Extrusion  ABS, POLYLAC® PA-747S

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>
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<tr>
<td>250</td>
<td>220</td>
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<tr>
<td>230</td>
<td>200</td>
</tr>
</tbody>
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| Max  | 250 |
| Min  | 220 |
| 210  | 190 |

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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