Guide to Molding

Wellamid® MR410 42H-N

Mineral Reinforced Nylon Resin (PA6)

<table>
<thead>
<tr>
<th>Screw Machine</th>
<th>°F</th>
<th>°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rear Zone</td>
<td>500 - 550</td>
<td>260 - 288</td>
</tr>
<tr>
<td>Front Zone</td>
<td>480 - 550</td>
<td>249 - 288</td>
</tr>
<tr>
<td>Nozzle Temp</td>
<td>470 – 550</td>
<td>243 – 288</td>
</tr>
<tr>
<td>Melt Temp</td>
<td>500 – 550</td>
<td>260 – 288</td>
</tr>
<tr>
<td>Mold Temp</td>
<td>160 – 200</td>
<td>71 – 93</td>
</tr>
</tbody>
</table>

**Injection Pressure**

5,000 – 20,000 PSI

34 – 138 MPa

**Back Pressure**

50 - 150 PSI

0.34 – 1.03 MPa

**Screw RPM**

30 – 120 RPM

DRYING

Wellamid® nylon resins shipped in bags are ready to mold with moisture content below 0.15%.

Nylon resins are hygroscopic and must be molded at a moisture level between .05% - .15% for best results. All Wellamid® nylon resins residing in opened bags or Gaylord boxes should be dried for 2 to 4 hours at 175°F prior to molding. It is highly recommended to check the moisture content of the material before and during the molding process. Maintaining a moisture level between .05% - .15% helps prevent degradation which manifests itself by splay marks, low physical properties, brittleness, and nozzle drool.

PROCESSING

Although not required, Wellman Engineering Resins highly recommends running a reverse heat profile on all Wellamid® nylon resins. This method produces a more homogenous melt and also assists in the control of nozzle drool. Reverse-taper nozzle tips are always recommended with the use of Wellamid® nylon resins also.

For further technical information please go to www.wellmanam.com or call 1 800 821-6022.