



Guide to Molding WELLAMID[®] FR1841-BK1 and FR1841-N1 Resins

Screw Machine	°F
Rear Zone	520-540
Middle Zone	510-530
Front Zone	500-520
Nozzle Temp	520-540
Melt Temp	510-530
Mold Temp	160-200
Injection Pressure	5,000-20,000 psi
Back Pressure	50 psi
Screw RPM	30-120

Drying:

The WELLAMID nylon resins shipped in bags have a moisture content below 0.2% and are ready to mold.

For opened bags and gaylord boxes, dry the material for 2 to 4 hours at 175 °F.

The use of circulating air ovens fitted with effective desiccant dehumidifying units, or vacuum ovens are recommended 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.