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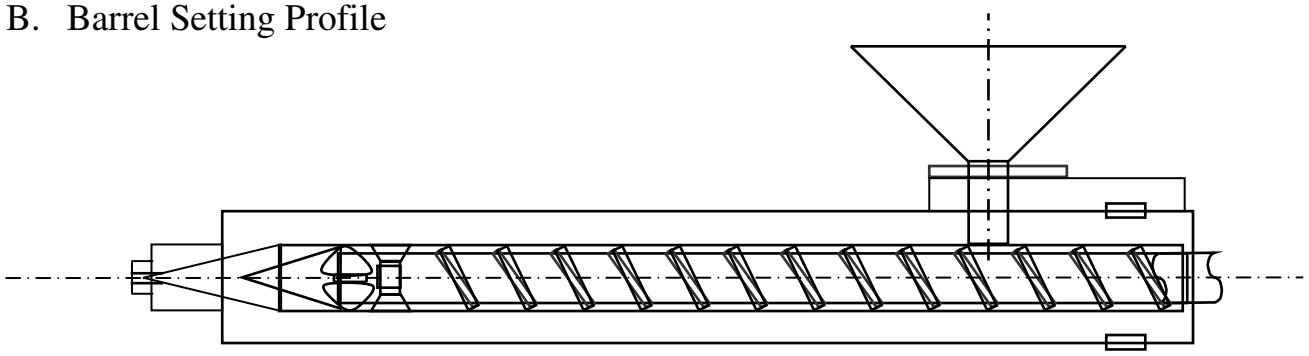
High Heat ABS, POLYLAC® PA-777C

Processing Conditions

A Pre-drying 90~100°C x 3 hrs

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

B. Barrel Setting Profile



MAX(°C)	250	250	240
MIN(°C)	230	230	220

C. Mold Temperature 30~70 °C

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

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

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 265°C to avoid melt from degrading.

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