

Injection Molding of CALIBRE™ IM 401-18 Polycarbonate 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. Hopper dryer may also be needed.

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

Drying Time: A minimum of 4 hours at 250°F (120°C) is typical, but dependent on dryer temperature.

Equipment Specifications

Shot Size: As required to fill part.

Clamp Tonnage: 2.0-5.0 tons/in² (0.28-0.70 metric tons/cm²) of projected surface area.

Barrel Capacity: 40-70% 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 demolding characteristics. See Table 1.

Manifold/Drop Temperature: 30-50°F (17-28°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	550-580 (288-304)	565 (296)
Mold Temperature	160-200 (71-93)	180 (82)
Barrel – Feed	470-510 (243-266)	490 (254)
Barrel – Transition	510-550 (266-288)	530 (277)
Barrel – Metering	550-580 (288-304)	565 (296)
Nozzle	530-560 (277-293)	545 (285)

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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North America

U.S. +1-855-TRINSEO (+1-855-874-6736)

U.S. & Canada +1-989-633-1718

Latin America

Brazil +55-11-5184-8722

Argentina, Chile, South Region of LAA +54-11-4319-0100

Mexico, Colombia, North Region of LAA +52-55-5201-4700

Europe/Middle East/Africa +800-444-11-444

+31-11567-2601

Asia Pacific +603-7965-53-19

China +86-21-3851-1017

Email CI@trinseo.com

www.trinseo.com

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