

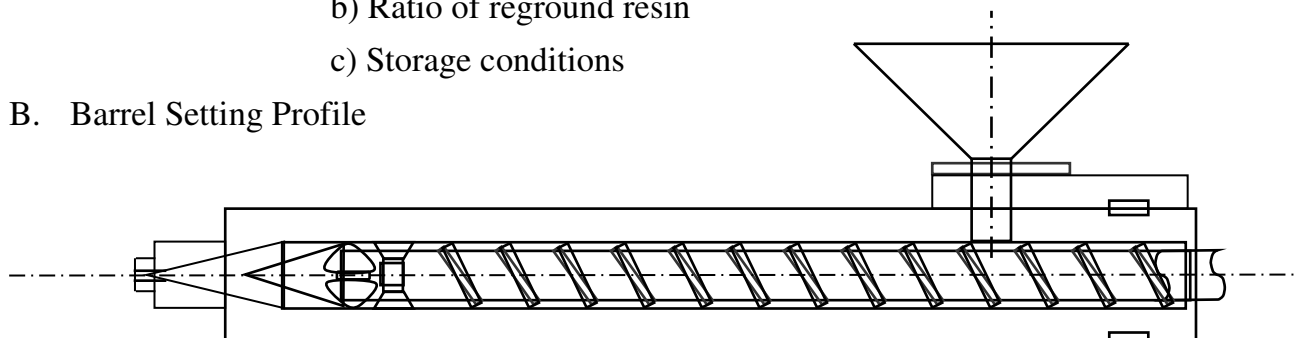
## Food Contact SAN, KIBISAN® PN-127 L150 FG

### Processing Conditions :

A Pre-drying 75~80°C x 3~4 hrs

- depending on
- a) Humidity
  - b) Ratio of reground resin
  - c) Storage conditions

B. Barrel Setting Profile



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

C. Mold Temperature 40~60 °C

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

D. Injection Pressure	50~70 kg/cm <sup>2</sup>
Holding Pressure	40~60 kg/cm <sup>2</sup>
Back Pressure	5~15 kg/cm <sup>2</sup>

### 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 230°C to avoid melt from degrading.
4. To avoid extra chemical residues, please use food contact materials to clean the injection machine while grade changing.

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