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北化院北研科技

BEIHUAYUAN BEIYAN TECHNOLOGY

广东北研新材料科技有限公司

GUANGDONG BEIYAN NEW MATERIALS TECHNOLOGY CO., LTD.

**PC+PBT BY551F**

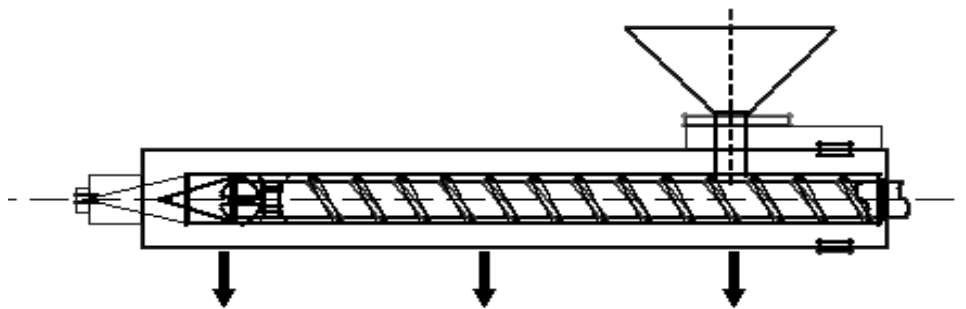
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## Molding condition

A, Pre-drying: 110 ~ 130 °C x 4 ~ 6 hrs.

- depending on:
- a) Humidity
  - b) Recycled material ratio
  - c) Storage conditions

B, Barrel Setting Profile:



Condition	Nozzle	Compression zone	Feeding zone	Mold Temperature
max. (°C)	270	260	250	80~120 °C
mix. (°C)	240	230	220	

### NOTE:

1. Keep the resin from dust and contamination during handling and production.
2. Do not retain the hot melt at the barrel for a long time between injection cycles.
3. Temperature setting of manifold system should not exceed 300°C to avoid melt from degrading.
4. Purging: Heat decomposing resin are not recommended for purging the residual PC and PBT resin in barrel of injection machine and extruder. Polyethylene and polypropylene are the most commonly used heat stable resins for purging purpose.

If you have any questions, please contact the technical department at 13827276006 Mr. Luo.

Note: The above statement is based on our current level of knowledge. The above recommended processing conditions should be adjusted according to the specific equipment. Beiyang does not make any express or implied warranty for any use of the above information, nor does it assume any responsibility. All condition data are for reference only.

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