

## Injection Molding of EMERGE™ PC/ABS 7500 Advanced Resin

### Drying Recommendations

**Moisture Content:** It is recommended to dry this resin to less than 0.02% moisture.

**Dryer:** A desiccant-type dryer is recommended for this material.

**Dew Point:** -20°F (-30°C) or lower is desired.

**Drying Time:** A minimum of 4 hours at 180-190°F (80-90 °C) is recommended.

### Equipment Specifications

**Shot Size:** As required to fill part.

**Clamp Tonnage:** 2.5-3.0 tons/in<sup>2</sup> (0.35-0.42 tonnes/cm<sup>2</sup>) of projected surface area.

**Barrel Capacity:** 60-70% of machine barrel size should be for part shot.

### Process Conditions

**Melt Temperature:** Can be varied as required to fill part. See Table 1.

**Mold Temperature:** Can be changed to affect gloss or demolding characteristics. See Table 1.

**Manifold/Drop Temperature:** 20-40°F (10-20°C) below melt temperature. See Table 1 for recommended melt temperatures and adjust manifold/drop temperature accordingly.

**Purging/Shutdown:** For short interruptions in production, empty the barrel and reduce barrel temperatures. For extended shutdowns, purge the machine with a purging compound or general purpose polystyrene before shutting down machine.

**Table 1:** Machine Temperature Recommendations

Temperatures	Range, °F (°C)	Aim, °F (°C)
Melt Temperature	460-550 (240-290)	490 (255)
Mold Temperature	140-195 (60-90)	180 (80)
Barrel – Feed	430-480 (220-250)	450 (230)
Barrel – Transition	440-500 (230-260)	460 (240)
Barrel – Metering	460-510 (240-270)	490 (255)
Nozzle	460-510 (240-270)	490 (255)

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.



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