



## Guide to Molding

### **EcoLon® 2100-BK1**

Screw Machine	°F
Rear Zone	510-550
Middle Zone	510-550
Front Zone	510-550
Nozzle Temp	500-540
Melt Temp	510-550
Mold Temp	160-200
Injection Pressure	5,000-20,000 psi
Back Pressure	50 psi
Screw RPM	30-120

#### **Drying:**

**EcoLon®** nylon resins shipped in bags are ready to mold with moisture content below 0.15%.

Nylon's are hygroscopic and must be molded at a moisture level between 0.15% and 0.05% moisture for best results. For opened bags and gaylord boxes, all **EcoLon®** nylon resins should be dried prior to molding for 2 to 4 hours at 175 °F with moisture checked prior to molding.

The moisture content of the resin should be maintained at a level between 0.15% and 0.05% during molding to prevent degradation which manifests itself by splay marks, low physical properties, brittleness and nozzle drool.

For further technical information please go to [www.wellmaner.com](http://www.wellmaner.com) or call 800 821 6022.