



PROCESSING GUIDE

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Revision : 001
Rev. Date : Sept 2014

4TECH[®] Polyamide (PA 6)

PROCESSING CONDITIONS

	Unreinforced	Impact Modified	Reinforced	Flame Retardant
Drying (°C/Hour)	80/2*	80/2*	80/2*	80/2*
Maximum Moisture Content (%)	0.2	0.2	0.2	0.2
Feed Throat Temperature (°C)	60 - 80	60 - 80	60 - 80	60 - 80
Processing Temperature (°C)	240 - 260	230 - 260	250 - 270	230 - 250
Mould Temperature (°C)	70 - 90	70 - 90	60 - 100	40 - 90
Hold Pressure (MPa)	50 - 100	50 - 100	50 - 100	50 - 100
Back Pressure	Low	Low	Low	Low
Injection Speed	Medium - Fast	Medium - Fast	Fast	Medium - Fast
Maximum Screw Speed (rpm)	400	400	200	200

*Products in moisture proof packs do not need pre-drying

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Test Values: Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/ die, the processing conditions and the colouring.