



**Document** Process Data for Injection Moulding  
**Description** **PC/ABS**  
**Application** Injection Moulding

Structure	Amorphous
General Properties	High flow, good dimensional and thermal stability.
Barrel Temperature	(decrease 15°C for flame retardant grades, V0/V2/XA/XF/XB)
	Feed Zone 50 – 70 °C
	Zone 1 230 – 250 °C
	Zone 2 240 – 260 °C
	Zone 3 250 – 270 °C
	Zone 4 250 – 270 °C
	Zone 5 250 – 270 °C
	Nozzle 250 – 270 °C
Melt temperature	250 – 270 °C
Mould temperature	70 – 90 °C
Injection pressure	900 – 1500 bar
Post-pressure	Between 40 and 60% of injection pressure, low post-pressure time
Counterpressure	50 – 150 bar
Injection speed	Medium
Screw speed	Equal to peripheric speed of 0.4 m/s
Metering	1 – 3 diameters
Cushion	2 – 5 mm, depends on metering and screw diameter
Drying	4 hours at 80°C
Recycle	20% of regrinded material. This percentage deceases for technical and aesthetic parts. Not recommended for Flame Retardant grade.
Shrinkage	0.4 – 0.7% (for unfilled product)
Barrel equipment	Standard screw, non-return valve, free-flow nozzle
Quenching	Not necessary to purge with other materials, however always empty the barrel. Purge with natural product suggested after Flame Retardant processing.