



Guide to Molding **EcoLon® MRGF1945-BK1**

25% Mineral/Glass-Reinforced Nylon Resin (PA6)

Screw Machine	°F	°C
Rear Zone	500 - 550	260 - 288
Middle Zone	490 - 550	254 - 288
Front Zone	480 - 550	249 - 288
Nozzle Temp	470 - 550	243 - 288
Melt Temp	500 - 550	260 - 288
Mold Temp	160 - 200	71 - 93
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	30 – 120 RPM

DRYING

EcoLon® 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 **EcoLon®** 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 **EcoLon®** 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 **EcoLon®** nylon resins also.

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