

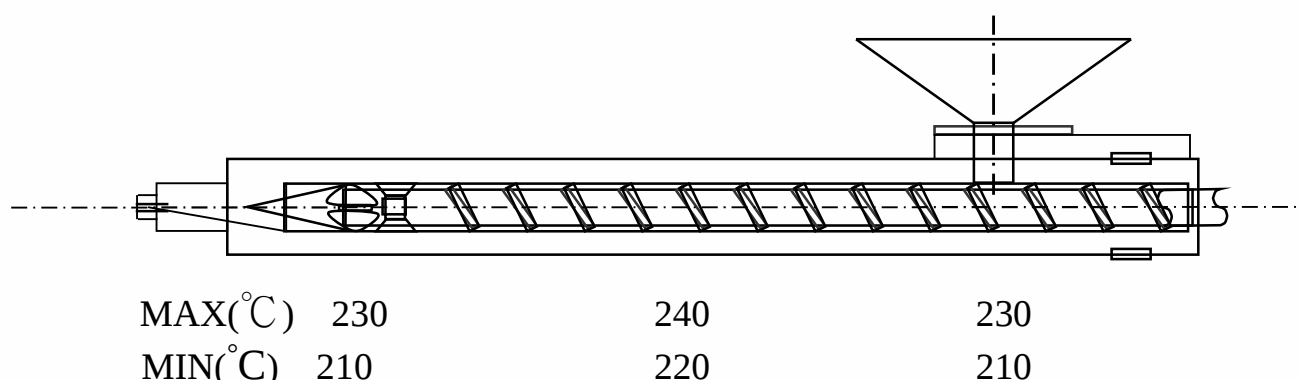
July 22, 2021 V1W

SAN, KIBISAN® PN-137H

A Pre-drying 80~85°Cx 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 250°C to avoid melt from degrading.

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