



MOCOM

❖ Altech® ECO PA6 Processing Guide Injection Molding

Altech® ECO PA6 is a semi-crystalline thermoplastic, unfilled or reinforced with glass fibers, glass beads or mineral.

Pre-drying

Altech® ECO PA6 is a hygroscopic polymer. Depending on external conditions, such as climate or storage, the material absorbs moisture. Pre-drying of Altech® ECO PA6 compounds is recommended to prevent surface defects or quality issues on the finished parts. Please see the technical data sheet of the individual Altech® ECO PA6 compound for drying conditions and the residual moisture recommended before processing.

Processing

Altech® ECO PA6 can be processed on all standard injection molding machines. Wear protected plasticizing units for reinforced or filled compounds are advised. High processing and mold temperature can improve part quality due to improved flowability of the PA6, among other factors.

Higher injection speed for glass fiber reinforced Altech® ECO PA6 helps to cover the glass fiber in parts and to reduce glass fiber coming to the part surface.

Shrinkage

Shrinkage values are generally to be understood as guide values and do not release the user from the obligation to carry out appropriate tests. They do not represent a pure material property, but are also dependent on the filler, processing method, the shape of the molded part, the uniformity of the wall thickness, the mold design and the processing conditions. As a result of the orientation of the macromolecules, the type, level and direction of the reinforcing materials. The shrinkage depends on multiple factors.

Platelet-shaped reinforcing materials, like in talc-reinforced Altech® ECO PA grades show an increasingly isotropic shrinkage behavior with increasing filler content. Compared with unreinforced grades, the shrinkage is lower. The difference between longitudinal and transverse shrinkage is low, and consequently also the tendency to warp. Fibrous reinforcing materials, such as glass fibers, also lead to a reduction of the shrinkage in the flow direction. However, the difference between longitudinal and transverse shrinkage is considerably greater. Thus, for individual grades, the shrinkage can therefore only be stated in a range.

Adding regrind material

The addition of sprues and rejects is generally possible. Exceptions to this are functionalized compounds, which are intended for welding or equipped with flame retardants, for example. The proportion of material returned to the process depends on the process and the final part. It is recommended to determine the ideal point of part quality and usage of the grinded material by means of a series of tests, starting with a low percentage addition.

Storage / Shelf life

The original packaging of our goods ensure sufficient protection against dust and other contamination. The quality of plastics during storage depends principally on the storage conditions. Only small variation of the temperature at the storage area are recommend – room temperature is preferred. Avoid high temperature differences between storage and processing area. Store the material in original package for as long as possible and avoid any source of UV-light at the storage area.

Coloration

Altech® ECO PA6 are offered in a variety of different colors and can also be colored according to customer requirements. Please feel free to contact us for this purpose. Subsequent coloration by master batches is also possible. Color batches based on polyamides are recommended with regard to compatibility and dispersion. Similar melting and flow properties to the selected Altech® ECO PA6 should be ensured. An improvement in homogeneity of the color appearance can be achieved by

increasing back pressure or by installing a mixer on the machine side. The batch manufacturer's instructions must also be observed.

Downtimes / Cleaning

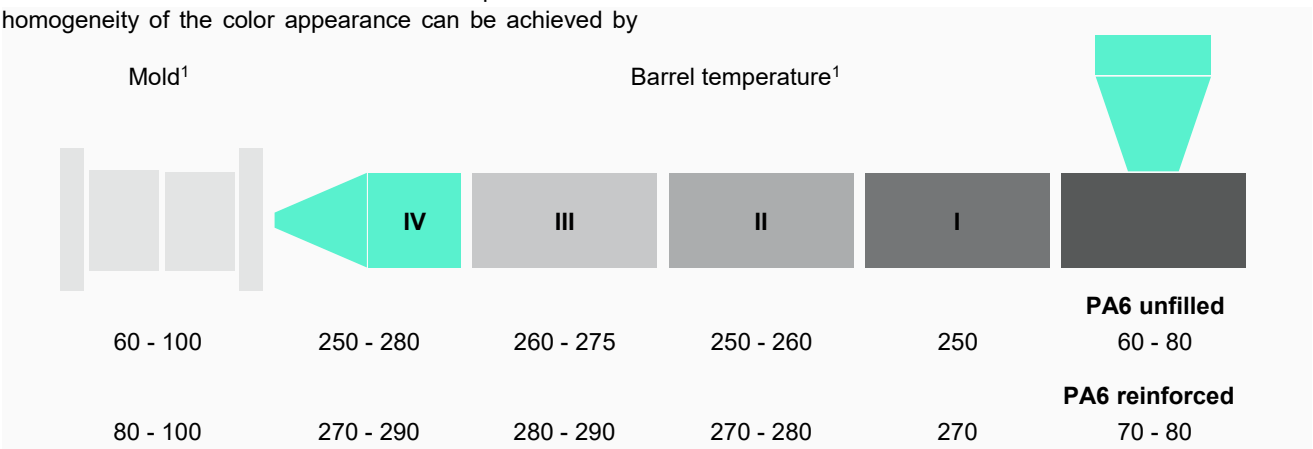
In case of longer downtimes, clean the injection molding machine from already melted material. Screws and barrels of the injection molding machine should be cleaned during material, color and production changes. Special cleaning granules are available with special additives and low-viscosity melt to remove deposits from the components. When critical material changes occur, the components should be disassembled and cleaned with hand tools or ovens.

Residues

In general, the existence of residual amounts of ferrous and non-ferrous metals cannot be completely ruled out in recycle feedstocks. In order to minimize potential negative effects of such inclusions, MOCOM uses state-of-the-art metal (and non-metal) detection and separation systems in the production of its Altech® ECO PA6 compounds. However the highest product quality assurance processes cannot guarantee zero levels of ferrous and non-ferrous metal in the final product. To further reduce risk, molders are therefor advised to deploy their own detection and separation techniques. In particular, special measures are advised for hot runner tools.

Altech® IQ

Altech® ECO and Altech® IQ differ significantly in the quality of the material. As a result, readjustments may be necessary for Altech® IQ products in the processing of different production batches. The scope of an Altech® IQ specification is very limited and cannot be extended. Further processing steps such as painting, welding and coating processes, which have to be adjusted using various parameters and require a constant surface quality of the material in order to be carried out economically, are not possible with an Altech® IQ. The use of an equivalent, higher quality Altech® ECO material is recommended for this purpose.



Temperatures in degrees Celsius (°C) ¹Guide values. Standard starting profile might be in the middle.

Properties

Polymer	PA6
Density (ISO 1183)	1.09 - 1.57 g/cm ³ (see technical data sheet)

Injection machinery

Screw stroke	Metering stroke between 1 x D and 3 x D (D = screw diameter)
Screw type	Three zone screw with L/D ratio 18:1 to 22:1
Nozzle type	Open or needle shut-off nozzle
Hopper type	Standard

Pre-processing

Storage	Dry, protected from heat and UV radiation	
Dryer type	Dry air (desiccant)	
Drying time	2 - 12 h	
Drying temperature	80 °C	
Permissible moisture content	Max.: 0.15 %	Optimum: 0.08 %

Processing conditions

	PA6, unfilled	PA6, glass fiber reinforced	PA6, mineral filled
Mass temperature	250 - 270 °C	270 - 290 °C	270 - 290 °C
Mold temperature	60 - 100 °C	80 - 100 °C	80 - 100 °C
Coolant	Water		
Throughput coolant	Turbulent flow must be achieved		
Peripheral screw speed	< 300 mm/s, e.g., screw speed of 40 rpm with a screw diameter of 50 mm		
Back pressure (specific)	50 - 150 bar		
Residence time	< 10 min		
Injection speed	Profile for constant flow front speed		

Shrinkage²

	PA6, unfilled	PA6, glass fiber reinforced	PA6, mineral filled
Parallel to flow, 24 h (ISO 294-4)	1,0 – 1,8%	0,1 – 0,4%	0,9 – 1,4%
Transverse to flow, 24 h (ISO 294-4)	1,2 – 2,2%	0,3 – 0,9%	1,0 – 1,5%

²Shrinkage is not a pure material property, but is influenced by fillers, the part/component geometry, its wall thickness and the position and size of the gate. The processing parameters, such as mold wall and melt temperature, also play a decisive role.

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