



Guide to Molding WELLAMID[®] XT1482-N, XT1482 -BK 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 | 5,000-20,000psi |
| 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.