



**EcoLon®**  
**ENGINEERING RESIN**

## **Guide to Molding** **EcoLon® 2100-BK1**

*38% Mineral/Glass-Reinforced Nylon Resin (PA66)*

| <b>Screw Machine</b>      | <b>°F</b>                 | <b>°C</b>              |
|---------------------------|---------------------------|------------------------|
| <b>Rear Zone</b>          | <b>510 - 560</b>          | <b>266 - 293</b>       |
| <b>Middle Zone</b>        | <b>500 - 560</b>          | <b>260 - 293</b>       |
| <b>Front Zone</b>         | <b>500 - 560</b>          | <b>260 - 293</b>       |
| <b>Nozzle Temp</b>        | <b>490 - 560</b>          | <b>254 - 293</b>       |
| <b>Melt Temp</b>          | <b>520 - 560</b>          | <b>271 - 293</b>       |
| <b>Mold Temp</b>          | <b>160 - 200</b>          | <b>71 - 93</b>         |
| <b>Injection Pressure</b> | <b>5,000 – 20,000 PSI</b> | <b>34 – 138 MPa</b>    |
| <b>Back Pressure</b>      | <b>50 - 150 PSI</b>       | <b>0.34 – 1.03 MPa</b> |
| <b>Screw RPM</b>          | <b>30 – 120 RPM</b>       | <b>30 – 120 RPM</b>    |

### **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](http://www.wellmaner.com) or call 1 800 821-6022.