**High Heat ASA, KIBILAC® PW-978B**

**Processing Conditions**

A. Pre-drying  \[90\sim 95 \, ^\circ \text{C} \times 3 \text{ hrs}\]
   - depending on
     - a) Humidity
     - b) Ratio of reground resin
     - c) Storage conditions

B. Barrel Setting Profile

- **MAX(\(\text{^\circ} \text{C}\))** 260
- **MIN(\(\text{^\circ} \text{C}\))** 240

C. Mold Temperature  \[40\sim 80 \, ^\circ \text{C}\]
   - depending on
     - a) Thickness
     - b) Dimension
     - c) Gate and runner system

D. Injection Pressure  \[50\sim 70 \, \text{kg/cm}^2\]
   - Holding Pressure  \[40\sim 60 \, \text{kg/cm}^2\]
   - Back Pressure  \[5\sim 15 \, \text{kg/cm}^2\]

**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 \(\text{^\circ} \text{C}\) to avoid melt from degrading.

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