

POLYshine

PBT D201 GF30

Processing data for the injection moulder

Parameter	Recommended Value	Unit
Melt temperature	250-270	°C
Mould temperature	80-100	°C
Injection pressure	900-1400	bar
Injection speed	High	
Holding pressure	80-100	% of injection pressure
Back pressure	Lowest	bar
Drying temperature	120	°C
Drying time in circulation dryer	3-4	h
Drying time in fresh-air dryer	2-3	h
Drying time in dessicant air dryer	2-3	h

Predry until moisture content < 0,02%

During production stops, emptying the cylinder is recommended. Leave the screw in its front most position. For polycarbonate it is also recommended to leave the cylinder temperature at 160-180°C and that the heating on the feeding zone is on. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould. For further information, see the material safety datasheet (MSDS).