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北化院北研科技

BEIHUAYUAN BEIYAN TECHNOLOGY

广东北研新材料科技有限公司

GUANGDONG BEIYAN NEW MATERIALS TECHNOLOGY CO., LTD.

PA66 BY301G30F

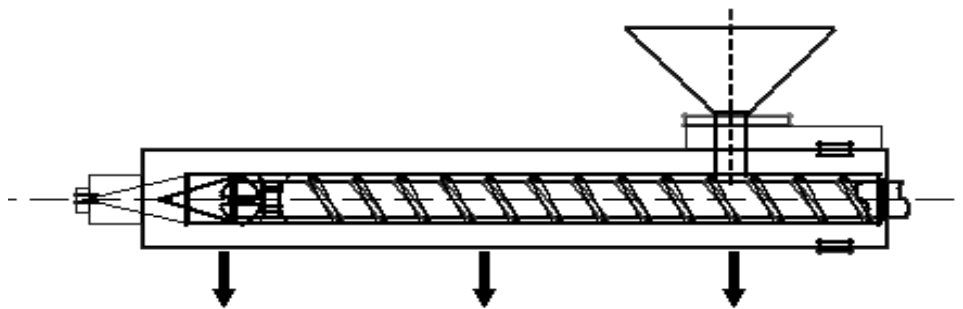
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Processing conditions

A. Pre-drying 100 ~ 120 °C x 4 ~ 6 hrs.

- Depending on
 - a) Humidity
 - b) Recycled material ratio
 - c) Storage conditions

B. Barrel Setting Profile



Condition	Nozzle	Compression zone	Feeding zone	Mold Temperature
max. (°C)	290	280	265	90~120 °C
mix. (°C)	260	250	235	

NOTE:

1. Keep the resin from dust and contamination during handling and production.
2. Do not retain the hot melt at the barrel for a long time between injection cycles.
3. Temperature setting of manifold system should not exceed 300°C to avoid melt from degrading.
4. Purging: Heat decomposing resin are not recommended for purging the residual PA66 resin in barrel of injection machine and extruder. Polyethylene and polypropylene are the most commonly used heat stable resins for purging purpose.

If you have any questions, please contact the technical department at 13827276006 Mr. Luo.

Note: The above statement is based on our current level of knowledge. The above recommended processing conditions should be adjusted according to the specific equipment. Beiyuan does not make any express or implied warranty for any use of the above information, nor does it assume any responsibility. All condition data are for reference only.

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