High Heat ABS, POLYLAC® PA-777E

Processing Conditions

A. Pre-drying  100~110 °C x 3 hrs
   depending on  a) Humidity
               b) Ratio of regrind resin
               c) Storage conditions

B. Barrel Setting Profile

   MAX(°C) 270  270  250
   MIN(°C) 240  240  220

C. Mold Temperature  40~80 °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 280 °C to avoid melt from degrading.

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