



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:

Drying Time (hrs)	3-4 (5-6 hrs w/regrind)
Drying Temp. (°F)	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

GRADE	P1035IL, P1335IL, P1035ILLG, P1335ILLG
REAR TEMP (°F)	450-490
MIDDLE TEMP (°F)	470-510
FRONT TEMP (°F)	500-520
NOZZLE TEMP (°F)	500-520
MELT TEMP (°F)	510-530
MOLD TEMP (°F)	150-190
FILLING PRESSURE (psi)*	800-1,800
HOLDING PRESSURE (psi)*	500-1,000
BACK PRESSURE (psi)*	70-150
SCREW SPEED (RPM)	40-70
SHOT TO CYLINDER SIZE (%)	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.

