



## Guide to Molding WELLAMID<sup>®</sup> EcoLon2000 -BK1 Resin

Screw Machine	°F
Rear Zone	540-580
Middle Zone	540-560
Front Zone	520-540
Nozzle Temp	510-560
Melt Temp	540-580
Mold Temp	160-200
Injection Pressure	5,000-20,000 psi
Back Pressure	50 psi
Screw RPM	30-120

### Drying:

WELLAMID nylon resin 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 0.05% 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.