



HYBRID® POLYCARBONATE ALLOYS

TYPICAL PROCESSING CONDITIONS[†]

DRYING

Hybrid® Polycarbonate Alloy resins should be dried in a desiccant type dryer* to a moisture content of less than 0.04% by weight. The following typical drying parameters are recommended to achieve acceptable moisture levels prior to molding the resin:

Drying Time (hrs) **2-4** (5-6 w/regrind)

Drying Temp. (°F) **220-230**

Drying time should not exceed 10 hours to avoid excessive heat history.

*Dew point of circulating air to be less than -20°F at hopper inlet. Air throughput minimum of 1 CFM/Lb. Resin/Hr.

INJECTION MOLDING

The following molding conditions are recommended starting points for Hybrid® Polycarbonate Alloy resins. Some modifications may be required depending on the specific molding equipment and part configuration.

PARAMETER	S459, S464, S466	S551, S570	S451H, S470H
Rear Temp (°F)	450-470	470-500	480-500
Center Temp (°F)	460-500	490-520	490-510
Front Temp (°F)	470-520	500-530	500-520
Nozzle Temp (°F)	470-520	500-530	500-530
Mold Temp (°F)	150-180	160-200	160-200
Filling Speed	MEDIUM	MEDIUM	MEDIUM
Filling Pressure (psi)***	800-1800	800-1500	800-1700
Screw Speed (RPM)	40-60	40-60	40-60
Back Pressure (psi)	50-150	50-120	50-120
Shot to Cylinder Size (%)	40-80	40-80	40-80

** For extrusion parameters, please contact your distributor's Technology Department

***NOTE: Pressures given are in the hydraulic circuit.

[†]The data listed here fall within the normal range of product properties, but they should not be used to establish specification limits or used alone as a basis for design. This information is not intended as a warranty of any kind. Buyers must make their own representative test and assume all risks of use, whether used alone or in combination with other products. ENTEC POLYMERS, LLC assumes no obligation or liability of any advice furnished by it or results obtained with respect to these products. All warranties expressed or implied including warranties of merchantability for a particular purpose or use are excluded and disclaimed. ENTEC POLYMERS, LLC assumes no liability for use of products in infringement of any patent. The foregoing limitation of remedy and exclusion of liability is reflected in and is part of the consideration for the price at which the products are sold by ENTEC POLYMERS, LLC.



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