



PROCESSING GUIDE

Page : 1 / 1
Revision : 005
Rev. Date : May 2014

4LEX[®] Polycarbonate (PC)

PROCESSING CONDITIONS

	Unreinforced	Impact Modified	Reinforced	Flame Retardant
Drying (°C/Hour)	120/3-4	-	120/3-4	120/3-4
Maximum Moisture Content (%)	0.02	-	0.02	0.02
Feed Throat Temperature (°C)	60 - 80	-	60 - 80	60 - 80
Processing Temperature (°C)	260 - 300	-	270 - 310	250 - 290
Mould Temperature (°C)	80 - 100	-	80 - 120	80 - 100
Hold Pressure (MPa)	60 - 120	-	60 - 120	60 - 120
Back Pressure	Low	-	Low	Low
Injection Speed	Medium - Fast	-	Medium - Fast	Medium - Fast
Maximum Screw Speed (rpm)	200	-	200	200

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Test Values: Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/ die, the processing conditions and the colouring.