

Tenac molding conditions

	Grades and Properties	Application Examples	Molding Conditions	Important Precautions	MSDS
Grades		2010, SH210, 3010, SH310, 4010, SH410, 4060, 5010, SH510, 7010, SH710, 5050, 7050, 7054, 9054, 3013A, 4013A, 5013A, GA510, GA520, GN705, LT802, LT804, LT200, FS410, LA541, LA543, LM511, LS701, 4012			
Predrying Conditions	Temp. (°C) Time (hr.)	80 - 90 3 - 4			
Molding Conditions	Resin temp. (°C) Mold temp. (°C)	190 - 210 (below 230) > 50			

PRECAUTIONS:

Before handling or using any Tenac polyacetal resin, be sure to consult the relevant Material Safety Data Sheet, available Asahi Kasei Chemicals Corporation. Polyacetal resins generate gases, principally formaldehyde, during decomposition. Their decomposition in the cylinder of the molding, extruding, or other processing machine may also cause a dangerous high-pressure buildup inside the cylinder. When handling or processing Tenac, the following precautions must be observed.

Handling, Transport, and Storage

- Keep away from flame and heat sources. During a fire, irritating and highly toxic gases (formaldehyde, carbon monoxide, etc.) may be generated by thermal decomposition or combustion.
- Avoid bag breakage, tearing, and water contact.
- Ensure stable, secure bag loading and stacking.
- To prevent the danger of slipping and environmental hazard, sweep up any spilled pellets and place them in proper containers for disposal.

Molding and Extrusion

1. Avoid resin temperatures and cylinder residence times which may cause resin decomposition. The following limits are a general guide; temperature and residence time may be lower for specific operating conditions.
 - Resin temperature
 - Optimum: 190 - 210°C
 - Maximum: 230°C
 - Maximum cylinder residence time
 - For non-reinforced non-colored resins:
 - 50 min. at 190°C
 - 40 min. at 200 °C
 - 30 min. at 210 °C
 - For colored or reinforced resins, consult Asahi Kasei Chemicals Corporation.
2. In any case where the cylinder residence time exceeds the relevant limit, promptly purge the cylinder.
3. At shutdown, purge all resin from the cylinder before turning off the cylinder heater.
4. As purging material, use only non-colored polyethylene, transparent polystyrene, or Asaclean purging agent from Asahi Kasei Chemicals; do not use any other resin. Always submerge purged resin in water immediately after purging, to prevent air contamination in the working environment.

5. Do not mix Tenac with pigments or additives other than those designated by Asahi Kasei Chemicals, or with different resins or resin grades, as this may degrade the thermal stability of Tenac and lead to decomposition.
6. Ensure that the cylinder, nozzle, hot runners, and other high temperature zones are free from local resin detention, as this may result in resin burning or decomposition. In the event of such detention, promptly remove all residual resin by complete, thorough purging.
7. Always provide adequate local or general ventilation to maintain a safe working environment.

NOTE:

The information provided here is accurate to the best of our knowledge, based on all information and data available at this time, and is subject to change without notice. It is provided with no guarantee or assumption of liability whatsoever. It applies only to the normal handling and use of Tenac as a molding material. Any other use or application would necessitate additional, special safety precautions, and is not recommended.

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