

Novamid® 1013GH15 1 NA/BK37

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This quick start instruction gives an indication of the key settings for processing Novamid® 1013GH15 1 NA/BK37 to ensure best crystallization and prevent material degradation as a result of hydrolysis or thermal load. It is a summary of the Injection Molding Recommendations which can be found in our Plastics Finder at <https://envalior.plasticsfinder.com>. Our online guidelines are recommendations to help with material processing and/or to evaluate and resolve potential processing issues.

MATERIAL HANDLING

Drying

Novamid® grades are hygroscopic and absorb moisture from the air relatively quickly. Moisture absorption is fully reversible under the following drying conditions without compromising material quality. Preferred driers are de-humidified driers with dew points maintained between -30 and -40°C / -22 and -40°F. Vacuum driers with N₂ purge can also be used. Hot air ovens or hopper driers are not suitable for pre-drying Novamid® grades; the use of such driers may result in non-optimum performance.

| Moisture content | Time | Temperature | |
|--------------------------|------|-------------|------|
| | | [°C] | [°F] |
| 0.1-0.2 and as delivered | 2-4 | 80 | 176 |
| 0.2-0.5 | 4-8 | 80 | 176 |

Drier types that are not de-humidified can be operated until 100°C but care has to be taken with natural/light colors for which a color change might be observed upon drying depending on time/temperature exposure.

TEMPERATURE SETTINGS

Barrel temperature

Optimal settings are governed by barrel size and residence time. Furthermore, the level of glass and/or mineral reinforcement and the presence or absence of flame retardant have to be taken into account.

| Mold/Tool | Measured melt | Nozzle | Front | Center | Rear |
|--------------------------|------------------------|------------------------|------------------------|------------------------|------------------------|
| 50 - 80°C 122 - 176°F | 250-285°C 482-545°F | 260-280°C 500-536°F | 265-280°C 509-536°F | 265-275°C 509-527°F | 255-265°C 491-509°F |

MELT RESIDENCE TIME

The optimal Melt Residence Time (MRT) for Novamid® 1013GH15 1 NA/BK37 is ≤ 4 minutes with preferably at least 50% of the maximal shot volume used. The MRT should not exceed 6 minutes. A full self-service MRT calculation can be done using the following [link](#).

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Typical values are indicative only and are not to be construed as being binding specifications. Colorants in the product or other additives may cause significant variations in typical values.

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