

General processing advice for SITRALON (PC)

Drying

SITRALON must be dried prior to processing. Therefore, the granules can absorb moisture during transport and storage (approx. 0,02% in standard atmospheric conditions)

The optimal dry temperature for SITRALON (PC) –type, can you figure out on the table 1.

When processing SITRALON (PC), therefore, care should be taken to ensure that the granules are processed in dry conditions. For injection molding the residual moisture in the granules should be less than 0,02%. An excessive amount of moisture in the plastic melt can lead to surface defects in the forms of streaks as well as hydrolytic degradation

| Engineering thermoplastic | Drying-temperature (°C) | Circulating dryer (hour) | Dry air dryer (hour) | Fresh air dryer (hour) |
|---------------------------|-------------------------|--------------------------|----------------------|------------------------|
| SITRALON (PC) | 120 | 4 - 12 | 2 - 3 | 2 - 4 |

The optimum processing temperature of SITRALON (PC) must be determined according to grade and molding and should be between 280 and 320°C (table 2).

| Engineering thermoplastic | Mold temperature (°C) | Mold Temperature (°C) |
|---------------------------|-----------------------|-----------------------|
| SITRALON (PC) | 280 -320 | 80 - 120 |

It is recommended that the effective melt temperature be checked using an insertion thermometer on the ejected press cake. Overheating, or leaving the melt in the cylinder for an extended period of time, can result in material damage, i.e. a reduction in strength and surface defects in the form of streaks on the injection molded starts at approx. 340°C

Die produktspezifischen Angaben sind keinesfalls als Garantien zu verstehen. Jeder Anwender hat unser Produkt in eigener Verantwortung für das beabsichtigte Einsatzgebiet zu prüfen.

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