Isoblend®
Dafneblend®

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

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|---|---|---|
| Structure | Amorphous | |
| Density | 1.12 g/cm$^3$ (unfilled) | |
| General Properties | High flow, good dimensional and thermal stability. | |
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| Barell Temperature | (decrease 15°C for flame retardant grades) | |
| | 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 | Maximum 20% of regrinded material. This percentage deceases for technical and aesthetic parts. | |
| 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. | |

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