**Extrusion**  **ABS, POLYLAC® PA-747F**

**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. Extrusion Temperature Profile(°C)

<table>
<thead>
<tr>
<th>Max</th>
<th>Min</th>
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<tbody>
<tr>
<td>230</td>
<td>200</td>
</tr>
<tr>
<td>250</td>
<td>220</td>
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![Diagram showing extrusion process](diagram.png)

**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 260 °C to avoid melt from degraded.

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