



Guide to Molding WELLAMID[®] 42L-XE-N, 42LH -XE-N Resins

Screw Machine	°F
Rear Zone	460 540
Middle Zone	450 530
Front Zone	440 520
Nozzle Temp	440 560
Melt Temp	440 560
Mold Temp	160 200
Injection Pressure	5,000-20,000psi
Back Pressure	50psi
Screw RPM	30 120

Drying:

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

Open 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.