

Stanyl®

PA46

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GRADE CODING

Stanyl PA46 non-reinforced and non-flame-retardant injection molding grades.

INTRODUCTION

The objective of this document is to provide the support to the injection molding guide, related or possible quality issues of processing Stanyl® injection molding grades.

OVERALL ASSESSMENT OF GOOD MOLDING PRACTICE

An effective assessment for good molding practice (that shows limited degradation of the polymer) is to measure the drop in relative viscosity number (VN) from granules to molded part. Good molding practice is characterized by an VN drop up to 5% of the mid spec VN of the material. A drop of 5% - 10% is acceptable. Anywhere between 10% and 15% drop is an indication that the molding process could be improved from the combination of moisture content, melt temperature and residence time perspective. Beyond 15% VN drop one should expect to see the onset of loss of functional robustness of the molded parts.

SAFETY

For the safety properties of the material, we refer to our MSDS which can be obtained at our sales offices. During practical operation we advise to wear personal safety protections for hands, eyes, and body. If the hot runner, nozzle, or even the screw is blocked, be aware that a sudden outburst of molten material may take place, either through the nozzle or backward through the hopper.

STARTUP, SHUT DOWN, AND CLEANING

Production has to be started and stopped with a clean machine. Cleaning can be done with PA6-GF or PA66-GF, applicable cleaning agents or HDPE. Hot runners can also be cleaned with PA6-GF or PA66-GF.

PRODUCTION BREAKS

During production breaks longer than a few minutes, we advise to empty the barrel. The temperature of the barrel and the hot runner (if applicable) should be reduced to a level far enough below the melting point of the compound in order to stop decomposition of the compound. After a production break, the first 10 shots after the machine has reached steady operation should be discarded.

TROUBLESHOOTING

Contact Envalior in case more information is required on material or processing.

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