performanceplastics

Suggested Start Up Conditions for Injection Moulding

Type of Material	Grade	Drying Temp°C	Drying Time h	Melt Temp°C	Nozzle°C	Rear°C	Tool Temp°C
Nylon 6 unfilled	Badamid B70 S	65	2-4	240-260	240-260	220	60-80
FR Nylon 6 unfilled	Badamid B70 FR HF	80	2-4	240-255	240-255	220	60-80
Nylon 6 filled	Badamid B70 GF30	80	2-4	260-280	260-280	240	75-100
Nylon 66 unfilled	Badamid A70 S	65	2-4	280-300	280-300	260	60-80
FR Nylon 66 unfilled	Badamid A70 FR HF	80	2-4	280-300	280-300	240	60-80
Nylon 66 filled	Badamid A70 GF30	80	2-4	285-305	285-305	260	80-110
FR Nylon 66 filled	Badamid A70 GF25 FR HF	80	2-4	280-300	280-300	240	60-80
Acetal unfilled	Kocetal K300	80	3-4	190-200	190-200	160-180	60-80
Acetal filled	Kocetal GF706	80	3-4	200-220	200-220	170-190	70-120
PBT unfilled	Badadur PBT8	110-130	2-4	240-250	240-250	235-250	80-100
PBT filled	Badadur PBT8 GF30	110-130	2-4	250-270	250-270	250	80-100
FR PBT Filled	Tarolox 10H G6 X0	120-130	2-4	230-270	230-270	230-240	80-110
PPS filled	Torelina A504 X90	130-150	2-4	320-335	300-325	295-310	135-150
ABS	LG HI 121H	80-90	3-5	230-240	230-240	210-220	40-80
FR ABS	LG AF312	80-90	3-5	200-210	200-210	180-190	40-80
FR PC / ABS	Taroblend 45 X0	80-100	2-3	230-250	230-250	220-230	50-70
Poly carb	Trirex 3022U	120	3-4	290-310	280-315	260-280	65-105
FR poly carb	2500 W X0	120-130	3-4	250-290	270-290	250-260	90-110
FR filled poly carb	2500 W G2 X0	120-130	3-4	250-290	270-290	250-260	100-120
Poly prop	PPC 5660	N/A	N/A	220-260	220-240	180-200	20-40
FR Poly prop	Nilene E V0 LSZH	80-90	1	190-220	190-220	180-190	40-60
Nylon 12 unfilled	Badamid PA12	80	2-4	240-260	240-260	220-240	60-80
Nylon 12 filled	Badamid PA12 GF30	80	2-4	270-290	270-290	240-260	60-80
PPA (high temp nylon)	Badamid T70 GF50 HH	80-100	2-4	310-340	320-330	295-310	80-110
PVDF	Dyneon 6008	N/A	N/A	220-240	220-240	190-200	60-90
Poly Urethane (TPU)	Elastollan 1195 A	90-120	2-3	205-20	210-225	190-220	40-60

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