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Processing advice Durethan (Injection molding)

The following information applies when the product is processed by **injection molding**. If other processing methods, such as extrusion, are used, then the parameters can differ considerably from the figures given here.

Drying

Care must be taken to ensure that the pellets are processed in a sufficiently dry state.

Permitted residual moisture content	0.12%
Drying temperature	176 °F (80 °C)
Drying time	Dry air dryer 2 to 20 hours (depending on starting moisture content)
	Fresh air dryer not suitable

General injection molding conditions

The figures given are the upper and lower limits for the whole range of grades. The melt temperature for the easy-flow grades will generally be selected from the lower end of the range and the melt temperature for standard grades from the upper end of the range.

Actual processing conditions will depend on machine size, mold design, material residence time, shot size, etc.

	Durethan A (PA 66)		Durethan B (PA 6)		Durethan T (PA 6I)
	non-reinforced	reinforced	non-reinforced	reinforced	non-reinforced
Melt temperature	527 - 563 °F (275 - 295 °C)	536 - 572 °F (280 - 300 °C)	500 - 536 °F (260 - 280 °C)	518 - 554 °F (270 - 290 °C)	518 - 554 °F (270 - 290 °C)
Mold temperature	176 - 212 °F (80 - 100 °C)	176 - 248 °F (80 - 120 °C)	176 - 212 °F (80 - 100 °C)	176 - 248 °F (80 - 120 °C)	122 - 176 °F (50 - 80 °C)
Permitted residence time	4 - 10 minutes				
Maximum circumferential velocity of screw	0.3 m/s *				

* Higher velocities are possible by processing Easy Flow und Extreme Flow grades.

For specific processing data also consider the dedicated material data sheet.

You will find more information in our brochure

[_Durethan PA Injection Molding Guide](#)

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