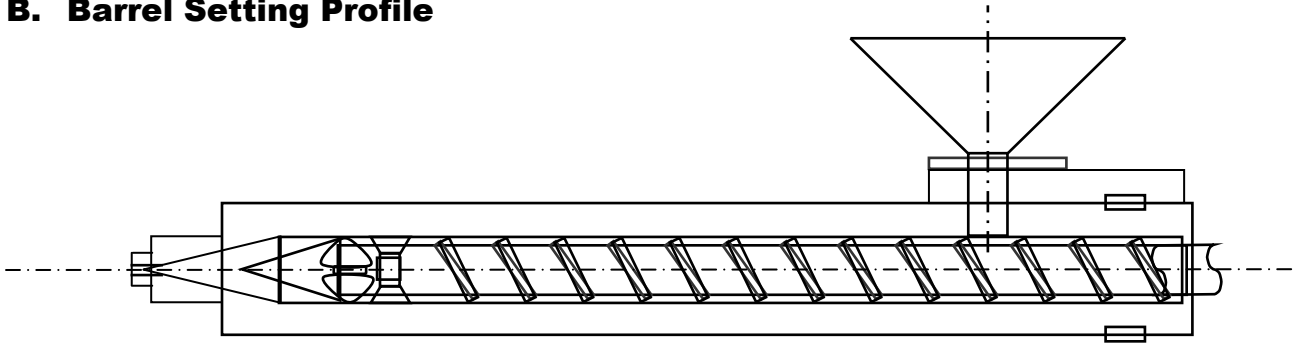


Clariant Nylon 6/6

Processing Conditions

- A. Pre-drying** 160~180 F x 2~4 hrs
depending on
- a) Humidity
 - b) Ratio of reground 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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