



HYBRID[®] PC/PBT ALLOYS

TYPICAL PROCESSING CONDITIONS[†]

DRYING

Hybrid[®] Polycarbonate Alloy 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) **4-5** (5-6 w/regrind)

Drying Temp. (°F) **230**

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 throughput minimum of 1 CFM/Lb. Resin/Hr.

INJECTION MOLDING

The following molding conditions are recommended starting points for these resins. Some modifications may be required depending on the specific molding equipment and part configuration.

PARAMETER	B2025I, B2025IU, B3030, B3030U, B6720, B6720U
Rear Temp (°F)	470-510
Center Temp (°F)	480-520
Center Temp (°F)	480-520
Front Temp (°F)	490-530
Nozzle Temp (°F)	490-520
Mold Temp (°F)	150-190
Filling Speed	MEDIUM
Filling Pressure	MEDIUM - HIGH
Screw Speed (RPM)	50-80
Shot to Cylinder Size(%)	50-80

[†]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.



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