

MITSUI CHEMICALS AMERICA, INC.

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► Products : Specialty Polymers & Engineering Plastics

ARLEN™ Modified Polyamide 6T Processing Methods

Mitsui Chemicals recommends the following to mold this sophisticated engineering plastic for any application part:

Molding machine:

- The injection molding of this modified polyamide requires a molding machine having wear resistance (corrosion resistance for the flame-retardant grade).
- A small molding machine should be selected so that the volume of one shot will be not less than 10% of the maximum injection capacity.
- A standard nozzle should be used.

Mold:

- A steel material having wear resistance (corrosion resistance for the flame-retardant grade) is required for the construction material of a mold for ARLEN.
- An approximately 10- μ m vent is required.

Predrying:

- Any ARLEN resin that absorbs moisture after the bag is opened needs to be dried again.
- Dehumidifying dryer: 110°C x 2 to 6 hr.

Electronic and Electric Standard Molding Conditions

Cylinder temp. (°C):	NH	320	(315 - 335)
	C3	320	(320 - 335)
	C2	320	(315 - 335)
	C1	310	(300 - 325)
	Hopper bottom	70	(50 - 90)
	Mold:	120	(90 - 140)
Injection speed:	Medium speed		
Injection pressure:	Medium pressure		
Screw revolution speed:	150rpm		

Mechanical and Structural Standard Molding Conditions

Cylinder temp (°C):	NH	330	(325 - 340)
	C3	330	(325 - 340)
	C2	325	(320 - 335)
	C1	320	(315 - 330)
	Hopper bottom	70	(50 - 90)
	Mold:	120	(90 - 140)
	(For non-reinforced grade	70	(50 - 90))
Injection speed:	Medium speed		
Injection pressure:	Medium pressure		
Screw revolution speed:	150rpm		

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