



HYLEX® POLYCARBONATE

TYPICAL PROCESSING CONDITIONS†

DRYING

Hylex® Polycarbonate resins should be dried in a desiccant type dryer* to a moisture content of less than 0.02% by weight. The following typical drying parameters are recommended to achieve acceptable moisture levels prior to molding the resin:

	Unreinforced Grades	Reinforced Grades
Drying Time (hrs)	3-4 (5-6 hrs w/regrind)	4-6 (6-8 hrs w/regrind)
Drying Temp. (°F)	250	250

Drying time should not exceed 12 hours to avoid excessive heat history.

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

INJECTION MOLDING

UNREINFORCED GRADES

	P1007L P1307L	P1010L, P1310L P1010LLT, P1310LLT P1010FR, P1310FR	P1017L, P1317L P1018LLT, P1318LLT P1017FR, P1317FR	P1025L, P1325L P1032L, P1332L
REAR TEMP (°F)	540-580	520-540	470-510	450-490
MIDDLE TEMP (°F)	550-590	530-550	490-520	470-510
FRONT TEMP (°F)	590-630	540-570	520-540	500-520
NOZZLE TEMP (°F)	570-620	530-570	510-530	500-520
MELT TEMP (°F)	590-640	550-600	520-550	510-530
MOLD TEMP (°F)	180-230	170-200	160-200	150-190
FILLING PRESSURE (psi)*	1,500-2,000	1,000-1,800	900-1,800	800-1,800
HOLDING PRESSURE (psi)*	1,000-1,400	700-1,200	600-1,100	500-1,000
BACK PRESSURE (psi)*	70-150	70-150	70-150	70-150
SCREW SPEED (RPM)	40-70	40-70	40-70	40-70
SHOT TO CYLINDER SIZE (%)	40-60	40-60	40-60	40-60

REINFORCED GRADES

	P1010G10 P1010G10FR P1025G10NHFR P1310G10	P1010G15 P1310G15	P1010G20 P1010G20FR P1310G20	P1010G30 P1010G30FR P1310G30	P1010G40 P1010G40FR P1310G40
REAR TEMP (°F)	550-570	550-570	550-570	560-580	570-590
MIDDLE TEMP (°F)	550-590	560-580	560-600	570-610	580-620
FRONT TEMP (°F)	560-600	560-600	580-620	580-630	590-640
NOZZLE TEMP (°F)	560-600	560-600	580-620	580-630	590-640
MELT TEMP (°F)	570-610	580-620	600-640	590-640	600-650
MOLD TEMP (°F)	180-240	190-250	190-250	190-250	190-250
FILLING PRESSURE (psi)*	1,200-1,800	1,300-1,900	1,400-2,000	1,600-2,200	1,600-2,200
HOLDING PRESSURE (psi)*	800-1,200	900-1,300	1,000-1,400	1,100-1,500	1,100-1,500
BACK PRESSURE (psi)*	60-150	60-150	60-180	50-180	50-180
SCREW SPEED (RPM)	40-70	40-70	60-80	60-80	60-80
SHOT TO CYLINDER SIZE (%)	40-60	40-60	40-60	40-60	40-60

* 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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