

Minlon® 11C140 BK086

MINERAL REINFORCED NYLON RESIN

Minlon® 11C140 BK086 is a 40% mineral reinforced, heat stabilised polyamide 66 resin for injection moulding. It has very low warpage.

General Information

Resin Identification ISO 1043
 Density ISO 1183

PA66-I-MD40
 1450/- kg/m³

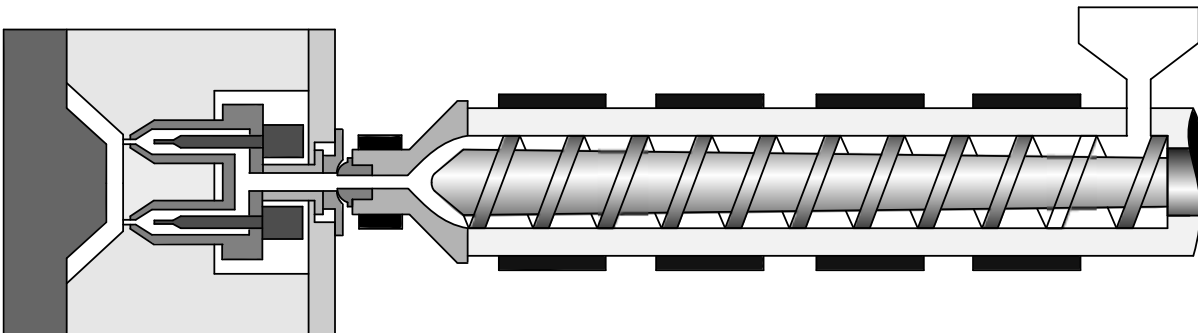
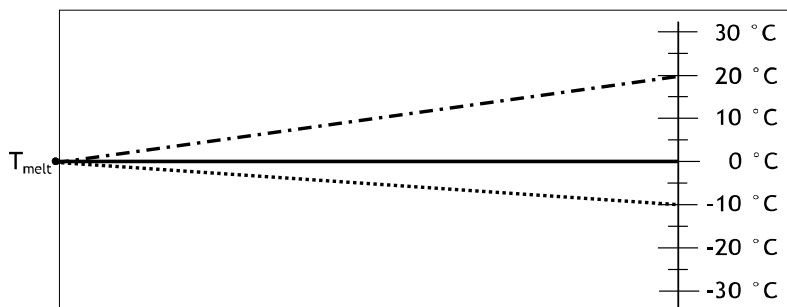
Drying

Drying Recommended yes
 Drying Temperature** 80 °C
 Drying Time* 2 - 4 h
 Processing Moisture Content - Optimum** 0.05 %
 Processing Moisture Content ≤0.2 %

Temperature settings

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

3 D (< 3 min) - - - - -
 2 D (3-5 min) = = = = =
 1 D (> 5 min)



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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	h^2+2 s
(h is the max. wall thickness of the part in mm)	
Max. screw tangential speed	≤ 0.2 m/s

$$\text{Residence time} = \frac{8 \cdot \text{screw } \varnothing [\text{mm}] \cdot \text{cycle time [s]}}{60 \cdot \text{dosing stroke [mm]}}$$

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 Molding Guide.

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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