General Purpose ABS, POLYLAC® PA-709

Processing Conditions

A. Pre-drying  80 ~ 85 °C x 2 ~ 4 hrs

   depending on  a) Humidity
              b) Ratio of reground resin
              c) Storage conditions

B. Barrel Setting Profile

   MAX(°C) 230          230          220
   MIN(°C) 190          190          180

C. Mold Temperature  30~70 °C

   depending on  a) Thickness
              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. Temperature setting of manifold system should not exceed 240 °C to avoid melt from degrading.

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