

Nilamid A3 H ZE

Processing guide



Nilit Plastics Division

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PROCESSING GUIDE NILAMID A3 H ZE

Nilamid A3 H ZE is an unfilled PA66 with superb low temperature impact resistance. This product offers excellent impact strength, even at minus temperatures, whilst maintaining acceptable stiffness and strength values.

Before processing this material, please read the safety data sheet and this processing guide carefully.

Nilamid A3 H ZE is an easy to mould material, which can be processed on most standard injection moulding equipment.

Pre-drying

Nilamid A3 H ZE is hygroscopic and moisture sensitive, so pre-drying is recommended as a matter of rule. Material that is not pre-dried to a moisture level below 0.1% will degrade, causing surface defects, parts that are out of dimension and brittle parts. It is recommended to dry material for 4 hours at 80 °C to 85 °C in a desiccant dryer with more than one desiccant element.

A few tips to ensure proper operation of the dryer:

- Ensure the thermocouple that regulates the temperature is placed immediately before the entry of the air into the dryer. There can be a significant temperature drop in the air-conveyance system!
- The temperature of the air going out of the dryer silo should not be more than 30 °C lower than the air entering the system. If this is the case, you have insufficient air capacity.
- From time to time, monitor the dew point of the dry air to ensure the desiccant elements are functioning properly.

Often, less air runs through the very bottom part of a dryer silo. Therefore, it is recommended that you take the material out of the bottom of the dryer and feed it back into the top when you start up your process.

Moulding temperatures

For Nilamid A3 H ZE, the melt temperature must be kept below 300 °C. Any higher temperature will cause rapid degradation of the product.

The following barrel settings are recommended:

Material	Zone 1 (hopper)	Zone 2	Zone 3	Zone 4 (Nozzle)
Nilamid A3 H ZE	265-285 °C	270-285 °C	275-290 °C	275-290 °C

The recommended melt temperature ranges from 275 to 290°C.

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Tool temperature

Mould temperature is always a compromise. On the one hand, tool temperature should be as high as possible to give optimum crystallization and dimensional, optimal surface finish and optimal mechanical performance. On the other hand, lower tool temperature can significantly cut cycle time. For Nilamid A3 H ZE, 60 °C should be maintained as a minimum, however 80 °C is preferred

Pressure and speed

Injection pressure should generally be around 70 to 100 MPa; this results in a minimum clamping force of the moulding machine in tonnes of 0.7 times the projected surface area in cm².

Holding pressure is generally in the area of 90 MPa.

For Nilamid A3 H ZE, the screw speed should be kept medium to avoid overheating, a rough indication is as follows:

Screw Diameter (mm)	Maximum rpm
20	250
30	150
40	110
50	100
60	85
70	65
80	60
>80	50

Back pressure should be kept to a practical minimum

Use of regrind

Parts have been moulded successfully with regrind levels of up to 30%. When regrind is used, observe these simple rules:

- Use a constant ratio of regrind and virgin material. When a material has been processed once, its viscosity has decreased. Using varying ratios of regrind can lead to variations in dimensions, mechanical performance and processing characteristics.
- Either feed the regrind straight back into the machine, or pre-dry the regrind before usage.
- Store regrind in a dry, clean place to avoid contamination and excess moisture.
- Ensure sharp cutting blades to keep dust generation to a minimum; cut glass fibre reinforced material when it is still hot.



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Special instructions

- Always pre-dry the material and any regrind that is not fed back immediately into the machine to below 0.1% moisture
- Keep the melt temperature below 290 °C, particularly in areas where long residence times may occur, like hot runners
- When the machine is stopped, purge with PE or a suitable purging compounds. Do not leave the material standing for longer than 30 minutes without purging

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