

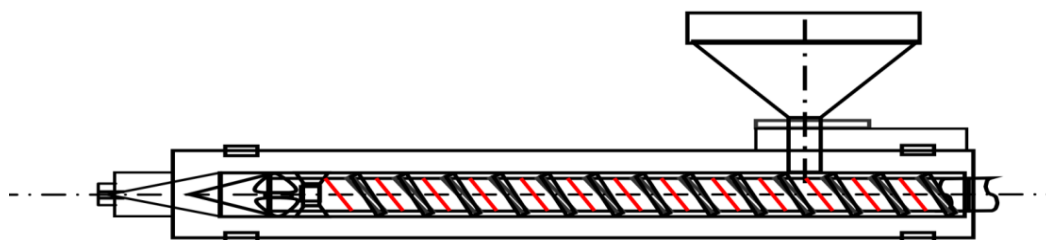


加工建議參數 TAIRILITE® AC2856

1. 烘料條件 **120°C x 4~8 hrs**

成型前膠粒需充分乾燥，水份的殘留可能會造成產品銀紋或物性的衰退。
避免色口變化乾燥時間需控制12小時以內。

2. 射出溫度參數



單位: (°C)

模溫	前段 (射嘴)	中段 (壓縮混煉段)	後段 (入料段)
70-100	250-280	250-280	230-270

* 成型變動因素

- 產品尺寸厚薄
- 成型冷卻(週期)的規劃
- 模具澆口、澆道、排氣的規劃設計

注意事項

- 加工生產前、中、後需避免材料、設備與產品受到汙染
- 適當的成型週期設定，避免材料於高溫料管中停留太久
- 避免造成材料劣解，射出溫度建議不可超過**320°C**。

■ 清車注意事項(螺桿套筒)：

- 不建議使用熱分解樹脂清除料管中的殘留TAIRILITE® 樹脂
- 聚乙烯和聚丙烯是用於清洗目的用最常用的熱穩定樹脂

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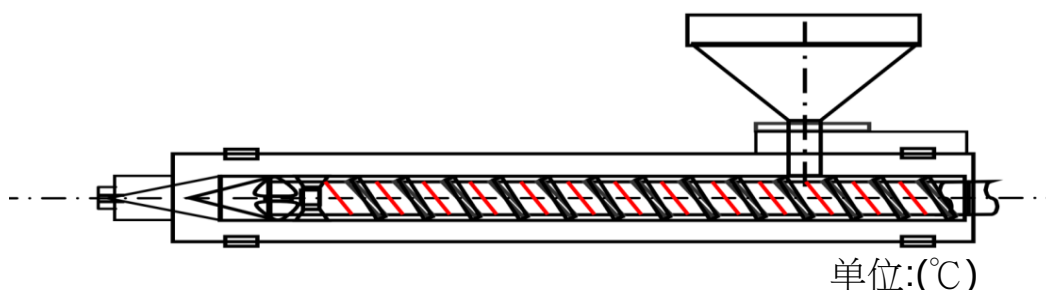


加工建议参数 TAIRILITE® AC2856

1. 烘料条件 120°C x 4~8 hrs

成型前胶粒需充分干燥，水份的残留可能会造成产品银纹或物性的衰退。
避免色口变化干燥时间需控制12小时以内。

2. 射出温度参数



模温	前 段 (射 嘴)	中 段 (压缩混炼段)	后 段 (入料段)
70-100	250-280	250-280	230-270

* 成型变动因素

- a) 产品尺寸厚薄
- b) 成型冷却(周期)的规划
- c) 模具浇口、浇道、排气的规划设计

注意事项

- 1. 加工生产前、中、后需避免材料、设备与产品受到污染
- 2. 适当的成型周期设定，避免材料于高温料管中停留太久
- 3. 避免造成材料劣解，射出温度建议不可超过 320°C.

■ 清车注意事项(螺杆套筒)：

- 1. 不建议使用热分解树脂清除料管中的残留TAIRILITE® 树脂
- 2. 聚乙烯和聚丙烯是用于清洗目的用最常用的热稳定树脂

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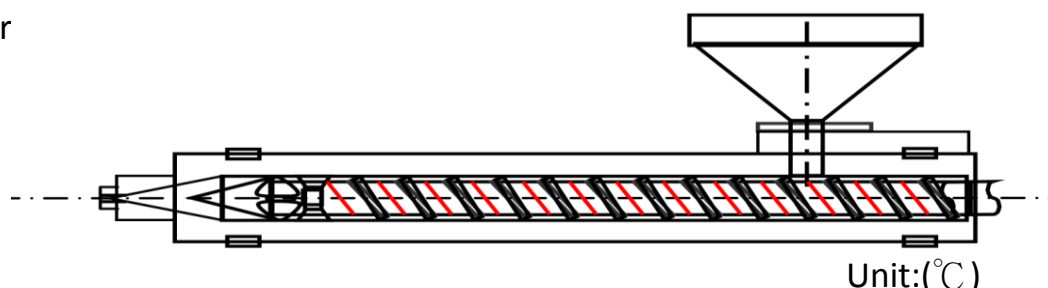


Processing Guides for TAIRILITE® AC2856

1. Pre-drying 120°C x 4~8 hrs

Sufficiently dried. Residual moisture may cause silver streaks or physical property decline.
Avoid changing the color tone, the drying time should be controlled within 12 hours.

2. Barrel Setting Pr



Mold Temp.	Front-Zone (Nozzle)	Middle-Zone (Compression)	Rear-Zone (Feeding)
70-100	250-280	250-280	230-270

- * varying with
- a) Thickness of molded articles
 - b) Cooling system design
 - 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. To avoid melt from degrading, Temperature setting of manifold system should not exceed 320°C.

■ Purging :

Heat decomposing resins are not recommended for purging the residual TAIRILITE® in barrel of injection machine and extruder.

Polyethylene and polypropylene are the most commonly used heat stable resins for purging purpose.

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