

MABS, POLYLAC[®] PA-758R

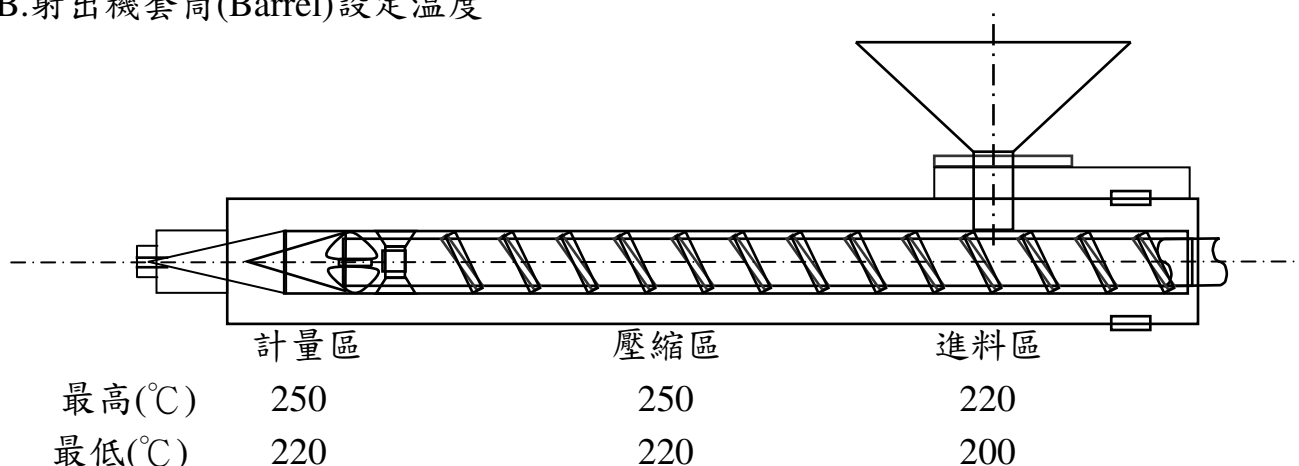
January 16, 2017 VIW

加工建議條件

A 乾燥 : 85°C, 3~5 小時。

依以下變數而變 a)濕度 b)回收料比例 c)儲存條件

B.射出機套筒(Barrel)設定溫度



較佳的射出溫度為230~240°C

C. 模具溫度 50~70 °C。依以下變數而變

a)製品厚度 b) 尺寸 c) 澆口(Gate)及流道(Runner)系統

D. 射壓 50~80 kg/cm²保壓 20~50 kg/cm²背壓 5~10 kg/cm²

E.停、開車的處置：

1. 開機時應溫度調整至設定值，射出料管中的殘餘MABS並確定料溫已達射定值後射出。
2. 若必須長時間停機，必須將料管中的塑料擠出
3. 洗車時請使用MS(PM-600)或高流動性的壓克力材料(CM-211)。請勿使用其他透明材料如PS、SAN或ABS來洗車。以減少洗車時間及避免材料透明度受到影響。

注意事項：

1. 生產及操作時避免樹脂接觸到灰塵及雜物。
2. 在射出週期中勿將熱融膠 (Hot Melt)長期停留在加熱管中。
3. 熱澆道(Hot Runner)系統溫度勿超過250°C
4. 各種MABS的製程及特性不同，使用時請勿混用，以免影響產品物性及透明程度。

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