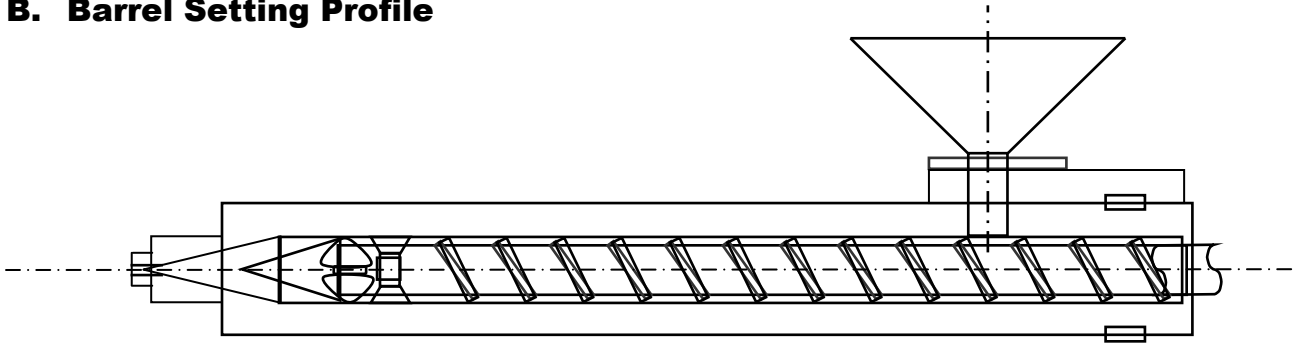


# Clariant Nylon 6

## 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**



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

- C. Mold Temperature**    **150~200<sub>F</sub>**

### **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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