

APEX™ PROCESSING CONDITIONS

Grade	HMB AJ240 VC240 WB240	MB LMB LB SLB AJ220 AJ210 AJ200 AJ190 VC220 VC210 VC200 VC190 WB220 WB210 WB200 WB190	M17R WB170
Drying	<p style="text-align: center;">4 Hrs @ 250°F (120°C)</p> <p>All polycarbonate resins must be thoroughly dried prior to processing.</p>	<p style="text-align: center;">4 Hrs @ 250°F (120°C)</p> <p>All polycarbonate resins must be thoroughly dried prior to processing.</p>	<p style="text-align: center;">4 Hrs @ 250°F (120°C)</p> <p>All polycarbonate resins must be thoroughly dried prior to processing.</p>
Temperature	<p style="text-align: center;">500-536-572-554°F 260-280-300-290°C</p> <p>Max Temperature: 608°F (320°C)</p>	<p style="text-align: center;">464-500-536-518°F 240-260-280-270°C</p> <p>Max Temperature: 608°F (320°C)</p>	<p style="text-align: center;">464-500-536-518°F 240-260-280-270°C</p> <p>Max Temperature: 608°F (320°C)</p>
Nozzle Temperature	536~572 ℉ (280~300°C)	518~554 ℉ (270~290°C)	518~554 ℉ (270~290°C)
Screw Speed	50~75 rpm	50~75 rpm	50~75 rpm
Injection Pressure	10,000~15,000 psi	10,000~15,000 psi	10,000~15,000 psi
Mold Temperature	158~248 ℉ (70~120°C)	158~248 ℉ (70~120°C)	158~248 ℉ (70~120°C)
Annealing	2~3 Hrs @ 250°F(120°C) if needed.	2~3 Hrs @ 250°F(120°C) if needed.	2~3 Hrs @ 250°F(120°C) if needed.
Others			

※ This information is intended to be used only as a guideline for designers and processors of modified thermoplastics for injection molding. Because injection mold design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

No information supplied above constitute a warranty regarding product performance or use. Any information regarding performance or use is only offered as suggestion for investigation for use, based upon APEX JAPAN co.,ltd. or other customer experience.

It is the responsibility of the customer to determine that product is safe, lawful and technically suitable for the intended use.