DSM Engineering Plastics - Technical Guide

Xantar[®] PC Recommendations for Injection Molding Xantar[®] grades

Drying conditions

Drying time [hour]	Temperature [°C]	Remarks
4	120 <i>(248°F)</i>	-(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 $170^{\circ}C$ (338°F). Do not drop below $160^{\circ}C$ (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





Disclaimer: All information supplied by or on behalf of DSM in relation to its products, whether in the nature of data, recommendations or otherwise, is supported by research and, in good faith, believed reliable, but DSM assumes no liability and makes no warranties of any kind, express or implied, including, but not to thimted to, those of TITLE, MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE or NON-INFRINGEMENT or any warranty arising from a course of dealing, usage, or trade practice whatsoever in respect of application processing or use made of the aforementioned information or product. The user assumes all responsibility for the use of all such information.

1