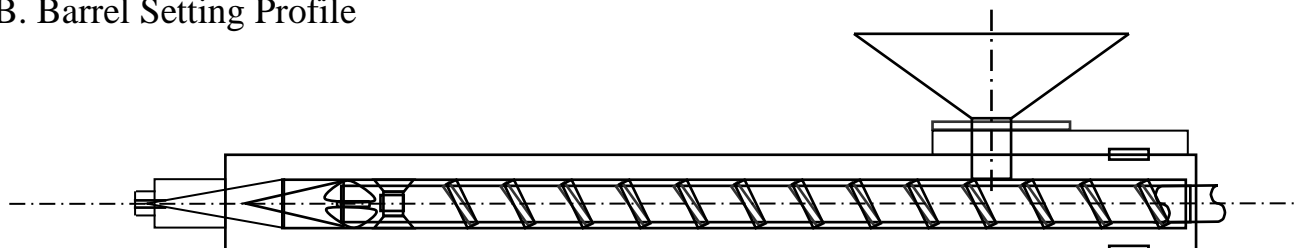


Clear KIBITON® PB-5903

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/cm ²
Holding Pressure	10~40 kg/cm ²
Back Pressure	5~10 kg/cm ²

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.

The above statement is based on our current level of knowledge and covers the above products directly manufactured and supplied by CHI MEI CORPORATION at the date of issue. CHI MEI CORPORATION makes no warranties, whether express or implied, and assumes no liability in connection with any use of above information. Notwithstanding the foregoing, CHI MEI CORPORATION shall in no event be held obligated or liable for any claims due to or arising from (i) any customer provided, consigned, materials and/or parts, which are incorporated or adopted in the products; (ii) any combination of the products with material not provided or authorized by our company; (iii) any modifications to the products which are made or directed by customer; (iv) our compliance with the specifications, instructions, and/or designs provided by customer; (v) any anti-trust, unfair competition and/or other unlawful actions effected by customer; or (vi) any defects, infringement, breach and/or violation which are arising out of customer's faults or otherwise not solely and directly attributable to CHI MEI CORPORATION. In no event will CHI MEI CORPORATION be liable for any indirect, special, exemplary, punitive, or consequential damages (including lost profits) of any nature whatsoever whether arising out of the purchase, shipment, unloading, handling, or use of any product or otherwise.