



Guide to Molding WELLAMID[®] MR410 22H Family of Resins

Screw Machine	°F
Rear Zone	540-580
Middle Zone	530-570
Front Zone	520-560
Nozzle Temp	540-560
Melt Temp	550-590
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.