

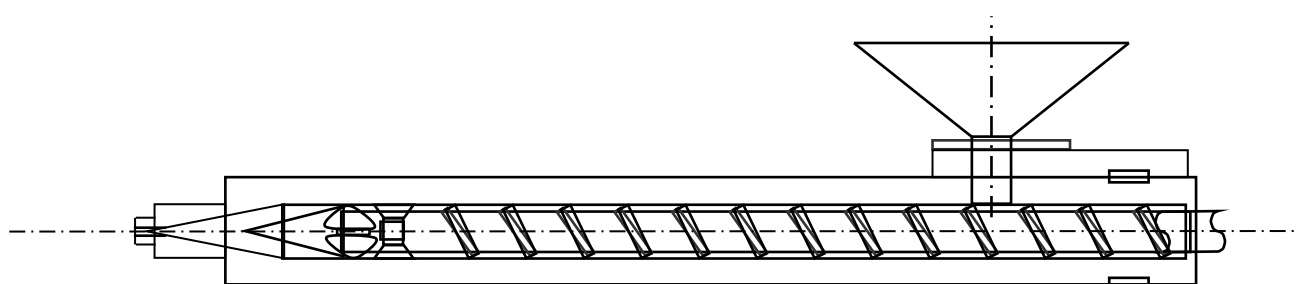
August 29, 2023 V1W

## **ABS, POLYLAC<sup>®</sup> PA-747S A01**

### **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 degradation.

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