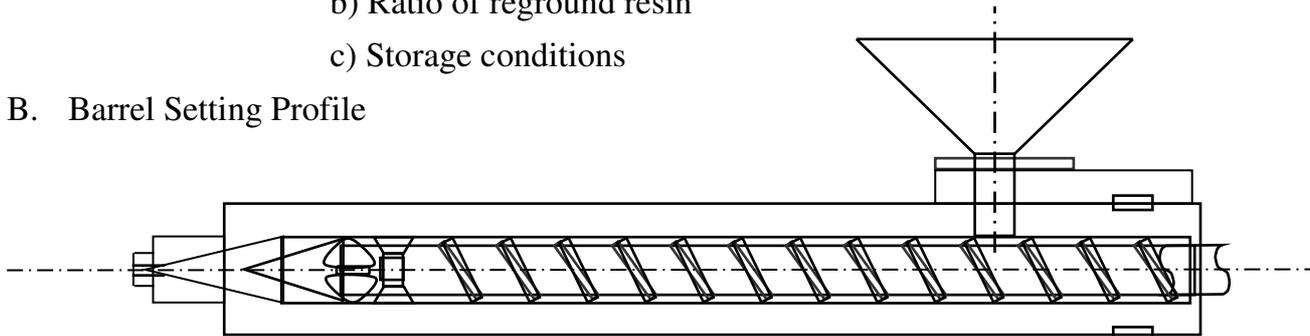


Food Contact SAN, KIBISAN® PN-127 L150 FG

Processing Conditions :

- A. Pre-drying 75~80°C x 3~4 hrs
depending on
- Humidity
 - Ratio of reground resin
 - Storage conditions
- B. Barrel Setting Profile



| | | | |
|---------|-----|-----|-----|
| MAX(°C) | 220 | 220 | 210 |
| MIN(°C) | 200 | 200 | 190 |

- C. Mold Temperature 40~60 °C
depending on
- Thickness
 - Dimension
 - Gate and runner system
- D. Injection Pressure 50~70 kg/cm²
Holding Pressure 40~60 kg/cm²
Back Pressure 5~15 kg/cm²

NOTE :

- Keep the resin from dust and contamination during handling and production.
- Do not retain the hot melt at the barrel for a long time between injection cycles.
- Temperature setting of manifold system should not exceed 230°C to avoid melt from degrading.
- To avoid extra chemical residues, please use food contact materials to clean the injection machine while grade changing.

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