

Technical Information

Pre-drying

The service of CP-Polymer-Technik includes the drying of every **WELLAMID** grade at the end of the compounding prior to being packed. The measured value of the residual moisture can be found in our inspection certificates. Many customers use our **WELLAMID** without an additional pre-drying of the material.

Processing Guidelines

WELLAMID	melt temperature [°C]	mold- temperature [°C]	screw speed	injection speed	holding pressure	back pressure
6000 ... ; 6000 S....	245-265	40-80	high	medium till high	high	low
6000/... (impact modified)	245-260	40-80	medium	medium	high	low
6000 HWVOCP	245-265	50-90	medium	medium	high	low
6000 GS ; 6000/... GS (impact mod.)	250-270	60-90	high	medium	high	low
6000 GV; 6000/... GV (impact mod.)	250-280	60-90	high	medium till high	high	low
6000 MF	250-280	60-90	high	medium till high	high	low
6000 GVS	250-280	60-90	high	high	high	low
6000 MR	260-290	70-100	high	high*	high	low
6000 MRGV	260-290	80-100	high	high*	high	low
6000 CF	260-290	70-100	high	medium till high	high	low
6000 GX, MX	250-280	80-100	high	medium till high	medium	low

WELLAMID	melt temperature [°C]	Mold- temperature [°C]	screw speed	injection speed	holding pressure	back pressure
6600 ...; 6600 S...	260-290	50-90	high	medium till high	high	low
6600/... (modifiziert/modified)	260-280	50-90	medium	medium till high	high	low
6600 HWL	260-295	50-90	medium	medium till high	high	low
6600 HWVOCP	260-275	70-90	high	medium till high	in steps	low
6600 GS ; 6600/... GS (impact mod.)	265-290	70-90	medium	medium till high	high	low
6600 GV; 6600/... GV (impact mod.)	265-295	70-90	medium	high	high	low
6600 MF	265-295	70-90	medium	high	high	low
6600 GVS	265-290	70-90	high	medium till high	high	low
6600 MR	265-295	80-100	medium	high*	high	low
6600 MRGV	270-295	80-100	medium	high*	high	low
6600 CF	275-295	80-100	high	high	high	low
6600 MZ	265-295	80-100	medium	medium till high	medium	low

* when streaks occur, reduce injection speed

Please note:

This information and our technical advice - whether verbal, in writing or by trials - are given in good faith but without warranty. Our advice does not release you from the obligation to check and test our products as regards their suitability for the intended process and use.

Unless specified otherwise, the values given have been established on standardised test specimen at room temperature. The figures should be regarded as guide values, only, and not as binding minimum. Kindly note that under certain conditions the product may be affected to a considerable extent by processing conditions, design of mould and colouring.

Our products are sold in accordance with our "Conditions of Sales and Delivery".