



Guide to Molding Wellamid MR409 22H-NBK1

Screw Machine	°F
Rear Zone	540-580
Middle Zone	530-570
Front Zone	520-560
Nozzle Temp	540-560
Melt Temp	520-590
Mold Temp	150-200
Injection Pressure	5,000-20,000 psi
Back Pressure	50psi
Screw RPM	30-120

Drying:

Wellamid nylon resins shipped in bags are ready to mold with moisture content below 0.2%.

Opened bags and Gaylord boxes, dry material for 2 to 4 hours at 175 °F.

The moisture content of the resin should be maintained at a level between 0.2% and 0.02% during molding to prevent hydrolytic degradation which manifests itself by splay marks, low physical properties, brittleness and nozzle drool.

When drying Wellamid nylon, circulating air ovens fitted with effective desiccant dehumidifying units, or vacuum ovens are best for drying Wellamid resins.

For further technical information call Wellman Technical Service at 248 645 0032