

POLYblend

45FS GF20

Processing data for the injection moulder

Parameter	Recommended Value	Unit
Melt temperature	240-280	°C
Mould temperature	70-100	°C
Injection pressure	900-1500	bar
Injection speed	High	
Holding pressure	20-50	% of injection pressure
Back pressure	5-15	bar
Drying temperature	100-110	°C
Drying time in circulation dryer	2-8*	h
Drying time in fresh-air dryer	2-8*	h
Drying time in dessicant air dryer	2-8*	h

*Predry until moisture-content < 0.05%

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).