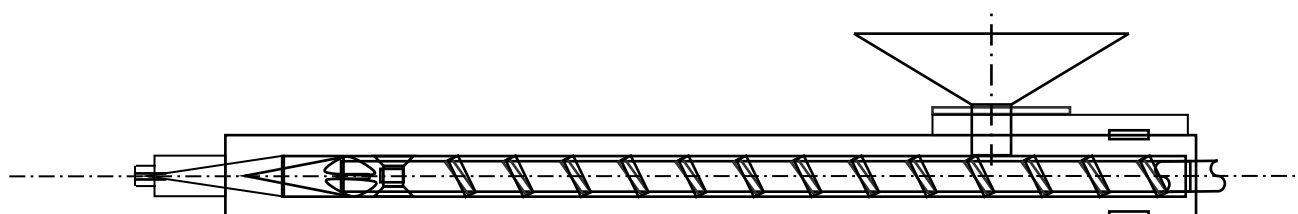


August 4, 2023

MABS POLYLAC® PA-758 L125

- A Predrying : 85°C , 3~5 hr
depending on a) Humidity b) Ratio of Regrind 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-758 L125resin with either PA-758 L125 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.

The above statement is based on our current level of knowledge and covers the above products directly manufactured and supplied by CHI MEI CORPORATION at the date of issue. CHI MEI CORPORATION makes no warranties, whether express or implied, and assumes no liability in connection with any use of above information. Notwithstanding the foregoing, CHI MEI CORPORATION shall in no event be held obligated or liable for any claims due to or arising from (i) any customer provided, consigned, materials and/or parts, which are incorporated or adopted in the products; (ii) any combination of the products with material not provided or authorized by our company; (iii) any modifications to the products which are made or directed by customer; (iv) our compliance with the specifications, instructions, and/or designs provided by customer; (v) any anti-trust, unfair competition and/or other unlawful actions directed by customer; or (vi) any defects, infringement, breach and/or violation which are arising out of customer's faults or otherwise not solely and directly attributable to CHI MEI CORPORATION. In no event will CHI MEI CORPORATION be liable for any indirect, special, exemplary, punitive, or consequential damages (including lost profits) of any nature whatsoever whether arising out of the purchase, shipment, unloading, handling, or use of any product or other