

Xytron™ M6510A

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This quick start instruction gives an indication of the key settings for processing Xytron™ M6510A 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

Hot air ovens or hopper driers can be used for pre-drying Xytron™ grades, however 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.

Moisture content	Time	Temperature	
[%]	[h]	[°C]	[°F]
as delivered	2-6	130-140	266-284

TEMPERATURE SETTINGS

Barrel temperature

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

Mold/Tool	Measured melt	Nozzle	Front	Center	Rear
140 – 150°C 284 – 302°F	310-340°C 590-644°F	310-340°C 590-644°F	320-340°C 608-644°F	310-330°C 590-626°F	300-320°C 572-608°F

MELT RESIDENCE TIME

The optimal Melt Residence Time (MRT) for Xytron™ M6510A is ≤ 6 minutes with preferably at least 50% of the maximal shot volume used. The MRT should not exceed 8 minutes. A full self-service MRT calculation can be done using the following [link](#).

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