



## PROCESSING GUIDE

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### 4MID<sup>®</sup> Polyamide (PA 6.6)

#### PROCESSING CONDITIONS

	<b>Unreinforced</b>	<b>Impact Modified</b>	<b>Reinforced</b>	<b>Flame Retardant</b>
<b>Drying (°C/Hour)</b>	80/2*	80/2*	80/2*	80/2*
<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>	270 - 290	260 - 290	270 - 300	260 - 180
<b>Mould Temperature (°C)</b>	50 - 90	50 - 90	70 - 110	50 - 100
<b>Hold Pressure (MPa)</b>	50 - 100	50 - 100	50 - 100	50 - 100
<b>Back Pressure</b>	Low	Low	Low	Low
<b>Injection Speed</b>	Medium - Fast	Medium - Fast	Fast	Medium - Fast
<b>Maximum Screw Speed (rpm)</b>	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.