# Genestar® Polyamide 9T

## Injection Molding Guidelines

**LC122**

### Drying Instructions

Resin should be dried before molding because excessive moisture will result in nozzle drool, reduced mechanical properties, and poor surface appearance. The target moisture level is below 0.05% and the maximum recommended drying temperature is 140℃（284F）to prevent the darkening of natural colored pellets.

- Do not open containers until ready to process.
- Genestar is packed dry（moisture content < 0.05%）but recommend require pre-drying.
- Drying is required when the material is exposed to humid air.

| Drying Condition | Drying Temperature, C（F） | Time, hours |
|---|---|---|
| Preferred | 120（248） | 5-24 |

### Starting Point Molding Conditions

| Parameter | Units | Value |
|---|---|---|
| Melt temperature（preferred） | C（F） | 310-345（590-653） |
| Barrel temperatures, rear zone | C（F） | 300-320 (572-608) |
| middle zone | C（F） | 300-330 (572-626) |
| front zone | C（F） | 310-340 (590-644) |
| Nozzle temperature（limited by drool） | C（F） | 320-340 (608-644) |
| Mold temperature | C（F） | 140-160 (284-320) |
| Injection speed（limited by burn marks） | — | High |
| Injection pressure（limited by flash） | MPa（kpsi） | 50-150（7-22） |
| Back pressure | MPa（psi） | 3~5（450~750） |
| Screw speed（limited by cooling time） | rpm | 80~150 |

* Hold pressure and time depend on runner design and shape of molded article.

### Purging Instructions

- 5-minute cycle interruption, purge at least 3 shots.
- More than 10-minute cycle interruption and at the end of the run, purge with high-density polyethylene or polypropylene (MFR<1g/10min) until all Genestar resin has been removed.