

## Thermylon Polyamide 6

Drying Conditions: Dry for 3-6 hours at 185-194°F (85-90°C)  
Check moisture before proceeding.  
Suggested Max Moisture is 0.2%  
Optimum moisture 0.04-0.10%

Screw Type: General Purpose or higher compression Nylon Screw design.  
Nozzle Tip: Reverse Taper "Nylon Tip"

### General Processing Recommendations

Mold Temperature 167-230°F (75-110°C)  
Recommended Melt Temperature 482-518°F (250-270°C)

Injection Pressure: 40-80% of available High – if >80% evaluate flow length  
Hold Pressure: 50-100% of peak fill  
Back Pressure: Low =<500 PSI, but enough to maintain melt uniformity.  
Screw RPM: Medium to High  
Injection Speed: Medium-Fast

Regrind: Up to 10% may be used if it is free from oil, grease, dirt and shows no signs of degradation. However, since every application is different, it is recommended that the user should apply appropriate judgment for specific application where the material is used for.

Special Notes: The above recommendations are general guidelines. It may be necessary, depending on material processing equipment and application at hand, to deviate from above guidelines for achieving optimal processing state.

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