LEIS POLYTECHNIK
POLYMERE WERKSTOFFE GMBH

Processing guidelines

NYLAFORCE® TW2

# *NYLAFORCE*® A 60 TW2

## General

***NYLAFORCE*® A 60 TW2** resins can be molded with usual types of molding machines. In principle the same processing conditions as for standard fibre glass reinforced nylon fit for ***NYLAFORCE*® *A 60 TW2***. Due to the high processing temperature and the abrasion of reinforced nylon, for barrel, screw and hot runner systems wear resistant steel must be specified. Heated, open nozzles are recommended for use in molding. For best molding and good part quality the actual shot size should be between 10 % and 70 % of the machine rated capacity and the screw design should be appropriate. A back-flow valve is necessary for molding.

## Material drying

***NYLAFORCE*® A 60 TW2** resins are supplied dry (less than 0,2 % moisture by weight) and are ready to mold directly from the moisture-proof shipping containers. We recommend dry storage areas.
The required final water content for best molding and part quality is less than 0,1 %, therefore we recommend pre-drying in a hopper dryer working with dehumidified air (dewpoint below –20 °C) or an oxygen-free environment (vacuum oven) at 80 to 90 °C for 4 to 12 hours. After drying hygroscopic materials like nylon have to be protected against atmospherical moisture.

## Recommended machine parameters | tool temperature

| parameter | range | recommendation |
|---|---|---|
| solid mass temperature | 280 °C to 310 °C | 290 °C |
| filling pressure | 800 to 1500 bar | 1200 bar |
| injection speed | high | high |
| tool temperature | 80 °C to 140 °C | 140 °C |

The technical data is only for orientation and advice. For any construction and especially for the required grade of part quality the necessary adjustments have to be done. Therefor no obligation can be derived from this data.

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