

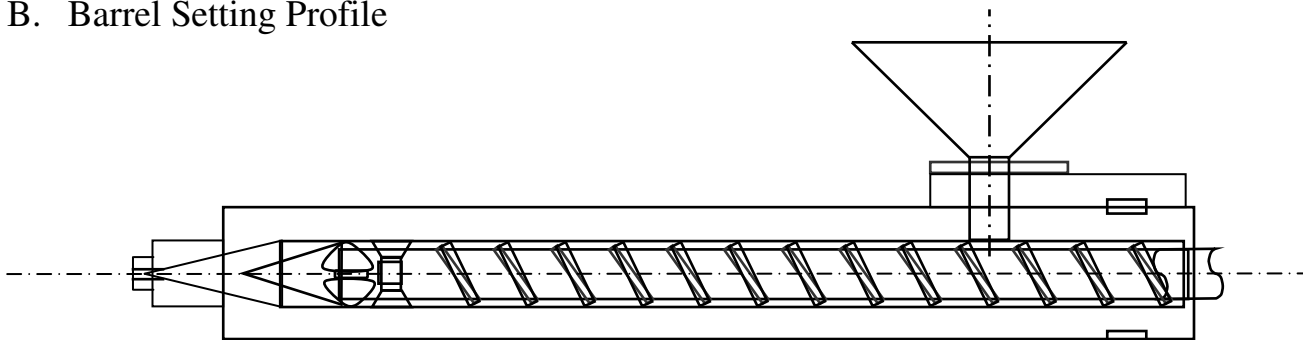
General Purpose ABS, POLYLAC[®] PA-747

Processing Conditions

A Pre-drying 80 ~ 85 °C x 2 ~ 4 hrs

- depending on
- a) Humidity
 - b) Ratio of reground resin
 - c) Storage conditions

B. Barrel Setting Profile



MAX(°C)	230	230	220
MIN(°C)	190	190	180

C. Mold Temperature 30~70 °C

- depending on
- a) Thickness
 - b) Dimension
 - c) Gate and runner system

NOTE :

1. Keep the resin from dust and contamination during handling and production.
2. Do not retain the hot melt at the barrel for a long time between injection cycles.
3. Temperature setting of manifold system should not exceed 240 °C to avoid melt from degraded.

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