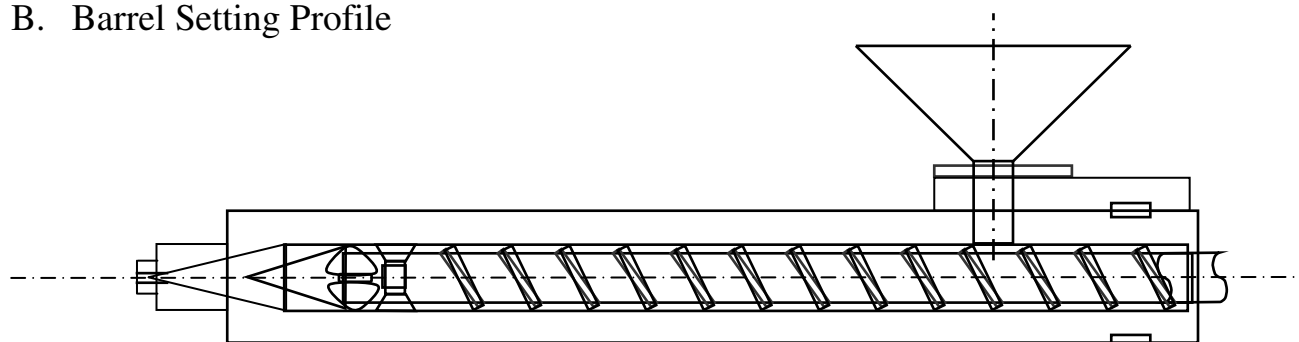


High Heat ABS, POLYLAC[®] PA-777D**Processing Conditions**

A Pre-drying 90~105 °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/cm²
 Holding Pressure 40~60 kg/ cm²
 Back Pressure 5~15 kg/ cm²

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 270 °C to avoid melt from degrading.

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