## INJECTION DATASHEET



## Zytel<sup>®</sup> 70G30HSLR ECO-R BK099 NYLON RESIN

Zytel® 70G30HSLR ECO-R BK099 is a 30% glass fibre reinforced, heat stabilised, hydrolysis resistant polyamide 66 resin for injection molding. It has same performance and processing properties as Zytel® 70G30HSLR BK099.

### **General Information**

## Temperature settings

Density ISO 1183	1370/- kg/m <sup>3</sup>
Drying	
Drying Recommended	yes
Drying Temperature**	80 °C
Drying Time*	2 - 4 h
Processing Moisture Content - Optimum**	0.1 %
Processing Moisture Content	≤0.2 %

Melt Temperature Optimum	295 °C
Min. melt temperature***	285 °C
Max. melt temperature	305 °C
Mold Temperature Optimum	100 °C
Min. mould temperature	70 °C
Max. mould temperature	120 °C



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### Recommended general settings

Residence time - optimum range	3 - 5 min
Residence time - maximum	10 min
Hold pressure range	50 - 100 MPa
Hold Pressure Time	h²+2 s
(h is the max. wall thickness of the part in mm)	
Max. screw tangential speed	≤0.2 m/s

# Residence time= $\frac{8^{*}screw \oslash [mm]^{*}cycle time [s]}{60^{*}dosing stroke [mm]}$

Hot runner residence time not included in calculation

### Special precautions

During molding, use proper protective equipment and adequate ventilation. Avoid fumes and limit the residence time and temperature of the resin in the machine.

#### Links for further information

#### **Trouble Shooting Guide**

For further information e.g. on Shrinkage, Hot runner systems, Venting, Gating, Drying and moisture measurement, Regrind, Purging, please refer to the detailed <u>Molding Guide</u>.

#### Footnotes:

\* Improper storage may lead to longer drying times

\*\* Excessive drying may lead to viscosity increase during processing. A discoloration of natural colored materials is possible.

\*\*\* Using melt temperature lower than recommended could create unmelt, leading to weak parts

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