

LNPTM ELCRESTM AMS9085

DESCRIPTION

AMS9085 is a specially designed unreinforced polycarbonate copolymer compound that is very well suited for use as support material in 3D printing. Especially in combination with ULTEMTM resin 9085 but also with other high heat printing materials.

GENERAL INFORMATION	
Applications	Prototype
Features	Amorphous, Low Shrinkage, High stiffness/Strength, High temperature resistance, No PFAS intentionally added
Fillers	Unreinforced
Polymer Types	Polycarbonate (PC)
Processing Techniques	Additive manufacturing, 3D printing, Fused Deposition Modeling (FDM) printing, Fibre and Filaments

INDUSTRY	SUB INDUSTRY
Industrial	Additive Manufacturing

TYPICAL PROPERTY VALUES

Revision 20240314

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL (1)			
Tensile Modulus, 1 mm/min	2400	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	70	MPa	ISO 527
Tensile Stress, break, 50 mm/min	61	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Nominal Strain, break, 50 mm/min	80	%	ISO 527
Flexural Modulus, 2 mm/min	2400	MPa	ISO 178
Flexural Strength, 2 mm/min	104	MPa	ISO 178
Tensile Modulus, 50 mm/min	2200	MPa	ASTM D638
Tensile Stress, yld, Type I, 50 mm/min	70	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	62	MPa	ASTM D638
Tensile Nominal Strain, brk, Type I, 50 mm/min	65	%	ASTM D638
Flexural Modulus, 1.3 mm/min, 50 mm span	2500	MPa	ASTM D790
Flexural Strength, 1.3 mm/min, 50 mm span	104	MPa	ASTM D790
IMPACT (1)			
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
Izod Impact, unnotched 80*10*4 +23°C	137	kJ/m²	ISO 180/1U
Izod Impact, notched, 23°C	71	J/m	ASTM D256
Izod Impact, unnotched, 23°C	1690	J/m	ASTM D4812
THERMAL (1)			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	159	°C	ISO 75/Af
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	173	°C	ISO 75/Bf
Vicat Softening Temp, Rate B/50	180	°C	ISO 306



Vact Softening Temp, Rate B/120 180 °C RO 300 CTE, 23°C to 50°C, flow 6.585 1,°C 80 11559-2 HDT, 132 MPs, 3.2mm, unannealed 157 °C ASTM D648 HDT, 132 MPs, 3.2mm, unannealed 172 °C ASTM D648 HDT, 045 MPs, 3.2 mm, unannealed 172 °C ASTM D1525 Vicat Softening Temp, Rate B/120 180 °C ASTM D1525 Vicat Softening Temp, Rate B/120 180 °C ASTM D1525 Vicat Softening Temp, Rate B/120 180 °C ASTM D1525 Vicat Softening Temp, Rate B/120 180 °C ASTM D1525 Vicat Softening Temp, Rate B/120 180 °C ASTM D1525 Vicat Softening Temp, Rate B/120 180 °C ASTM D1525 CTC, 23°C to So°C, flow 5.58 9.0 ASTM D1525 CTC, 23°C to So°C, flow 1.15 8.0 8.0 8.0 8.0 8.0 8.0 8.0 8.0 8.0 8.0 8.0 8.0 8.0 8.0 8.0 8.0	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, 23°C to 50°C, filow 6.5E5 1,°C 80 1359.2 CTE, 23°C to 50°C, filow 6.5E9 1,°C 80 1359.2 HDT, 1.32 MPA, 3.2 mm, unannealed 172 °C ASTM D648 HDT, 0.45 MPA, 3.2 mm, unannealed 180 °C ASTM D648 Vicat Softening Temp, Rate B J50 180 °C ASTM D1525 CTE, 23°C to 50°C, flow 5.5E9 1,°C ASTM B831 CTE, 23°C to 50°C, flow 5.5E9 1,°C ASTM B831 CTE, 23°C to 50°C, flow 1.15 g/cm MSI 183 PHYSICAL*** 1.15 g/cm 150 62.4 Moisture Absorption, (23°C/50% RH/24hn) 0.16 % 50 62.4 Moisture Absorption, (23°C/50% RH/24hn) 0.18 % 50 62.4 Water Absorption, (23°C/50% RH/24hn) 0.18 % 50 62.4 Water Absorption, (23°C/50% RH/24hn) 0.18 % 50 62.4 Water Absorption, (23°C/50% RH/24hn) 0.18 % ASTM D702 Water Absorption, (23°C/50% RH/24hn) 0.18 % ASTM D702	Vicat Softening Temp, Rate B/120	180	°C	ISO 306
HDT. 1.82 MPa 3.2 mm, unanneeled 172 °C ASTM D648 HDT. 0.45 MPa 3.2 mm, unanneeled 172 °C ASTM D648 Vicat Softening Temp, Rate B/50 180 °C ASTM D1525 Vicat Softening Temp, Rate B/120 180 °C ASTM D1525 CTC, 23°C to 50°C, flow 55-5 1,°C ASTM B831 CTC, 23°C to 50°C, flow 55-5 1,°C ASTM B831 CTC, 23°C to 50°C, flow 55-5 1,°C ASTM B831 CTC, 23°C to 50°C, flow 50 15-5 1,°C ASTM B831 Mosture Absorption, (23°C/50K RH/24hrs) 0.16 % 50 62-4 Moisture Absorption, (23°C/50K RH/Equilibrium) 0.35 % ASTM D570 Vater Absorption, (23°C/50K RH/Equilibrium) 0.35 % ASTM D570 Vater Absorption, (23°C/50K RH/Equilibrium) 0.35 % ASTM D570 Vater Absorption, (23°C/50K RH/Equilibrium) 0.36 % ASTM D570 Vater Absorption, (23°C/50K RH/Equilibrium) 0.36 % ASTM D570 Water Absorption, (23°C/50K RH/Equilibrium)<	CTE, 23°C to 50°C, flow	6.5E-5	1/°C	ISO 11359-2
HDT. 1.82 MPa 3.2 mm, unanneeled 172 °C ASTM D648 HDT. 0.45 MPa 3.2 mm, unanneeled 172 °C ASTM D648 Vicat Softening Temp, Rate B/50 180 °C ASTM D1525 Vicat Softening Temp, Rate B/120 180 °C ASTM D1525 CTC, 23°C to 50°C, flow 55-5 1,°C ASTM B831 CTC, 23°C to 50°C, flow 55-5 1,°C ASTM B831 CTC, 23°C to 50°C, flow 55-5 1,°C ASTM B831 CTC, 23°C to 50°C, flow 50 15-5 1,°C ASTM B831 Mosture Absorption, (23°C/50K RH/24hrs) 0.16 % 50 62-4 Moisture Absorption, (23°C/50K RH/Equilibrium) 0.35 % ASTM D570 Vater Absorption, (23°C/50K RH/Equilibrium) 0.35 % ASTM D570 Vater Absorption, (23°C/50K RH/Equilibrium) 0.35 % ASTM D570 Vater Absorption, (23°C/50K RH/Equilibrium) 0.36 % ASTM D570 Vater Absorption, (23°C/50K RH/Equilibrium) 0.36 % ASTM D570 Water Absorption, (23°C/50K RH/Equilibrium)<	CTE, 23°C to 50°C, xflow	6.5E-5	1/°C	ISO 11359-2
Vicat Softening Temp, Rate 8/100 180 °C ASTM D1525 CTE, 23°Cto 50°C, flow 656-5 1/°C ASTM E831 CTE, 23°Cto 50°C, flow 656-5 1/°C ASTM E831 CTE, 23°Cto 50°C, flow 565-5 1/°C ASTM E831 PHYSICAL*** Use of 50°C, flow 1.15 50°C \$18.0 Moisture Absorption, (23°C/50% RH/Equillibrium) 1.8 \$0.62.4 Moisture Absorption, (23°C/50% RH/Equillibrium) 0.18 \$0.62.4 Moisture Absorption, (23°C/50% RH/Equillibrium) 0.18 \$0.62.1 Water Absorption, (23°C/50% RH/Equillibrium) 0.18 \$0.62.1 <tr< th=""><th></th><th>157</th><th>°C</th><th>ASTM D648</th></tr<>		157	°C	ASTM D648
Vicat Softening Temp, Rate 8/120 180 °C ASTM D1525 CTE, 23°C to 50°C, flow 5.55 1/°C ASTM E831 CTE, 23°C to 50°C, flow 5.55 1/°C ASTM E831 CTE, 23°C to 50°C, flow 5.55 1/°C ASTM E831 Physical, Cli V V V Boilty Cli 1.15 g/cm² 80 183 Molsture Absorption, (23°C/50% RH/Equilibrium) 0.16 \$ 80 62-4 Molety Absorption, (23°C/50% RH/Equilibrium) 0.18 \$ 80 62-4 Water Absorption, (23°C/50% RH/Equilibrium) 0.18 \$ 80 62-4 Water Absorption, (23°C/50% RH/Equilibrium) 0.18 \$ 80 62-4 Water Absorption, (23°C/24hry) 0.18 \$ 80 62-4 Water Absorption, (23°C/24hry) 0.18 \$ 80 70 70 Water Absorption, (23°C/24hry) 1.5 \$ 80 70 70 Water Absorption, (23°C/24hry) 1.5 \$ \$ Water Absorption, (23°C/24hry) 2.0 \$ \$ Water Absorption, (23°C/24hr	HDT, 0.45 MPa, 3.2 mm, unannealed	172	°C	ASTM D648
CTE, 23°C to 50°C, flow 6.5E5 1/°C ASTM E831 CTE, 23°C to 50°C, flow 6.5E5 1/°C ASTM E831 PHYSICAL ⁽¹⁾ V ASTM E831 PHYSICAL ⁽¹⁾ V SD of E831 Boilsture Absorption, (23°C/50% RH/Equilibrium) 0.16 % 150 62-4 Moisture Absorption, (23°C/50% RH/Equilibrium) 0.18 % 150 62-4 Water Absorption, (23°C/50x RH/Equilibrium) 0.18 % 150 62-4 Water Absorption, (23°C/54mrsded) 0.15 % ASTM D970 Water Absorption, (23°C/54mrsded) 0.18 % C Water Absorption, (23°C/54mrsded) 0.18 % C Water Absorption, (23°C/54mrs	Vicat Softening Temp, Rate B/50	180	°C	ASTM D1525
CTE, 23°C to 50°C, xiflow 6.5E5 1°C ASTMERAIS PHYSICAL ⁽¹⁾ FUNDALIS 1°C ASTMERAIS Density 1.5 g/cm² 50 183 Moisture Absorption, (23°C/50% RH/Equilibrium) 0.16 30 62-4 Water Absorption, (23°C/50% RH/Equilibrium) 0.18 30 62-4 Water Absorption, (23°C/50% RH/Equilibrium) 0.15 30 62-4 Water Absorption, (23°C/54mrated) 0.15 30 70 37M D792 Water Absorption, (23°C/54mrated) 0.06 30 70 37M D792 37M D792	Vicat Softening Temp, Rate B/120	180	°C	ASTM D1525
Physical. (*) Poensity 1.15 g/cm³ \$0.183 Moisture Absorption, (23°C/50% RH/Equilibrium) 0.16 % \$0.624 Moisture Absorption, (23°C/50% RH/Equilibrium) 0.18 \$0.624 Water Absorption, (23°C/54 RH/Equilibrium) 0.35 \$0.624 Specific Cravity 0.15 4 \$0.624 Water Absorption, (23°C/54sturated) 0.18 \$0.024 \$150 Water Absorption, (23°C/54sturated) 0.18 \$150 \$150 Water Absorption, (23°C/54sturated) 0.18 \$150 \$150 Water Absorption, (23°C/54sturated) 0.28 \$150 \$150 \$150 \$150 \$150 \$150 \$150 \$150	CTE, 23°C to 50°C, flow	6.5E-5	1/°C	ASTM E831
Density 1.15 g/m² ISO 183 Moisture Absorption, (23°C/50K RH/24hrs) 0.16 % 50 624 Moisture Absorption, (23°C/50K RH/Equilibrium) 0.18 % 50 624 Water Absorption, (23°C/50K RH/Equilibrium) 0.35 % 60 624 Water Absorption, (23°C/24hrs) 0.18 % ASTM D792 Water Absorption, (23°C/24hrs) 0.28 ASTM D792 ASTM D792 Water Absorption, (23°C/24hrs) 0.28 ASTM D792 ASTM D792 Water Absorption, (23°C/24hrs) 0.28 C C C C C C C C C C C C C C C C C <th>CTE, 23°C to 50°C, xflow</th> <th>6.5E-5</th> <th>1/°C</th> <th>ASTM E831</th>	CTE, 23°C to 50°C, xflow	6.5E-5	1/°C	ASTM E831
Moisture Absorption, (23°C/50% RH/24lrish) 0.16 \$ 150 62-4 Moisture Absorption, (23°C/50% RH/Equilibrium) 0.18 \$ 150 62-4 Water Absorption, (23°C/54lryated) 0.15 2 ATM D570 Water Absorption, (23°C/24hrs) 0.18 3 ATM D570 Water Absorption, (23°C/54lryated) 0.18 2 C Bigging Target (23°C/54lryated) 4 6 1 C C C C C C C C C C C C C C <th>PHYSICAL (1)</th> <th></th> <th></th> <th></th>	PHYSICAL (1)			
Moisture Absorption, (23°C/50% RH/24lrish) 0.16 \$ 150 62-4 Moisture Absorption, (23°C/50% RH/Equilibrium) 0.18 \$ 150 62-4 Water Absorption, (23°C/54lryated) 0.15 2 ATM D570 Water Absorption, (23°C/24hrs) 0.18 3 ATM D570 Water Absorption, (23°C/54lryated) 0.18 2 C Bigging Target (23°C/54lryated) 4 6 1 C C C C C C C C C C C C C C <th></th> <th>1.15</th> <th>g/cm³</th> <th>ISO 1183</th>		1.15	g/cm³	ISO 1183
Water Absorption, (23°C/saturated) 0.35 % ISO 62-1 Specific Gravity 0.15 - ASTM D792 Water Absorption, (23°C/24hrs) 0.18 % ASTM D570 Water Absorption, (23°C/Saturated) 0.35 % ASTM D570 INJECTION MOLDING (23°C/Saturated) - *** *** *** *** *** *** *** *** *** *** *** *** ** ***	Moisture Absorption, (23°C/50% RH/24hrs)	0.16		ISO 62-4
Specific Gravity 0.15 ∴ ASTM D792 Water Absorption, (23°C/24hrs) 0.18 % ASTM D570 Water Absorption, (23°C/35turated) 0.35 % ASTM D570 INJECTION MOLDING (3) Typing Temperature Drying Temperature 135 °C	Moisture Absorption, (23°C/50% RH/Equilibrium)	0.18	%	ISO 62-4
Water Absorption, (23°C/24hrs) 0.18 \$ ASTM D570 Water Absorption, (23°C/25aturated) 0.35 % ASTM D570 INJECTION MOLDING (3) Drying Temperature 135 *C C Drying Time 4 − 6 Hris C C Melit Temperature 300 − 340 *C C	Water Absorption, (23°C/saturated)	0.35	%	ISO 62-1
Nater Absorption, (23°C/Saturated) 0.35 % ASTM D570 INJECTION MOLDING (2) C	Specific Gravity	0.15	-	ASTM D792
INIECTION MOLDING (²) Drying Temperature 135 °C Drying Time 4 − 6 Hrs Maximum Moisture Content 0.06 % Melt Temperature 320 − 340 °C Rear - Zone 1 Temperature 320 − 340 °C Middle - Zone 2 Temperature 320 − 340 °C Front - Zone 3 Temperature 300 − 320 °C Mozel Temperature 120 − 140 °C Mold Temperature 120 − 140 °C Back Pressure 0.2 − 0.7 Mra EXTRUSION T Drying Time 4 − 6 Hrs Maximum Moisture Content 0.02 % Melt Temperature 290 − 330 °C Nozzle Temperature 290 − 330 °C Nozzle Temperature 290 − 330 °C Barrel - Zone 3 Temperature 280 − 320 °C Barrel - Zone 2 Temperature 280 − 320 °C Barrel - Zone 2 Temperature 270 − 310 °C	Water Absorption, (23°C/24hrs)	0.18	%	ASTM D570
Drying Temperature 135 C Drying Time 4 - 6 Hrs Maximum Moisture Content 0.06 % Melt Temperature 320 - 340 C Rear - Zone 1 Temperature 320 - 340 C Middle - Zone 2 Temperature 320 - 340 C Front - Zone 3 Temperature 310 - 330 C Mold Temperature 300 - 320 C Mold Temperature 120 - 140 C Back Pressure 0.2 - 0.7 MPa Drying Temperature 135 C Drying Time 4 - 6 Hrs Maximum Moisture Content 90 - 330 C Melt Temperature 290 - 330 C Rozzle Temperature 290 - 330 C Barrel - Zone 3 Temperature 290 - 330 C Barrel - Zone 2 Temperature 280 - 320 C Barrel - Zone 2 Temperature 280 - 320 C Barrel - Zone 1 Temperature 290 - 330 C	Water Absorption, (23°C/Saturated)	0.35	%	ASTM D570
Drying Time 4 - 6 Hrs Maximum Moisture Content 0.06 % Melt Temperature 320 - 340 °C Rear - Zone 1 Temperature 320 - 340 °C Middle - Zone 2 Temperature 320 - 340 °C Front - Zone 3 Temperature 310 - 330 °C Nozzle Temperature 120 - 140 °C Back Pressure 0.2 - 0.7 MPa EXTRUSION VC Drying Temperature 135 °C Drying Time 4 - 6 Hrs Maximum Moisture Content 0.02 % Melt Temperature 290 - 330 °C Nozzle Temperature 290 - 330 °C Barrel - Zone 3 Temperature 290 - 330 °C Barrel - Zone 2 Temperature 280 - 320 °C Barrel - Zone 1 Temperature 280 - 320 °C	INJECTION MOLDING (2)			
Maximum Moisture Content 0.06 % Melt Temperature 320 – 340 °C Rear - Zone 1 Temperature 320 – 340 °C Middle - Zone 2 Temperature 320 – 340 °C Front - Zone 3 Temperature 310 – 330 °C Nozzle Temperature 300 – 320 °C Mold Temperature 120 – 140 °C Back Pressure 0.2 – 0.7 MPa EXTRUSION *C Drying Temperature 4 – 6 Hrs Maximum Moisture Content 0.02 % Melt Temperature 290 – 330 °C Nozzle Temperature 290 – 330 °C Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 270 – 310 °C	Drying Temperature	135	°C	
Melt Temperature 320 – 340 °C Rear - Zone 1 Temperature 320 – 340 °C Middle - Zone 2 Temperature 320 – 340 °C Front - Zone 3 Temperature 310 – 330 °C Nozzle Temperature 300 – 320 °C Mold Temperature 120 – 140 °C Back Pressure 0.2 – 0.7 Mra EXTRUSION *C Drying Temperature 135 °C Drying Time 4 – 6 Hrs Maximum Moisture Content 0.02 % Melt Temperature 290 – 330 °C Nozzle Temperature 290 – 330 °C Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 280 – 320 °C	Drying Time	4 – 6	Hrs	
Rear - Zone 1 Temperature 320 – 340 °C Middle - Zone 2 Temperature 320 – 340 °C Front - Zone 3 Temperature 310 – 330 °C Nozzle Temperature 300 – 320 °C Mold Temperature 120 – 140 °C Back Pressure 0.2 – 0.7 MPa EXTRUSION C Drying Temperature 135 °C Maximum Moisture Content 4 – 6 Hrs Maximum Moisture Content 0.02 % Melt Temperature 290 – 330 °C Nozzle Temperature 290 – 330 °C Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 270 – 310 °C	Maximum Moisture Content	0.06	%	
Middle - Zone 2 Temperature 320 - 340 °C Front - Zone 3 Temperature 310 - 330 °C Nozzle Temperature 300 - 320 °C Mold Temperature 120 - 140 °C Back Pressure 0.2 - 0.7 MPa EXTRUSION *C Drying Temperature 135 °C Drying Time 4 - 6 Hrs Maximum Moisture Content 0.02 % Melt Temperature 290 - 330 °C Nozzle Temperature 290 - 330 °C Barrel - Zone 3 Temperature 290 - 330 °C Barrel - Zone 2 Temperature 280 - 320 °C Barrel - Zone 1 Temperature 270 - 310 °C	Melt Temperature	320 – 340	°C	
Front - Zone 3 Temperature 310 – 330 °C Nozzle Temperature 300 – 320 °C Mold Temperature 120 – 140 °C Back Pressure 0.2 – 0.7 MPa EXTRUSION C Drying Temperature 135 °C Drying Time 4 – 6 Hrs Maximum Moisture Content 0.02 % Melt Temperature 290 – 330 °C Nozzle Temperature 290 – 330 °C Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 270 – 310 °C	Rear - Zone 1 Temperature	320 – 340	°C	
Nozzle Temperature 300 – 320 °C Mold Temperature 120 – 140 °C Back Pressure 0.2 – 0.7 MPa EXTRUSION "C Drying Temperature 135 °C Maximum Moisture Content 0.02 % Melt Temperature 290 – 330 °C Nozzle Temperature 290 – 330 °C Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 280 – 320 °C	Middle - Zone 2 Temperature	320 – 340	°C	
Mold Temperature 120 – 140 °C Back Pressure 0.2 – 0.7 MPa EXTRUSION °C Drying Temperature 135 °C Drying Time 4 – 6 Hrs Maximum Moisture Content 0.02 % Melt Temperature 290 – 330 °C Nozzle Temperature 290 – 330 °C Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 270 – 310 °C	Front - Zone 3 Temperature	310 – 330	°C	
Back Pressure 0.2 – 0.7 MPa EXTRUSION Drying Temperature 135 °C Drying Time 4 – 6 Hrs Maximum Moisture Content 290 – 330 °C Nozzle Temperature 290 – 330 °C Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 1 Temperature 270 – 310 °C Barrel - Zone 1 Temperature 270 – 310 °C	Nozzle Temperature	300 – 320	°C	
EXTRUSIONDrying Temperature135°CDrying Time4-6HrsMaximum Moisture Content0.02%Melt Temperature290-330°CNozzle Temperature290-330°CBarrel - Zone 3 Temperature290-330°CBarrel - Zone 2 Temperature280-320°CBarrel - Zone 1 Temperature270-310°C	Mold Temperature	120 – 140	°C	
Drying Temperature 135 °C Drying Time 4 - 6 Hrs Maximum Moisture Content 0.02 % Melt Temperature 290 - 330 °C Nozzle Temperature 290 - 330 °C Barrel - Zone 3 Temperature 290 - 330 °C Barrel - Zone 2 Temperature 280 - 320 °C Barrel - Zone 1 Temperature 270 - 310 °C	Back Pressure	0.2 – 0.7	MPa	
Drying Time 4−6 Hrs Maximum Moisture Content 0.02 % Melt Temperature 290−330 °C Nozzle Temperature 290−330 °C Barrel - Zone 3 Temperature 290−330 °C Barrel - Zone 2 Temperature 280−320 °C Barrel - Zone 1 Temperature 270−310 °C	EXTRUSION			
Maximum Moisture Content 0.02 % Melt Temperature 290 – 330 °C Nozzle Temperature 290 – 330 °C Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 270 – 310 °C	Drying Temperature	135	°C	
Melt Temperature 290 – 330 °C Nozzle Temperature 290 – 330 °C Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 270 – 310 °C	Drying Time	4 – 6	Hrs	
Nozzle Temperature 290 – 330 °C Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 270 – 310 °C	Maximum Moisture Content	0.02	%	
Barrel - Zone 3 Temperature 290 – 330 °C Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 270 – 310 °C	Melt Temperature	290 – 330	°C	
Barrel - Zone 2 Temperature 280 – 320 °C Barrel - Zone 1 Temperature 270 – 310 °C	Nozzle Temperature	290 – 330	°C	
Barrel - Zone 1 Temperature 270 – 310 °C	Barrel - Zone 3 Temperature	290 – 330	°C	
·	Barrel - Zone 2 Temperature	280 – 320	°C	
Die Temperature 110 − 130 °C	Barrel - Zone 1 Temperature	270 – 310	°C	
	Die Temperature	110 – 130	°C	

⁽¹⁾ The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

⁽²⁾ Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.



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