High Heat ABS, POLYLAC® PA-777B

Processing Conditions

A. Pre-drying  90~95°C x 3 hrs
   depending on  
   a) Humidity
   b) Ratio of reground resin
   c) Storage conditions

B. Barrel Setting Profile

   \[
   \begin{array}{ccc}
   \text{MAX (°C)} & 250 & 250 & 240 \\
   \text{MIN (°C)} & 230 & 230 & 220 \\
   \end{array}
   \]

C. Mold Temperature  30~70°C
   depending on  
   a) Thickness
   b) Dimension
   c) Gate and runner system

D. Injection Pressure  50~70 kg/cm²
   Holding Pressure  40~60 kg/cm²
   Back Pressure  5~15 kg/cm²

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 degrading.

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