

#### Product description

Long glass-fiber-reinforced injection moulding grade for industrial articles having very high rigidity.

#### Physical form and storage

The product is supplied in the form of granules with a bulk density of approx. 0.7 g/cm<sup>3</sup>. Standard packs are bag and bulk container (octagonal IBC=intermediate bulk container made from corrugated board with a liner bag). Other packaging materials and shipping in road or rail silo wagons are possible by agreement. The containers should only be opened immediately before processing or drying. To ensure that the delivered product absorbs as little moisture as possible, the containers should be stored in dry rooms and always carefully closed again after partial quantities have been withdrawn. In principle, the product can be stored for a long period of time. Containers stored in cold rooms should be equalized to ambient temperature before opening in order to avoid condensation on the granules. Regardless of the storage conditions, the product should be pre-dried according to our recommendations and the machine should preferably be loaded using a closed conveyor system.

#### Product safety

In case processing is done under conditions as recommended (cf. processing data sheet) melts are thermally stable and do not generate hazards by molecular degradation or the evolution of gases and vapors. Like all thermoplastic polymers the product decomposes on exposure to excessive thermal load, e.g. when it is overheated or as a result of cleaning by burning off. Further information is available from the safety data sheet.

#### Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed. In order to check the availability of products please contact us or our sales agency.

## Processing Data Sheet

	Test method	Unit	Values
<b>Properties</b>			
Polymer abbreviation	-	-	<b>PA66-GLF60</b>
<b>Drying</b>			
Moisture, recommended <sup>1)</sup>	-	%	<b>0.03 - 0.06</b>
Dryer temperature <sup>2)</sup>	-	°C	<b>80</b>
Drying time <sup>3)</sup>	-	h	<b>4</b>
<b>Injection molding</b>			
Melt temperature range	-	°C	<b>290 - 310</b>
Melt temperature, optimal	-	°C	<b>300</b>
Mold temperature range	-	°C	<b>80 - 90</b>
Mold temperature, optimal	-	°C	<b>80</b>
Residence time, max.	-	min	<b>10</b>
<b>Machine Settings</b>			
Temperature hopper throat	-	°C	<b>80</b>
Cylinder temperature 1 (feed zone)	-	°C	<b>300</b>
Cylinder temperature 2 (compression)	-	°C	<b>300</b>
Cylinder temperature 3 (metering-zone, in front of the screw)	-	°C	<b>300</b>
Cylinder temperature 4 (nozzle)	-	°C	<b>300</b>
Peripheral screw speed	-	m/s	<b>0.3</b>
<b>Shrinkage</b>			
Molding shrinkage (parallel)	ISO 294-4	%	<b>0.41</b>
Molding shrinkage (normal)	ISO 294-4	%	<b>0.63</b>
Processing shrinkage, constrained, longitudinal (TM = 300 °C, TW = 100 °C) <sup>4)</sup>	-	%	<b>0.32</b>

### Footnotes

- 1) Excessive drying of the granules may lead to an increase of melt viscosity during processing.
- 2) Dry air dryer; drying time is dependent on the initial moisture content of the granules, drying temperature and the dew point of the dried air.
- 3) In case of improper storage (e.g. open packages) drying time may have to be extended.
- 4) Model housing with central sprue, measures of the base: 107 x 47 x 1.5 mm.

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## Processing Data Sheet

### Material conveying system

Large pipe diameters are better, avoid sharp bends and directional changes  
Processing of warm material, is an advantage

### Feed hopper

Steep sided, avoid sudden changes of the throat-section and built-in components like magnets

### Screw

Preferred diameter 30 mm  
Standard three-section screw (see also Ultramid brochure)  
No mixing rings - or sheering elements recommended

### Machine nozzle

Open, large diameter

### Back-flow return valve

Flow enhanced (see also Ultramid brochure)

### Machine set up

Melt front velocity/ injection speed slow to moderate  
Keep back pressure low with slow screw speed, keep shear low

### Gating and mould

Flow enhancing layout  
Hot runner with open nozzle or shut off valve nozzle (no internal tip)  
Wear protected, hardened replaceable inserts in the gate area  
Good mould venting especially at split lines, and moving cores

### Reprocessing

It is not recommended to reprocess moulded parts and sprues, this leads to reduced fibre length