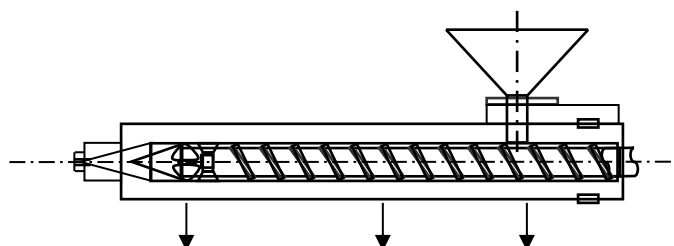


June 16, 2023 VIW

## **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              | 205          | 50~70 °C           |
|                     | min.(°C) | 210    | 220              | 185          |                    |

- \* 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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