



## General guide for injection moulding parameters for Polycarbonate

Barrel temperatures feed	260°C – 280°C
Barrel temperatures middle	270°C – 290°C
Barrel temperatures forward	270°C – 290°C
Nozzle temperatures	270°C – 290°C
Mould plattern temperatures	80°C – 120°C

### Injection pressures

Under pack the mould then build up the shot weight maintaining a screw cushion of 3mm to 6mm depending on the moulding machine and part being moulded.

### Injection speed

Consistent with mould filling and part quality at optimum rate.

### Holding pressure

To be consistent with maintaining good quality mouldings with no sink marking.

### Holding time

To be consistent with maintaining good quality mouldings with no sink marking.

### Cooling time

Dependent on the wall thickness and overall size of the part, cooling needs to be consistent with moulding that are dimensionally stable when leaving the mould.

### Drying time

4hrs @ 120°C

### Barrel residence time

30sec – 2min

### Purging

Purge the moulding machine with PP after use

All information given is for guidance use only