General Purpose ABS, POLYLAC® PA-757G J08(Black)

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

- MAX(°C) 230
- MIN(°C) 190

C. Mold Temperature 80 ~ 120°C depending on
   a) Thickness
   b) Dimension
   c) Gate and runner system

D. Injection Pressure 50~60 %
   Holding Pressure 40~50 %
   Back Pressure 5~10 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 250°C to avoid melt from degrading.

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