Isoclear®
Dafneloy®

Document	Process Data for Injection Moulding
Description	PC
Application	Injection Moulding

Structure	Amorphous	
Density	1.17 g/cm^3 (unfilled)	
General Properties	Hard, high resilience, transparent. High thermal and dimensional stability.	
Barell Temperature	(decrease 15°C for flame retardant grades)	
	Feed Zone	70 – 90 °C
	Zone 1	230 – 270 °C
	Zone 2	260 – 300 °C
	Zone 3	290 – 310 °C
	Zone 4	290 – 310 °C
	Zone 5	290 – 310 °C
	Nozzle	290 – 310 °C
Melt temperature	280 – 310 °C	
Mould temperature	60 – 110 °C	
Injection pressure	1300 – 1800 bar	
Post-pressure	Between 40 and 60% of injection pressure, low post-pressure time	
Counterpressure	100 – 150 bar	
Injection speed	High	
Screw speed	Equal to peripheric speed of 0.6 m/s	
Metering	0.5 – 3.5 diameters	
Cushion	2 – 6 mm, depends on metering and screw diameter	
Drying	Dehumidification for 3 hours at 120°C	
Recycle	10% of regrinded material. This percentage decreases for technical and aesthetic parts.	
Shrinkage	0.5 – 0.8% (for unfilled PC)	
Barrel equipment	Three-sections screw, non-return valve, free-flow nozzle	
Quenching	Turn off barrel heating and purge with PEHD down to 200°C. Purge recommended after flame retardant processing.	

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