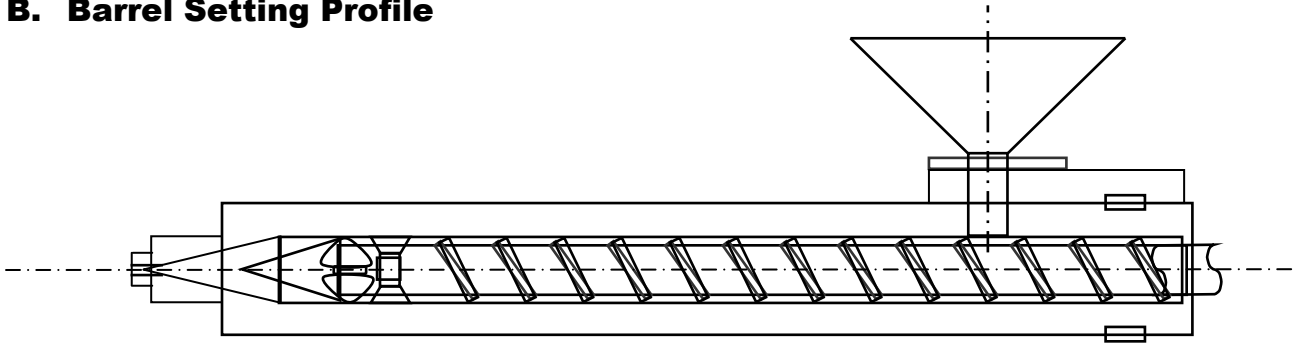


Clariant Nylon 6/6

Processing Conditions

- A. Pre-drying** **160~180 F x 2~4 hrs**
depending on **a) Humidity**
 b) Ratio of regrind resin
 c) Storage conditions

B. Barrel Setting Profile



MAX(F)	550_{NOZZLE}	560_{FRONT}	550_{MIDDLE}	510_{REAR}
MIN(F)	510	540	520	480

- C. Mold Temperature** **130~200F**

Notes:

- 1. Injection Pressure - 5000 to 15000 psi**
- 2. Back Pressure - 0.00 to 800 psi**
- 3. Screw Speed - 30 to 90 rpm**
- 4. Suggested Max Regrind - 25%**

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