

PROCESSING GUIDE

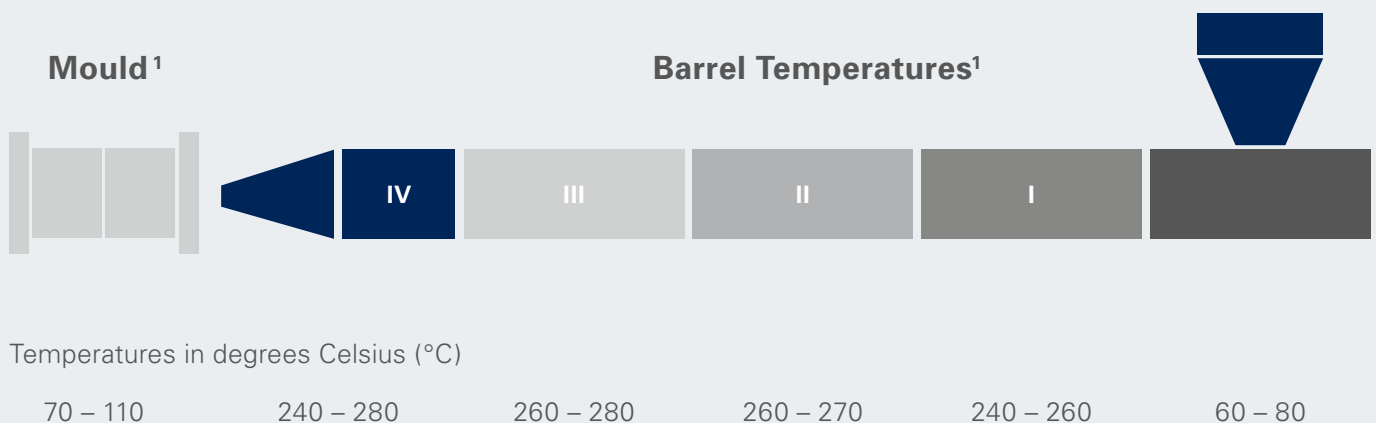
ALTECH[®] PC+ABS is an amorphous thermoplastic, unfilled or reinforced with glass fibre.

PRE-TREATMENT

ALTECH[®] PC+ABS is a hygroscopic polymer. Due to absorption of moisture from the air, pre-drying is mandatory in order to avoid material degradation and surface defects. For specific filled products see corresponding Technical Data Sheet.

PROCESSING

ALTECH[®] PC+ABS may be processed on all standard injection moulding machines.



Temperatures in degrees Celsius (°C)

¹ Guide values. Standard starting profile might be in the middle, for filled or high heat PC+ABS a rather higher, for standard PC+ABS a rather lower temperature profile.

		Unit	Notes
Properties			
Polymer abbreviation			PC+ABS
Density (ISO 1183)	g/cm ³	1.12 – 1.30 (see Technical Data Sheet)	
Injection Machinery			
Screw stroke		Metering stroke between 1 x D and 3 x D	
Screw type		Three zone screw with L/D ratio 18:1 to 22:1	
Nozzle type		Open or shut-off possible	
Hopper type		Standard	
Pre-processing			
Storage		Dry, protected from heat and light	
Dryer type		Air circulating	Dry air
Drying time	h	3 – 6	2 – 4
Drying temperature	°C	100 – 110	
Permissible moisture content	%	0.02 – 0.05	
Processing Conditions			
Melt temperature range	°C	240 – 280	
Mould temperature range	°C	70 – 110	
Coolant		Water	
Throughput coolant		To ensure turbulent flow	
Peripheral screw speed	mm/s	50 – 300, e.g. screw speed of 35rpm with a screw diameter of 50 mm	
Back pressure (specific)	bar	50 – 100	
Residence time	minutes	4 – 6	
Injection speed		Profile for constant flow front speed	
Shrinkage²			
		PC+ABS Unfilled	PC+ABS Glass fibre
Shrinkage range (ISO 294-4)	%	0.5 – 0.8	0.2 – 0.6

² Shrinkage is influenced by the part geometry, the wall thickness of the moulding, the position and size of the gate and the processing parameters.

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