

**Genestar® Polyamide 9T**  
**Injection Molding Guidelines**

<b>GW1458HF</b>
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**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°C (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)	290-320 (554-608)
middle zone	C (F)	300-330 (572-626)
front zone	C (F)	310-340 (590-644)
Nozzle temperature (limited by drool)	C (F)	310-340 (590-644)
Mold temperature	C (F)	140-160 (284-320)
Injection speed (limited by burn marks)	—	Middle - High
Injection pressure (limited by flash)	MPa (kpsi)	60-150 (9-22)
Back pressure	MPa (psi)	3~8 (435~1160)
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.