



Guide to Molding WELLAMID[®] MR410 42H-N Resin

Screw Machine	°F
Rear Zone	530 560
Middle Zone	520 550
Front Zone	510 540
Nozzle Temp	490 560
Melt Temp	520 560
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%.

Opened 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.