



## Guide to Molding WELLAMID<sup>®</sup> 22LHI4-XE-GY1 Resin

| Screw Machine      | °F               |
|--------------------|------------------|
| Rear Zone          | 530-560          |
| Middle Zone        | 520-550          |
| Front Zone         | 510-540          |
| Nozzle Temp        | 510-560          |
| Melt Temp          | 520-580          |
| Mold Temp          | 160-200          |
| Injection Pressure | 5,000-20,000 psi |
| Back Pressure      | 50 psi           |
| Screw RPM          | 30-120           |

### **Drying:**

WELLAMID nylon resins shipped in bags are ready to mold with moisture content below 0.2%.

For opened bags and Gaylord boxes, material should be dried prior to molding for 2 to 4 hours at 175 °F. Circulating air ovens fitted with effective desiccant dehumidifying units, or vacuum ovens are best for drying WELLAMID resins.

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.

**For further technical information call Wellman Technical Service at 248-645-0032.**