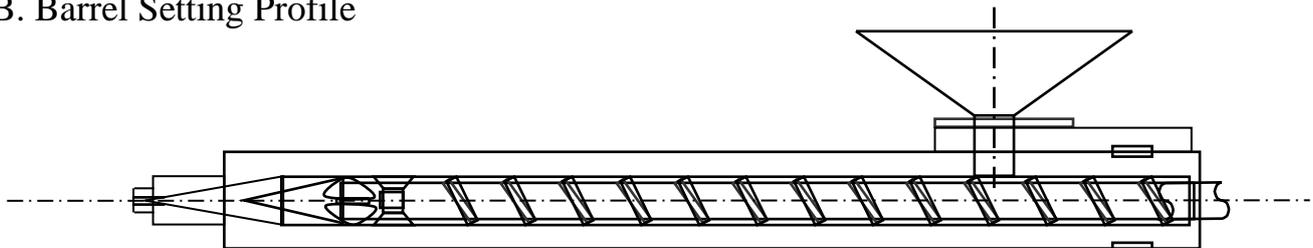


Clear KIBITON® PB-5903

Recommended Processing Condition

A Predrying is not necessary.

B. Barrel Setting Profile



| | <u>Metering Zone</u> | <u>Compression Zone</u> | <u>Feeding Zone</u> |
|---------|----------------------|-------------------------|---------------------|
| Max(°C) | 200 | 200 | 180 |
| Min(°C) | 180 | 180 | 160 |

The suggested processing temperature is 180~190°C

C. Mold Temperature 30~50 °C

depending on a) Thickness b) Dimension c) Gate and runner system

D. Injection Pressure 40~70 kg/cm²
 Holding Pressure 10~40 kg/cm²
 Back Pressure 5~10 kg/cm²

E Purging

Purging for shutdown should include complete removal of PB-5903 resin with either PB-5903 or PG-33/PG383 . The other clear plastics (ex. Clear ABS/Clear HIPS) are not suggested.

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 210°C to avoid melt from degradation.

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