



Guide to Molding

EcoLon[®] MRGF1619-BK3

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 or call 800 821 6022.