

Stanyl[®] TE250F9

PA46–GF45 FR(17)

45% Glass Reinforced, Heat Stabilized, Flame Retardant

Print Date: 2024–06–13

GRADE CODING

Stanyl[®] PA46 reinforced and flame retardant injection molding grades.

MATERIAL HANDLING

Storage

In order to prevent moisture pick up and contamination, supplied packaging should be kept closed and undamaged. For the same reason, partial bags should be sealed before re–storage. Advisable is storage at room temperature.

Packaging

Stanyl[®] grades are supplied in airtight, moisture–proof packaging.

Moisture content as delivered

Stanyl[®] TE250F9 is packaged at a moisture level ≤ 0.1 w%.

Conditioning before molding

To prevent moisture condensing on granules, bring cold granules up to ambient temperature in the molding shop while keeping the packaging closed.

Moisture content before molding

Stanyl[®] TE250F9 is delivered at molding moisture specification (≤ 0.1 w%). We advise to pre–dry to overcome the fluctuation from package to package (see drying section below). Furthermore, pre–drying is required in case the material is exposed to moisture before molding (prolonged storage or open/damaged packaging).

Moisture content can be checked by water evaporation methods or manometric methods (ISO 15512).

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Drying

Stanyl® 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 N_2 purge can also be used. Hot air ovens or hopper driers are not suitable for pre-drying Stanyl® 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	80	176
0.2 – 0.5	4 – 8	80	176
>0.5	<100 or 24	80 105	176 221

Regrind

Regrind can be used taking into account that this regrind must be clean/low dust content/not thermally degraded/dry, of same composition and similar particle size as the original material. The acceptable level of regrind depends on the application requirements (e.g. UL Yellow Card). Be aware that regrind can cause some small color deviations.

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MACHINERY

Stanyl® grades can be processed on general injection molding machines.

Screw geometry

Typically 3-zone screw designs with volumetric compression ratios of approximately 2.5 work fine.

Steel type

Abrasive & corrosion resistant tool steels which are normally used for glass and/or mineral reinforced, flame retardant materials are also to be used for Stanyl® polymers in tools, nozzles and screws.

Nozzle temperature control

Due to the combination of the typical high melting temperature of Stanyl® and consequently its high processing temperature, it is necessary to have a good temperature control for the nozzle. The use of an open nozzle or, even better, a reversed tapered nozzle with good temperature control and an independently-controlled thermocouple nearby the tip and heater bands with sufficient output is recommended.

The nozzle temperature should be set as high as possible to prevent a cold slug, yet low enough to prevent excessive drool.

Venting design

A good venting design is crucial for good molding behavior (easy filling) and low outgassing/mold deposit. Blocked vents can lead to incomplete parts and/or burning at the end of the flow path (diesel effect).

It is recommended to use venting on all inserts (explosive venting) and also on the runner system. Use decreased injection speeds during filling in order to make the venting as effective as possible.

Hot runner layout

The fast crystallization of Stanyl® asks for specific hot runner design rules. For more details, there is also a special hot runner flyer available for all Stanyl® grades. Please contact your Envalior sales or check our websites.

Try to achieve a close contact with your hot runner supplier and Envalior as the material supplier, to ensure that the right hot runner system is chosen.

When processing Stanyl® with hot runners, keep in mind these basic rules:

- Central bushing heated separately
- Only use external heated system
- Manifold heated from both sides
- Tip with thermocouple in front (near gate)
- Very accurate temperature control in the gate area

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TEMPERATURE SETTINGS

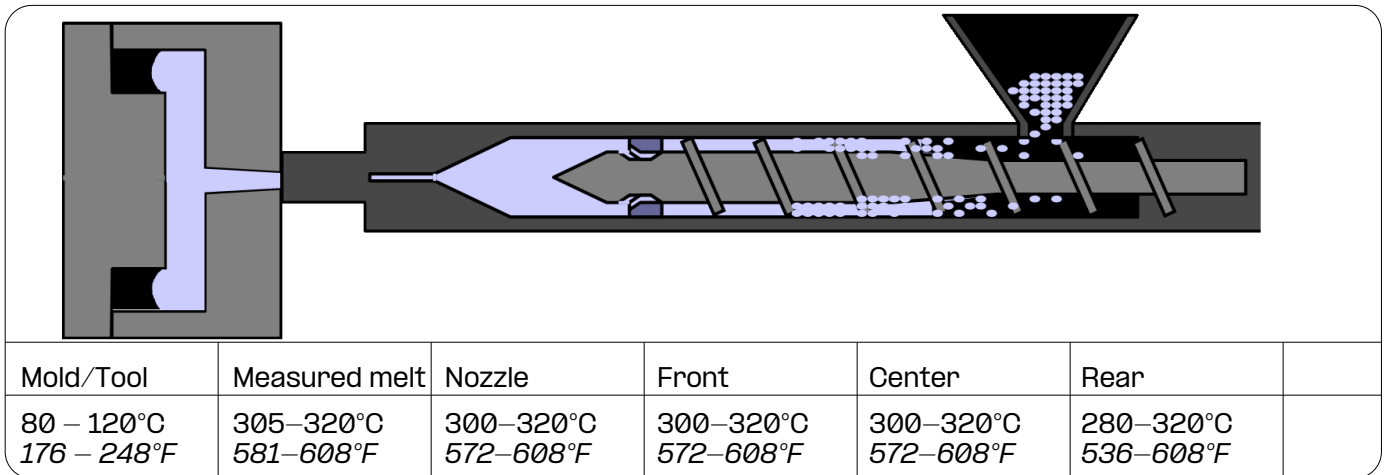
Mold temperature

Stanyl® can be used with a wide range of tool temperatures (80 – 120°C / 176 – 248°F). However, to achieve optimal mechanical properties and stable dimensional parts, it is recommended to apply a tooling temperature at the higher side (120°C / 248°F).

Due to the fast crystallization speed of Stanyl®, the mold temperature has less influence on the cycle-time.

Barrel temperature

Optimal settings are governed by barrel size and residence time. Due to the high melting point of Stanyl® this temperature should be set high enough to provide a homogeneous melt without getting too near to the degradation temperature of 330°C / 626°F. A flat or rising temperature profile is recommended.



Melt temperature

To generate a good and homogeneous melt, the melt temperature should always be above 305°C / 581°F. Optimal mechanical properties will be achieved at melt temperatures between 305–320°C / 581–608°F.

We advise to frequently measure the melt temperature by pouring the melt in a Teflon cup and inserting a thermo probe into the melt.

Hot runner temperature

A hot runner temperature set to the same level as the nozzle temperature should work fine and not lead to excessive overheat of the Stanyl® grade. When starting up, an increased tip temperature may be necessary to overcome a frozen nozzle.

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GENERAL PROCESSING SETTINGS

Screw rotation speed

To realize a good and homogeneous melt, it is advised to set a screw rotation speed resulting in a plasticizing time that is just within the cooling time.

The rotational speed of the screw should not exceed $6500 / D$ RPM (where D is the screw diameter in mm).

Back pressure

Back pressure should be between 20–100 bars effective. Keep it low in order to prevent nozzle-drooling, excessive shear heating and long plasticizing times.

Decompression:

In order to prevent nozzle drool after plasticizing and retracting the nozzle from the mold, a short decompression stroke can be used. However, to prevent oxidation of the melt, which may result in surface defects on the parts, it is recommended to keep this as short as possible.

Injection speed

Moderate to high injection speeds are required in order to prevent premature crystallization in the mold during injection phase and to obtain a better surface finish. The recommended injection speed profile goes from fast (for sprue and runner filling) to medium (for part filling) to avoid excessive shear heating and allow air to escape from the mold. Adequate mold venting is required to avoid burning at the end of the flow path (due to diesel effect).

Injection pressure

The real injection pressure is the result of the flowability of the material (crystallization rate, flow length, wall thickness, filling speed). The set injection pressure should be high enough to maintain the set injection speed (use set injection pressure higher than the peak pressure if possible). Tooling air vents must be effective to allow optimum filling pressure and prevent burn marks.

Holding time

Effective holding time is determined by part thickness and gate size. Holding time should be maintained until a constant product weight is achieved. Due to its fast solidification, holding time for Stanyl® is short compared to other engineering plastics.

Holding pressure

The most adequate holding pressure is the level whereby no sinkmarks or flash are visible. A too high holding pressure can lead to stresses in the part.

Cooling Time

Actual cooling time will depend on part geometry and dimensional quality requirements as well as the tool design (gate size). Due to the fast crystallization of Stanyl®, a short cooling time is possible.

