**General Purpose ABS, POLYLAC® PA-727**

**Processing Conditions**

A. Pre-drying 80 ~ 85°C x 3 ~ 4 hrs
   depending on
   a) Humidity
   b) Ratio of reground resin
   c) Storage conditions

B. Barrel Setting Profile

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MAX(°C) 230  230  220
MIN(°C) 190  190  180
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C. Mold Temperature 30~70°C
   depending on
   a) Thickness
   b) Dimension
   c) Gate and runner system

**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 240°C to avoid melt from degraded.

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