

Nilamid A H2 FR HF2

Processing guide



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Nilamid A H2 FR HF2 is an unfilled PA66/6 co-polymer modified with a halogen- and red phosphorous free flame retardant system. This product combines thermal, mechanical and electrical properties with a UL 94 V0 flame retardancy listing down to 0.4 mm. This product has a complete UL yellow card.

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

Nilamid A H2 FR HF2 is an easy to mould material, which can be processed on most standard injection moulding equipment.

Pre-drying

Nilamid A H2 FR HF2 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 a reduction in flame retardancy, 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 A H2 FR HF2, the melt temperature must be kept below 280 °C. Any higher temperature will cause rapid degradation, which can be recognized by foaming of the material or splash marks on the surface of the part. Degraded material may not reach the UL listed properties!

The following barrel settings are recommended:

Material	Zone 1 (hopper)	Zone 2	Zone 3	Zone 4 (Nozzle)
Nilamid A H2 FR HF2	260-270 °C	260-275 °C	270-280 °C	270-280 °C

The recommended melt temperature ranges from 265 to 280 °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 A H2 FR HF2, 80 °C should be maintained as a minimum.

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 A H2 FR HF2, the screw speed should be kept low, a rough indication is as follows:

Screw Diameter (mm)	Maximum rpm
20	150
30	100
40	70
50	60
60	50
70	40
80	35
>80	30

Back pressure should be kept to a practical minimum

Use of regrind

Parts have been moulded successfully with regrind levels of up to 15%. 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 and flame retardancy. 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 280 °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 15 minutes without purging

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