

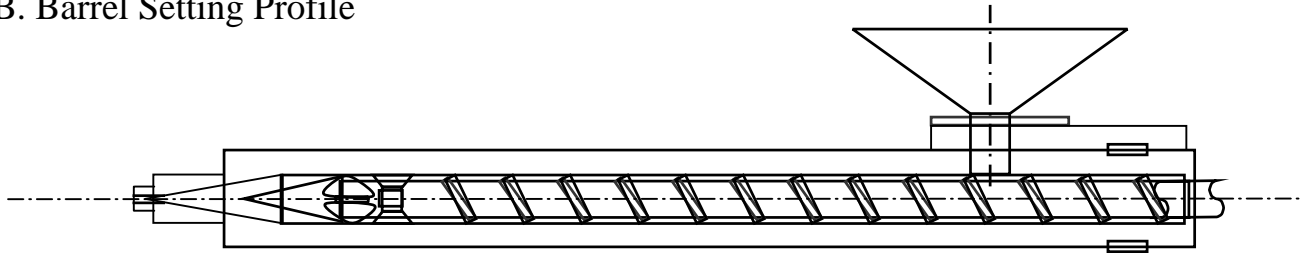


## ***Clear KIBITON<sup>®</sup> PB-5300/5302***

### **Recommended Processing Condition**

A Predrying is not necessary.

#### B. Barrel Setting Profile



	<u>Metering Zone</u>	<u>Compression Zone</u>	<u>Feeding Zone</u>
Max(°C)	180	180	150
Min(°C)	140	140	130

The suggested processing temperature is 150~160°C

#### C. Mold Temperature 30~70 °C

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

D. Injection Pressure	20~80 kg/cm <sup>2</sup>
Holding Pressure	20~40 kg/cm <sup>2</sup>
Back Pressure	5~10 kg/cm <sup>2</sup>

#### E Purging

Purging for shutdown should include complete removal of PB-5300/5302 with either PE or GPPS(PG-33) .

### **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.