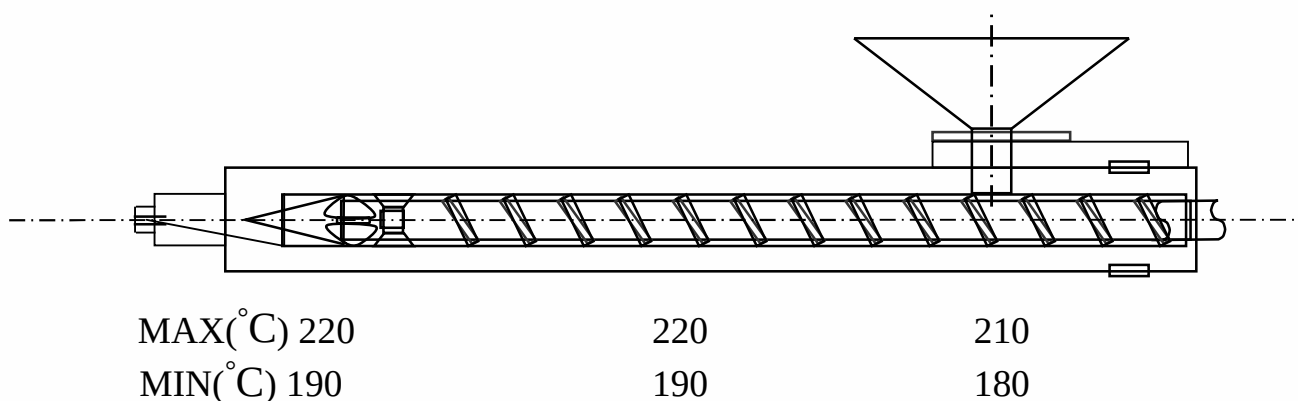


July 22, 2021 V1W

SAN, KIBISAN® PN-117 L100

- A. Pre-drying 75~80°C x 3~4 hrs
depending on a) Humidity
b) Ratio of reground resin
c) Storage conditions
- B. Barrel Setting Profile



- C. Mold Temperature 40~60 °C
depending on a) Thickness
b) Dimension
c) Gate and runner system
- D. Injection Pressure 50~70 kg/cm²
Holding Pressure 40~60 kg/cm²
Back Pressure 5~15 kg/cm²

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 235°C to avoid melt from degrading.

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