



## PROCESSING GUIDE

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### 4TECH<sup>®</sup> Polyphthalamide (PPA)

#### PROCESSING CONDITIONS

|                                     | <b>Unreinforced</b> | <b>Impact Modified</b> | <b>Reinforced</b> | <b>Flame Retardant</b> |
|-------------------------------------|---------------------|------------------------|-------------------|------------------------|
| <b>Drying (°C/Hour)</b>             | 120/4               | 120/4                  | 120/4             | 120/4                  |
| <b>Maximum Moisture Content (%)</b> | 0.2                 | 0.2                    | 0.2               | 0.2                    |
| <b>Feed Throat Temperature (°C)</b> | 60 - 80             | 60 - 80                | 60 - 80           | 60 - 80                |
| <b>Processing Temperature (°C)</b>  | 320 - 340           | 320 - 330              | 320 - 340         | 320 - 330              |
| <b>Mould Temperature (°C)</b>       | 70 - 90             | 70 - 90                | 140 - 180         | 140 - 180              |
| <b>Hold Pressure (MPa)</b>          | 40 - 80             | 40 - 80                | 40 - 80           | 40 - 80                |
| <b>Back Pressure</b>                | Low                 | Low                    | Low               | Low                    |
| <b>Injection Speed</b>              | Medium - Fast       | Low - Medium           | Fast              | Medium - Fast          |
| <b>Maximum Screw Speed (rpm)</b>    | 400                 | 400                    | 200               | 200                    |

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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.