



Guide to Molding Wellamid MRGF1878-BK

| Screw Machine | °F |
|--------------------|------------------|
| Rear Zone | 530-560 |
| Middle Zone | 520-540 |
| Front Zone | 510-530 |
| Nozzle Temp | 490-540 |
| Melt Temp | 520-570 |
| Mold Temp | 160-200 |
| 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