General Purpose ABS, POLYLAC® PA-756S

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

   \[
   \begin{array}{c|c|c|c}
   & MAX (°C) & 230 & 230 & 220 \\
   MIN (°C) & 190 & 190 & 180 \\
   \end{array}
   \]

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 degraded.

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