



4LEX[®] is the registered trade name for Polycarbonate (PC) compounds produced by 4PLAS.

PROCESSING

Polycarbonate (PC) should be stored in a dry, well ventilated area away from sources of heat.

4LEX[®] should be dried at 120°C for 3 to 4 hours. However flame retardant grades should be dried for 4 to 6 hours in dehumidified driers prior to processing.

4LEX[®] compounds can be processed in all commercial injection moulding machinery. Guide recommendations for processing parameters are detailed below:

Detailed processing instructions specific for each type of product are available upon request.

RECYCLING

Regrind levels up to 25% can be used depending upon the application and requirements. However for flame retardant grades a maximum 10% addition rate is recommended. Regrind should be clean, free of contamination and not thermally degraded and must be dry as moulded, or be dried prior to reuse.

SAFETY

Under normal working conditions **4LEX[®]** is not a toxic or hazardous material. During processing preventative actions should be taken to avoid direct contact with the polymer melt or inhalation of any gases produced. Detailed safety information can be found in our material safety data sheets (MSDS).

	Barrel Temperature (°C)	Mould Temperature (°C)	Melt Temperature (°C)	Back Pressure	Injection Speed	Injection Pressure
4LEX [®] (PC)	250 - 290	70 - 100	230 - 260	Low	Fast	High
4LEX [®] (PC-FR)	240 - 280	60 - 100	230 - 260	Low	Fast	High
4LEX [®] (PC-GF)	270 - 290	100 - 120	230 - 260	Low	Fast	High