

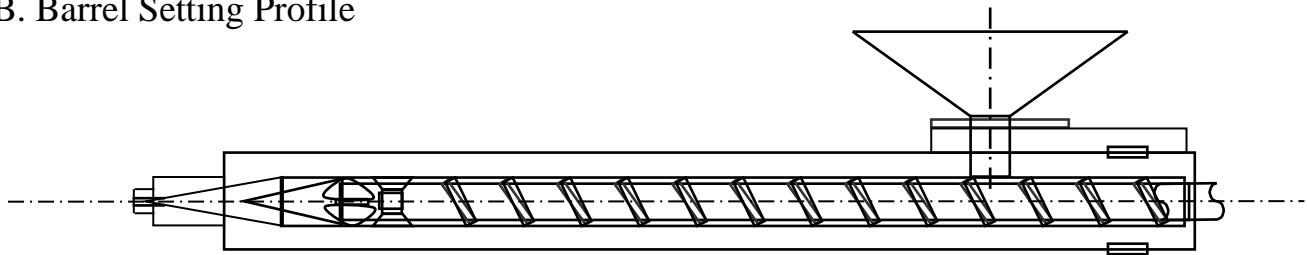
KIBITON® PB-575/587/585

Recommended Processing Condition

A Predrying : 60~70°C , 1~2 hr .

depending on a) Humidity b) Ratio of Regrind c) Storage conditions

B. Barrel Setting Profile



	<u>Metering Zone</u>	<u>Compression Zone</u>	<u>Feeding Zone</u>
Max(°C)	190	190	150
Min(°C)	150	150	130

The suggested processing temperature is 160~170°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 ²
Holding Pressure	20~40 kg/cm ²
Back Pressure	5~10 kg/cm ²

E Purging

Purging for shutdown should include complete removal of KIBITON® series 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.