

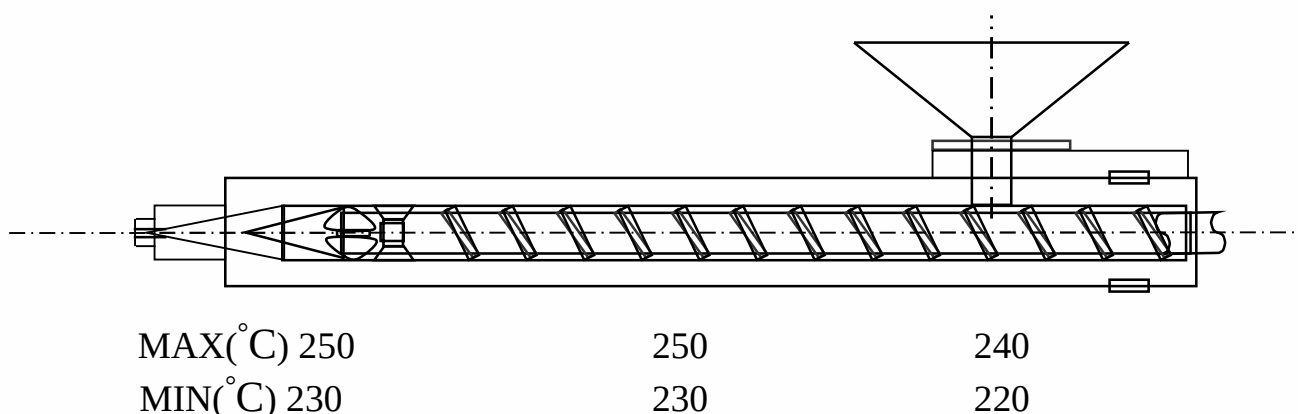
July 22, 2021 V1W

ABS, POLYLAC® PA-77NB

Processing Conditions

- A Pre-drying 90~95°C x 3 hrs
depending on a) Humidity
b) Ratio of reground resin
c) Storage conditions

B. Barrel Setting Profile



- C. Mold Temperature 30~70 °C
depending on a) Thickness
b) Dimension
c) Gate and runner system

- D. Injection Pressure 50~70 kg/cm²
Holding Pressure 40~60 kg/ cm²
Back Pressure 5~15 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 260°C to avoid melt from degrading.

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