

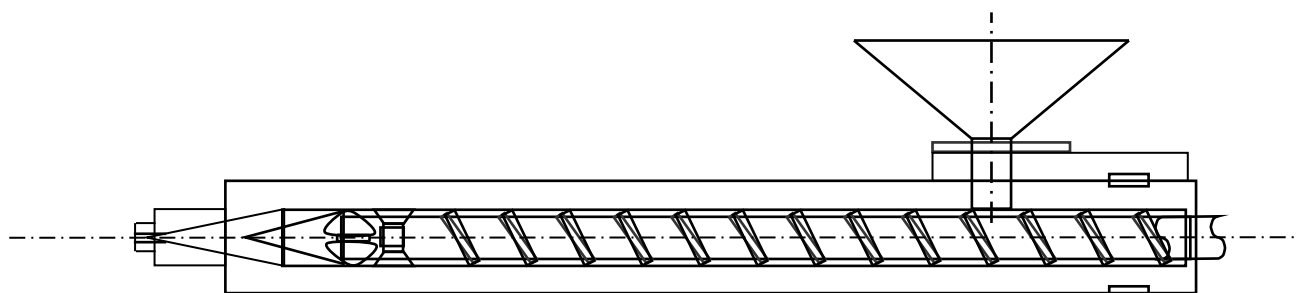
August 29, 2023 V1W

ABS, POLYLAC® PA-757G J08

Processing Conditions

- A Pre-drying 80 ~ 85 °C x 3 ~ 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 80 ~ 120 °C
depending on a) Thickness
 b) Dimension
 c) Gate and runner system
- D Injection Pressure 50~60 %
Holding Pressure 40~50 %
Back Pressure 5~10 kg/cm²

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 250°C to avoid melt from degradation.

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