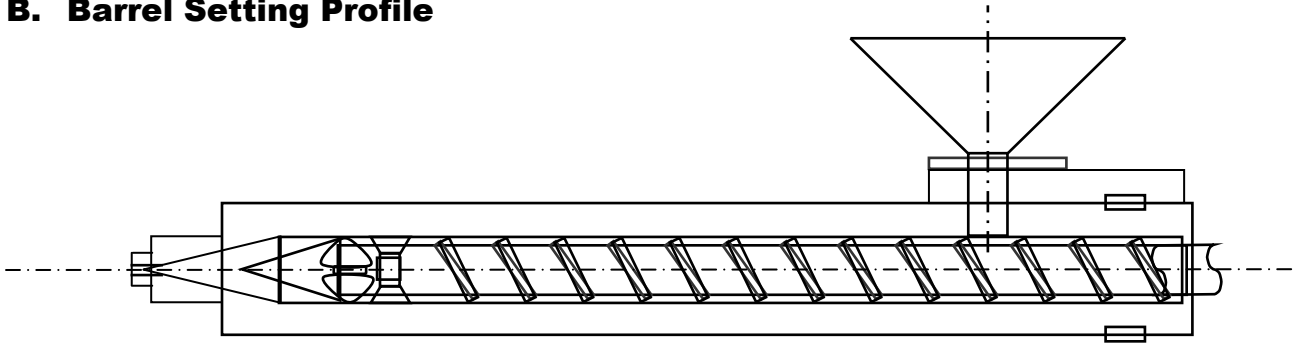


# Clariant Nylon 6/6

## 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**



<b>MAX(F)</b>	<b>550<sub>NOZZLE</sub></b>	<b>560<sub>FRONT</sub></b>	<b>550<sub>MIDDLE</sub></b>	<b>510<sub>REAR</sub></b>
<b>MIN(F)</b>	<b>510</b>	<b>540</b>	<b>520</b>	<b>480</b>

- 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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