

ARLEN™ MN-400

High Performance Polyamide PA6T



Drying

ARLEN™ is hygroscopic:

- If the pellets absorb moisture, it may cause variations in processing conditions, drooling, or poor appearance.
- Arlen™ pellet is contained in a dry state in a moisture-proof bag (aluminum laminate).
- Drying pellets before use is recommended, using dehumidifying dryer is preferable
- If the drying temperature is too high or the drying time is too long, the pellets may become discolored. Be careful not to dry over 120°C and over 12 hours.

Drying temperature	Drying time
110°C	6-8h

Molding

Injection molding	Units	Standard Conditions
Hopper bottom temperature	°C	80
Cylinder temperature C1	°C	300 -320 (recommended: 315)
C2	°C	315 -330 (recommended: 320)
C3	°C	315 -330 (recommended: 320)
Nozzle temperature	°C	310 -330 (recommended: 320)
Mold temperature	°C	40 -100 (recommended > 55)
Injection pressure		Medium pressure
Injection speed		Slow to medium speed
Screw speed		80~150rpm
Back pressure		1 ~ 10 MPa (recommended: Low pressure)

Precautions for Use

ARLEN™ has high molding temperature, so please note the following points:

- Clean cylinder and screw with polypropylene before molding
- When suspending molding for about 30 minutes, please stop machine with polypropylene filled
- When suspending molding for more than 30 minutes, please stop machine at 270 degrees or lower with polypropylene filled
- Please finish molding with polypropylene filled to the bottom of the hopper