



General guide for injection moulding parameters for PA 66

Barrel temperatures feed	275°C – 280°C
Barrel temperatures middle	270°C – 285°C
Barrel temperatures forward	270°C – 285°C
Nozzle temperatures	260°C – 280°C
Mould plattern temperatures	60°C – 100°C

Injection pressures

Under pack the mould then build up the shot weight maintaining a screw cushion of 3mm to 6mm depending on the moulding machine and part being moulded.

Injection speed

Consistent with mould filling and part quality at optimum rate.

Holding pressure

To be consistent with maintaining good quality mouldings with no sink marking.

Holding time

To be consistent with maintaining good quality mouldings with no sink marking.

Cooling time

Dependent on the wall thickness and overall size of the part, cooling needs to be consistent with moulding that are dimensionally stable when leaving the mould.

Drying time

4hrs @ 90°C

Barrel residence time

30sec – 2min

Purging

Purge the moulding machine with PP after use

All information given is for guidance use only