

# Firestone

## Nylon 6

### Processing Information

Listed below are our recommended start up processing temperatures. This data should be considered as a guide and not absolute. We suggest starting at the lower end of the listed temperatures and increase as necessary.

Barrel	Unfilled N6	Reinforced N6
Rear Zone	460-480°F	520-540°F
Center Zone	460-480°F	530-550°F
Front Zone	470-500°F	510-530°F
Nozzle	480-500°F	500-520°F
Melt	480-500°F	520-540°F
Mold Cavity	120-180°F	130-180°F
Drying Conditions:	165°F for 4 hours ( when required )	
Suggested Max Moisture	0.12%	

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