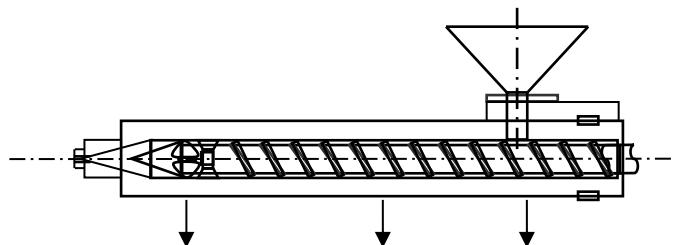


June 16, 2023 VIW

ACRYREX® CM-205M

A Pre-drying 85~90°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 *
CM-205M	max. (°C)	230	240	50~70 °C
	min. (°C)	210	220	

* varying with a) Thickness of molded articles
b) Dimension
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. Occasionally use acrylic or detergent to clean the screw and sleeve.
4. Temperature setting of manifold system should not exceed 240°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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