

ASA RESIN PROCESSING CONDITIONS

Items	General Grade	High Flow Grade	Extrusion Grade
Grade No.	WG1800	WF3301	WE8300 WE830M WE830M-F
Pre-drying (°C×hr)	80~85°C 2~3hr	80~85°C 2~3hr	80~85°C 2~3hr
Mold Shrinkage (%)	0.4~0.7	0.4~0.7	0.4~0.7
Screw Temp. (°C)	190~230	180~220	180~230
Injection Pressure (Kg/cm ²)	700~1100	600~1100	--
Mold Temp. (°C)	40~80	40~80	--
Cooling Roll(°C)			
Upper			70~80
Middle	--	--	80~90
Lower			90~110

Notes : Products quality from injection process depends on the following factors:

1. Wall thickness of Products
2. Mold cooling loop design
3. Mold gate and runner design



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