

General processing advice for SITRALOY (PC+ABS)

Drying

SITRALOY must be dried prior to processing. Therefore, the granules can absorb moisture during transport and storage (approx.. 0,2% in standard atmospheric conditions)

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

When processing SITRALOY (PC+ABS), 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)
SITRALOY (PC+ABS)	100 -120	4 - 8	2 - 3	2 - 4

Processing

The optimum processing temperature of SITRALOY (PC+ABS) must be determined according to grade and molding and should be between 240 and 280°C (table 2).

Engineering thermoplastic	Mold temperature (°C)	Mold Temperature (°C)
SITRALOY (PC+ABS)	240 - 280	70 - 100

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. 300°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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