High Heat ABS, POLYLAC® PA-77NB

Processing Conditions

A. Pre-drying 90~95°C x 3 hrs
   depending on
   a) Humidity
   b) Ratio of reground resin
   c) Storage conditions

B. Barrel Setting Profile

   MAX(°C) 250
   MIN(°C) 230

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 260°C to avoid melt from degrading.

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