



**4MID<sup>®</sup>** is the registered trade name for Polyamide (PA) compounds produced by 4PLAS.

### PROCESSING

For polyamide compounds, moisture content should be less than 0.2% before processing. **4MID<sup>®</sup>** compounded grades are manufactured with a maximum moisture content of 0.1%, therefore products in moisture proof packs do not need pre-drying prior to processing.

As polyamides are hygroscopic and absorb moisture from the environment, materials stored in open packs or containers should be dried at 80°C for a minimum of 2 hours.

**4MID<sup>®</sup>** compounds can be processed on all commercial injection moulding machinery. Guide recommendations for processing parameters are detailed below:

Detailed processing conditions specific for each type of product are available upon request.

### RECYCLING

Regrind levels up to 25% can be used depending on the application and requirements. However, for flame retardant grades a maximum 10% addition rate is recommended. Regrind should be clean and free of contamination, should not be thermally degraded and must be dry as moulded, or be dried prior to reuse.

### SAFETY

Under normal conditions **4MID<sup>®</sup>** is not a toxic or hazardous material. During processing preventative action should be taken to avoid direct contact with the polymer melt or inhalation of any gases produced. Processing temperatures above 320°C should be avoided. Detailed safety information can be found in our material safety data sheets (MSDS).

	Processing Temperature (°C)	Mould Temperature (°C)	Hold Pressure (MPa)	Back Pressure
<b>4MID<sup>®</sup> A</b> (PA 6.6)	270 - 300	50 - 110	50 - 100	Low
<b>4MID<sup>®</sup> B</b> (PA 6)	250 - 280	50 - 110	50 - 100	Low
<b>4MID<sup>®</sup> AB</b> (PA 6.6/6)	260 - 290	50 - 110	50 - 100	Low