**High Flow ABS, POLYLAC® PA-746**

**Processing Conditions**

A. Pre-drying  
80 ~ 85 °C x 2 ~ 3 hrs  
depending on  
a) Humidity  
b) Ratio of reground resin  
c) Storage conditions

B. Barrel Setting Profile

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MAX(°C) 230 230 220
MIN(°C) 190 190 180
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C. Mold Temperature  30~60 °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 degraded.

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