**High Heat ABS, POLYLAC® PA-777D**

**Processing Conditions**

A. Pre-drying  90~105°C x 3 hrs  
 depending on  
 a) Humidity  
 b) Ratio of reground resin  
 c) Storage conditions

B. Barrel Setting Profile

<table>
<thead>
<tr>
<th>MAX(°C)</th>
<th>250</th>
<th>250</th>
<th>240</th>
</tr>
</thead>
<tbody>
<tr>
<td>MIN(°C)</td>
<td>230</td>
<td>230</td>
<td>220</td>
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</tbody>
</table>

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 270°C to avoid melt from degrading.

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