

INJECTION MOLDING OF

PULSE™ 2000EZ PC/ABS

ENGINEERING RESIN



TRINSEO™

TECHNICAL INFORMATION

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 220°F (104 °C), or overnight at 180-200°F (82-93°C).

Equipment Specifications

Shot Size As required to fill part.

Clamp Tonnage 2.5-3.0 tons/in² (0.35-0.42 tonnes/cm²) 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)

Mold Temperature

Can be changed to affect gloss or demolding characteristics. (See Table)

Manifold/Drop Temperature

20-40°F (11-22°C) below melt temperature. See the Table 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.

MACHINE TEMPERATURE

RECOMMENDATIONS

Temperatures	Range, °F (°C)	Aim, °F (°C)
Melt Temperature	500-540 (260-282)	520 (271)
Mold Temperature	160-200 (71-93)	180 (82)
Barrel – Feed	460-500 (238-260)	470 (243)
Barrel – Transition	480-520 (249-271)	500 (260)
Barrel – Metering	480-540 (249-282)	510 (266)
Nozzle	480-520 (249-271)	500 (260)

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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