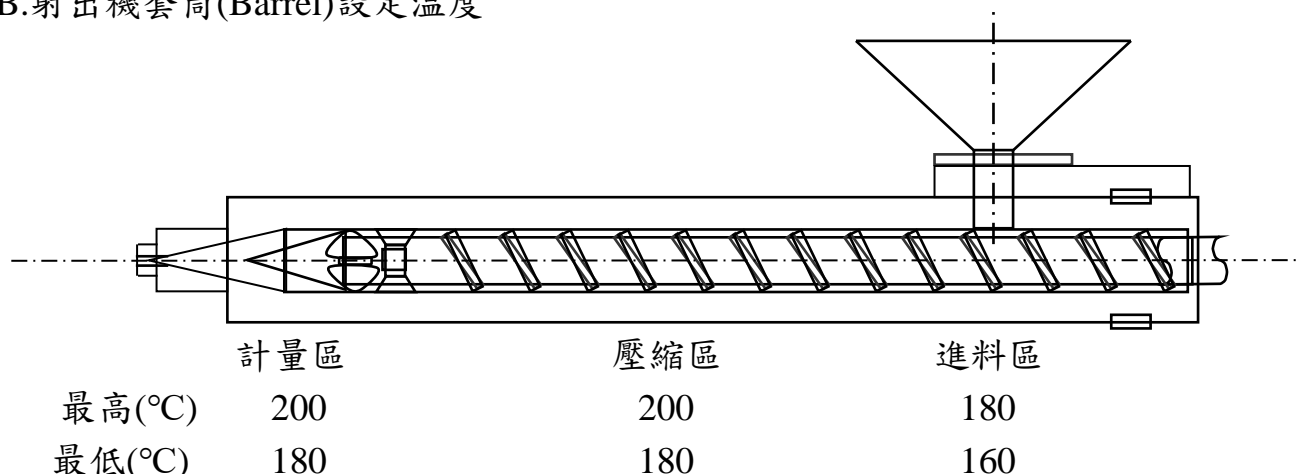


June 29, 2018 VIW

透明級 KIBITON® PB-5903**加工建議條件**

A 不需預先乾燥

B. 射出機套筒(Barrel)設定溫度



較佳的射出溫度為180~190°C

C. 模具溫度 30~50 °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 40~70 kg/cm²保壓 10~40 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PB-5903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PB-5903或GPPS 例如PG-33/PG-383。請勿使用其他透明材料 如透明ABS或透明HIPS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210°C

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