended to dry this resin to less than 0.02% moisture.

Dryer: A desiccant-type dryer is recommended for this material. Hopper dryer may also be needed.

Dew Point: -20°F (-30°C) or lower is desired.

Drying Time: A minimum of 4 hours at 250°F (120°C) is recommended.

Equipment Specifications

Shot Size: As required to fill part.

Clamp Tonnage: 2.5-3.0 tons/in² (0.35-0.42 tonnes/cm²) of projected surface area.

Barrel Capacity: 60-70% of machine barrel size should be for part shot.

Process Conditions

Melt Temperature: Can be varied as required to fill part. See Table 1.

Mold Temperature: Can be changed to affect gloss or demolding characteristics. Higher mold temperatures result in higher gloss. See Table 1.

Manifold/Drop Temperature: 20-40°F (10-20°C) below melt temperature. See Table 1 for recommended melt temperatures and adjust manifold/drop temperature accordingly.

Purging/Shutdown: For short interruptions in production, empty the barrel and reduce barrel temperatures. For extended shutdowns, purge the machine with a purging compound or general purpose polystyrene before shutting down machine.

Table 1: Machine Temperature Recommendations

Temperatures	Range, °F (°C)	Aim, °F (°C)
Melt Temperature	480-540 (250-280)	520 (270)
Mold Temperature	110-210 (45-100)	150 (65)
Barrel – Feed	440-490 (220-255)	450 (230)
Barrel – Transition	480-540 (250-280)	500 (260)
Barrel – Metering	480-540 (250-280)	520 (270)
Nozzle	490-545 (255-285)	525 (275)

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.





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