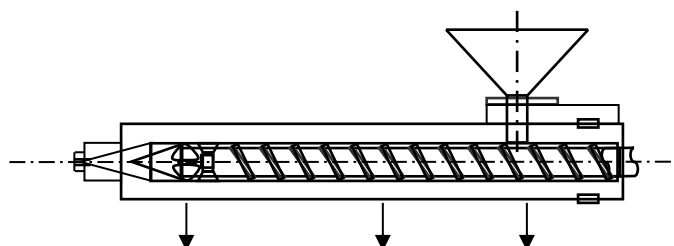


January 19, 2022 VIW

## **WONDERLITE® PC-681U**

- A Pre-drying 120°C x 4 hrs  
depending on a) Humidity  
b) Storage conditions  
c) Dryer's performance

### B. Barrel Setting Profile



Grade / Application		Nozzle	Compression zone	Feeding zone	Mold Temperature *
PC-6600	<b>max. (°C)</b>	<b>310</b>	<b>320</b>	<b>300</b>	<b>70 -120</b>
	<b>min. (°C)</b>	<b>250</b>	<b>250</b>	<b>230</b>	

- \* 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. Temperature setting of manifold system should not exceed 330°C to avoid melt from degrading.

### ■ Purging :

**Heat decomposing resins are not recommended for purging the residual WONDERLITE® and WONDERLOY® 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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