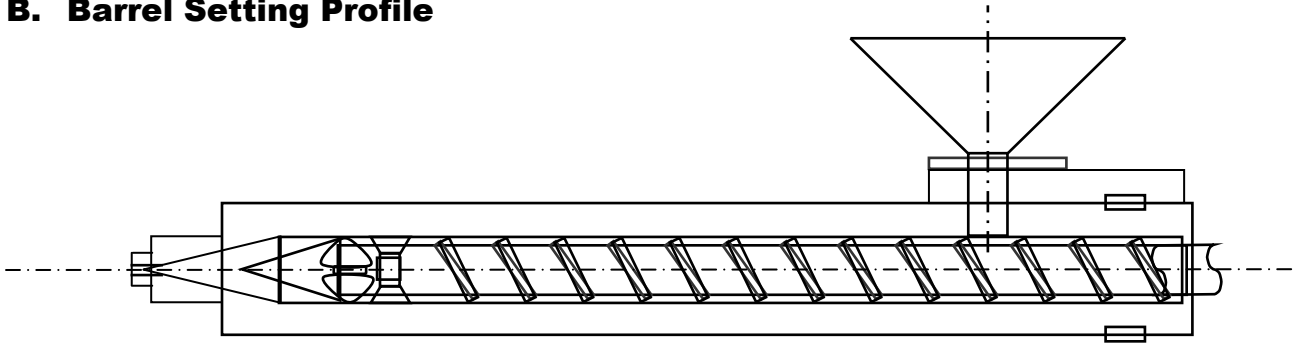


Clariant Nylon 6

Processing Conditions

- A. Pre-drying** **160~175 F x 2~4 hrs**
depending on **a) Humidity**
 b) Ratio of reground resin
 c) Storage conditions

B. Barrel Setting Profile



MAX(F)	540_{NOZZLE}	540_{FRONT}	540_{MIDDLE}	540_{REAR}
MIN(F)	520	520	520	520

- C. Mold Temperature** **150~200_F**

Notes:

- 1. Injection Pressure - 1200 to 2000 psi**
- 2. Back Pressure - 50 to 100 psi**
- 3. Screw Speed - 40 to 80 rpm**

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