

Xantar® PC

Recommendations for Injection Molding Xantar® grades

Drying conditions

Drying time [hour]	Temperature [°C]	Remarks
4	120 (248°F)	-(Pre-dried) air dryers are recommended to use. -Maximum allowed moisture content after drying is 0.03%.

Injection Molding Temperatures

Mold	Melt	Nozzle	Front	Center	Rear
[°C]	[°C]	[°C]	[°C]	[°C]	[°C]
80 – 120	290 - 320	270 - 290	280 - 300	270 - 290	260 – 280
176 - 248°F	554 - 608°F	518 - 554°F	536 - 572°F	518 - 554°F	500 - 536°F

Remarks:

- Within the given ranges higher mold and melt temperatures are for high viscosity grades.
- Also for glass fiber filled types (grade code starting with G) higher mold and melt temperatures within the given ranges are recommended.

General remarks:

- In order to minimize heat generation due to friction use a low rotation speed of the screw. Use almost the complete cooling time for plasticizing.
- When interrupting the process for a short time, the barrel should be emptied and temperature settings of the barrel should be lowered to 170°C (338°F). Do not drop below 160°C (320°F), the surface of the screw can be damaged due to adhesion of the frozen material.
- When stopping production, purge the barrel with HDPE.

[DSM Sales Offices](#)

Date: 22.12.2003

DSM Guide