

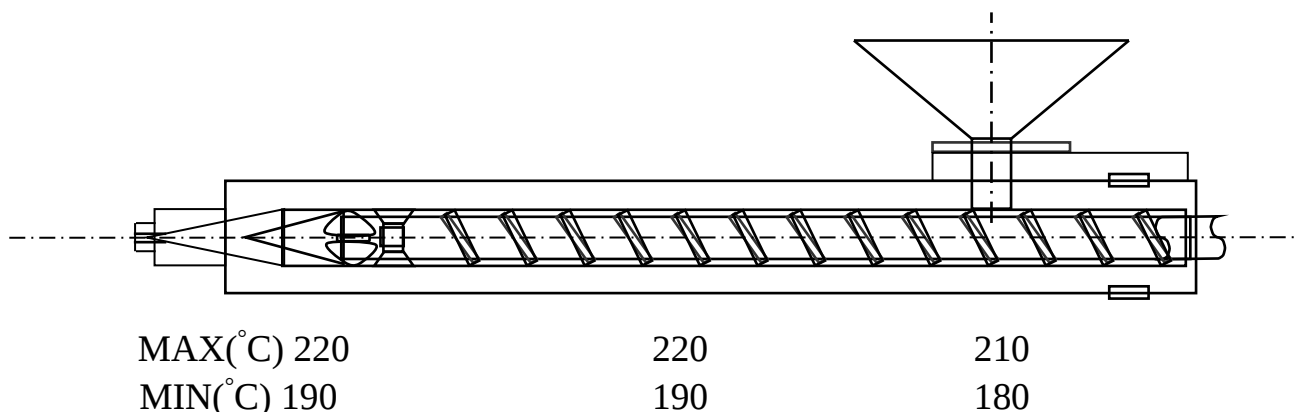
August 29, 2023 V1W

ABS, POLYLAC® PA-765

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



- C. Mold Temperature 40~70 °C
depending on a) Thickness
 b) Dimension
 c) Gate and runner system
- D Injection Pressure 50~80 %
Holding Pressure 20~50 %
Back Pressure 5~10 kg/cm²
- E Injection Speed: Slow to moderate fill speeds are recommended
- F Cushion Zone: approximately 1/8" after injection to provide good dimension consistency
- G. Machine Downtime

For any normal machine shutdown or if mechanical problems require that FR-ABS resin remain in molding machine for as long as 30 minutes, lower the barrel, nozzle and melt temperature to around 95°C to prevent thermal degradation. When ready to resume operations, increase temperature setting to required level, purge the barrel, check melt with pyrometer and continue normal operations.

The above statement is based on our current level of knowledge and covers the above products directly manufactured and supplied by CHI MEI CORPORATION at the date of issue. CHI MEI CORPORATION makes no warranties, whether express or implied, and assumes no liability in connection with any use of above information. Notwithstanding the foregoing, CHI MEI CORPORATION shall in no event be held obligated or liable for any claims due to or arising from (i) any customer provided, consigned, materials and/or parts, which are incorporated or adopted in the products; (ii) any combination of the products with material not provided or authorized by our company; (iii) any modifications to the products which are made or directed by customer; (iv) our compliance with the specifications, instructions, and/or designs provided by customer; (v) any anti-trust, unfair competition and/or other unlawful actions effected by customer; or (vi) any defects, infringement, breach and/or violation which are arising out of customer's faults or otherwise not solely and directly attributable to CHI MEI CORPORATION. In no event will CHI MEI CORPORATION be liable for any indirect, special, exemplary, punitive, or consequential damages (including lost profits) of any nature whatsoever whether arising out of the purchase, shipment, unloading, handling, or use of any product or otherwise.

For prolonged shutdown or storage, molds should be cleaned and coated with a neutralizer and dehydrator containing a rust inhibitor.

Purging operations should be done with the safety shield in the down position to cover the barrel end and nozzle to contain possible splatter.

Purging for shutdown should include complete removal of FR-ABS resin with either general purpose ABS or SAN. Reduce temperature settings to the temperature below 170°C and continue to purge until indicators show a reduction, then follow normal shutdown procedures.

After purging, the screw should be left in the forward position until ready for heat-up to start the next job.

Mold Build-Up

Mold build-up is a characteristic common to many types of the thermoplastics, including FR-ABS. Proper processing conditions can minimize this occurrence. Various type of mold cleaning agents are available; consult your local CHIMEI agent for recommendation. Molds need to be inspected frequently for evidence of build-up or vent clogging which may affect cosmetic appearance.

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 220°C to avoid melt from degradation.

The above statement is based on our current level of knowledge and covers the above products directly manufactured and supplied by CHI MEI CORPORATION at the date of issue. CHI MEI CORPORATION makes no warranties, whether express or implied, and assumes no liability in connection with any use of above information. Notwithstanding the foregoing, CHI MEI CORPORATION shall in no event be held obligated or liable for any claims due to or arising from (i) any customer provided, consigned, materials and/or parts, which are incorporated or adopted in the products; (ii) any combination of the products with material not provided or authorized by our company; (iii) any modifications to the products which are made or directed by customer; (iv) our compliance with the specifications, instructions, and/or designs provided by customer; (v) any anti-trust, unfair competition and/or other unlawful actions effected by customer; or (vi) any defects, infringement, breach and/or violation which are arising out of customer's faults or otherwise not solely and directly attributable to CHI MEI CORPORATION. In no event will CHI MEI CORPORATION be liable for any indirect, special, exemplary, punitive, or consequential damages (including lost profits) of any nature whatsoever whether arising out of the purchase, shipment, unloading, handling, or use of any product or otherwise.