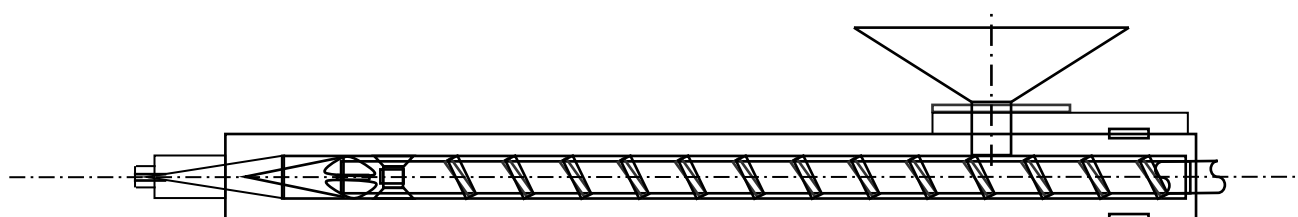


July 21, 2021 VIW

MABS POLYLAC® PA-703TRP

- A Pre-drying : 85°C , 3~5 hr
depending on a) Humidity b) Ratio of Re grind c) Storage conditions
- B. Barrel Setting Profile



	<u>Metering Zone</u>	<u>Compression Zone</u>	<u>Feeding Zone</u>
Max(°C)	250	250	220
Min(°C)	220	220	200

The suggested processing temperature is 230~240°C

- C. Mold Temperature 50~70 °C
depending on a) Thickness b) Dimension c) Gate and runner system
- D. Injection Pressure 50~80 kg/cm²
Holding Pressure 20~50 kg/cm²
Back Pressure 5~10 kg/cm²
- E Purging

Purging for shutdown should include complete removal of PA-703TRP resin with either PA-703TRP or high flow PMMA(for example, CM-211). The other clear plastics (PS , SAN or the other MABS) are not suggested.

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 250°C to avoid melt from degradation.
4. The manufactured process and the properties may be different among various MABS manufactures. Therefore, blending of the different MABS is not recommended. The blending of the different MABS will influence the properties and light transmission.

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